

GÜHRING

GROOVING SYSTEMS

NEW

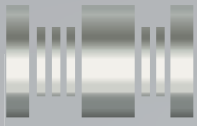
Boring out
Grooving
Threading
Broaching
Special tools

A 3D CAD rendering of a complex metal part, possibly a bracket or a housing, with a central circular hole. The part is shown in a light gray color. Below it, a yellow drill bit is shown in a perspective view, pointing towards the hole in the metal part. The background is a light gray gradient with some faint geometric lines.

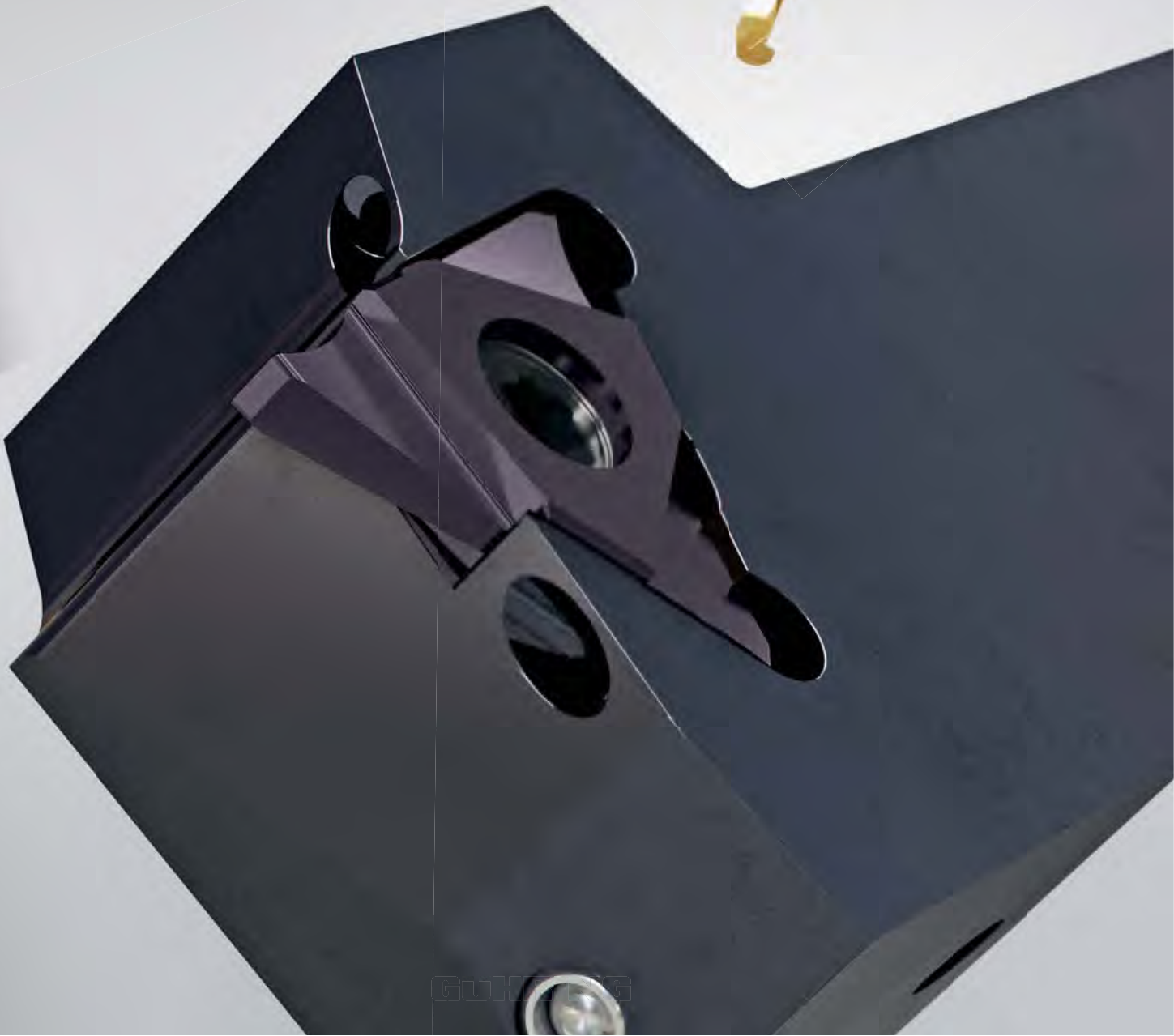
// FLEXIBLE
// ECONOMICAL
// ACCURATE

GÜHRING

GÜHRING



GROOVING
SYSTEMS



GROOVING SYSTEMS

highest quality and flexibility thanks
to maximum manufacturing depth



GRINDING – INDEXABLE INSERTS AND CUTTING INSERTS

Complete production on
Guhring built grinding machines



COATING – INDEXABLE INSERTS AND CUTTING INSERTS

// In-house coating on
Guhring built coating systems
// Latest coating technology
and coating types

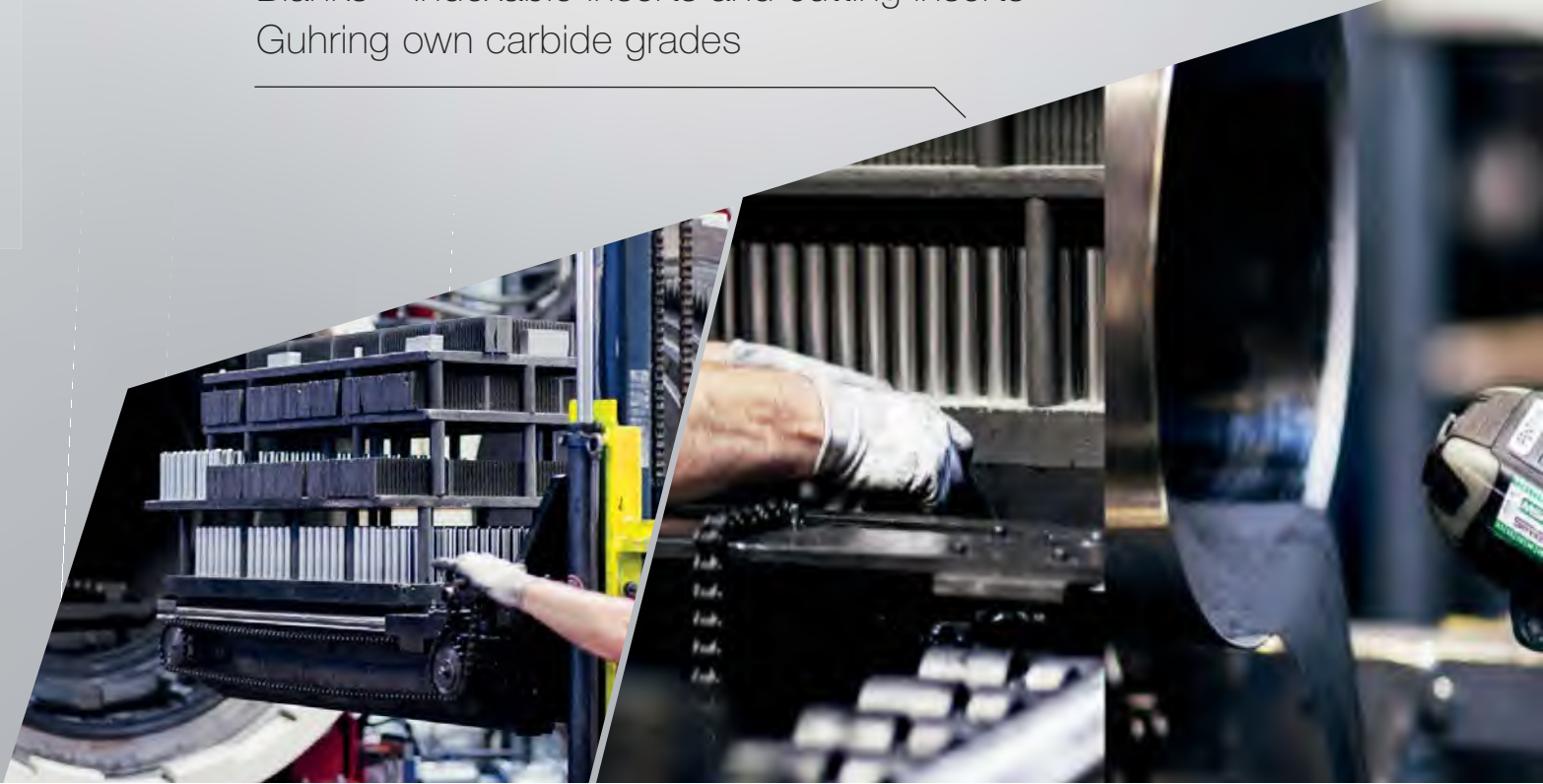


MILLING/TURNING – HOLDER PRODUCTION



GUHRING'S OWN CARBIDE PRODUCTION

Blanks – Indexable inserts and cutting inserts
Guhring own carbide grades



WE KEEP ON GROWING

| PROGRAMME EXPANSION | MORE SIZES | NEW APPLICATIONS

This rapid development is made possible by the huge manufacturing depth at Guhring, which is also evident in the grooving tool product line. Carbide manufactured in-house and specially developed machines and coatings from our own R&D are typical of Guhring products. This is no longer exclusive to rotating tools, but now also applies to stationary tools.

108

The new System 108 is the logical next development of the range of micro-precision tools. With a shank diameter of 8 mm and a minimum machining diameter of 7 mm, System 108 is a valuable addition to the existing tool portfolio. The shank diameter of 8 mm provides maximum stability and therefore high processing safety. The start-up range offers over 700 different articles for boring and profiling up to a maximum depth of 2.5 mm, internal grooving up to a maximum depth of 3 mm and back boring.

System 108 will also be continuously expanded to meet the needs of its users.



106

In the tried and tested System 106, a larger selection of broaching tools is now available. These are now available for internal hexagon processing of spanner sizes 4 to 10.

Where internal hole machining with micro-precision tools is concerned, the 106 tool system is already one of the most comprehensive ranges on the market.



110

Similarly, System 110 also opens up new and exciting opportunities. With a shank diameter of 10 mm, this special tool ensures maximum stability. We have blanks in stock measuring up to 112 mm in length to be able to provide the best possible solution for challenging applications. In addition, the standard range includes the most conventional round shank holders.

Gühring specialises in industry-specific tool and process solutions. We are also able to design custom-made special tools for grooving. As well as our comprehensive standard portfolio, we focus on tailored systems aimed specifically at our customers. This is based in particular on Gühring's substantial tool expertise and extensive consulting experience.



GÜHRING
GROOVING
SYSTEMS

Guhring R&D for innovative tool developments

Highest quality standard world-wide

Pooled expertise under one roof

Exceptionally high manufacturing depth

Machining technology with an edge



GUHRING

Production location
Grooving tools







Dr. Jörg Gühring

President



Oliver Gühring

Sales and Marketing
Director

8000

Employees
world-wide



3500

Employees
Germany



Internal training and further
programme of education



International knowledge transfer thanks
to world-wide exchange programme for
employees



Dietmar Pfränger

R&D, Logistics, Technical and
Production Director



Bernd Schatz

Financial and Commercial
Director

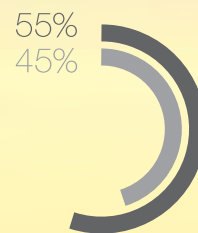


90000

Standard tools

4000

Tool types



■ Standard tools
■ Special tools

Everything from one supplier – comprehensive and global

With a global network of manufacturing sites Guhring develops and produces precision tools for all the important markets. Users from the automotive industry, the aerospace industry or the machine tool and general industry rely on the trend-setting tools manufactured world-wide at the highest level to uniform quality standards.

48
SUBSIDIARIES

MORE THAN 70
PRODUCTION AND
SERVICE CENTRES



CANADA
Guhring Corp.
sales@guhring.com
www.guhring.com

**USA
BROOKFIELD**
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**USA
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www.guhring.com

MEXICO
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SOUTH AFRICA
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www.guhring.nl

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www.guhring.be

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www.guhring.ch

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ALTDORF**
Guhring (Schweiz) AG
mailto:jurg@guhring.ch
www.guhring.ch

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**RAMSTEIN-
MIESENBACH**
Guhring KG
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www.guhring.de

With innovative technologies Guhring meets specific customer requirements from process proposal to series application of the precision tools – flexibly, promptly, globally. For this, experts are in action internationally looking after customers on site. Production, service and contact persons are available from one supplier world-wide.

Own carbide production Own machine construction
 Own coating plants Highest quality standards world-wide




CHEMNITZ 25
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 www.guhring.de




KULMBACH 26
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 service@german-carbide.com



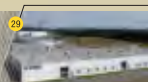
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 Uberrme-Guhring Italiana
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 www.uberrme.it



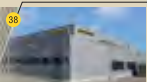
ITALY MISSAGLIA 36
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 www.guhring-italy.com




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 www.guhring.in



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 www.guhring.ru



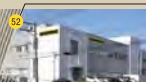
AUSTRALIA 50
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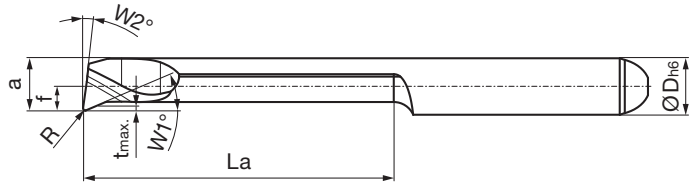


GROOVING SYSTEMS

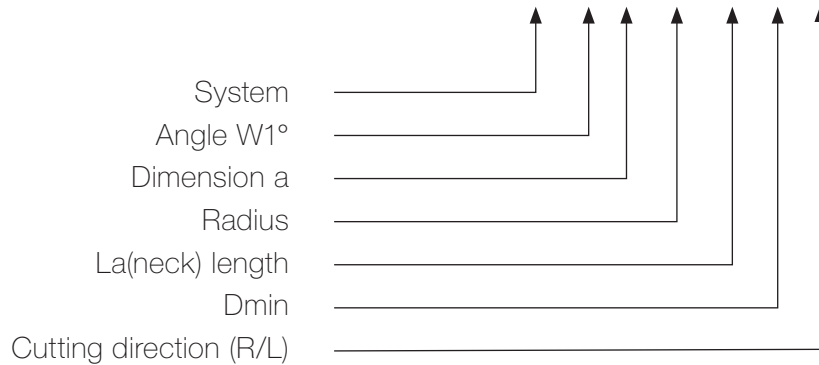
Explanation of the article description

Article description

System 104/106/108/110

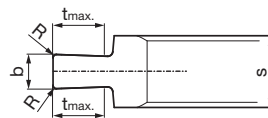
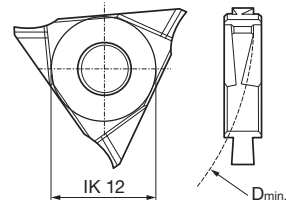


Tool description: Example: GT104.2326.010.22.30.R

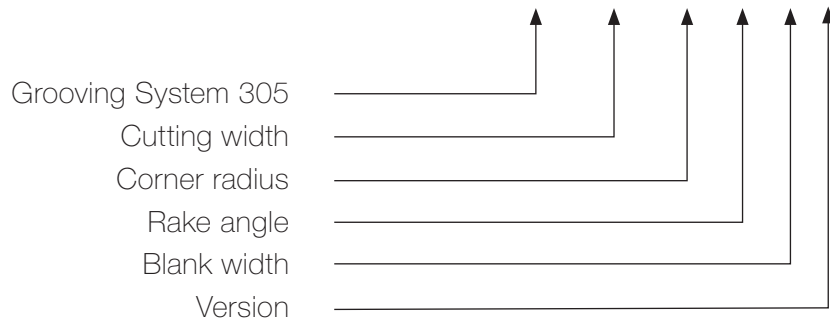


Article description

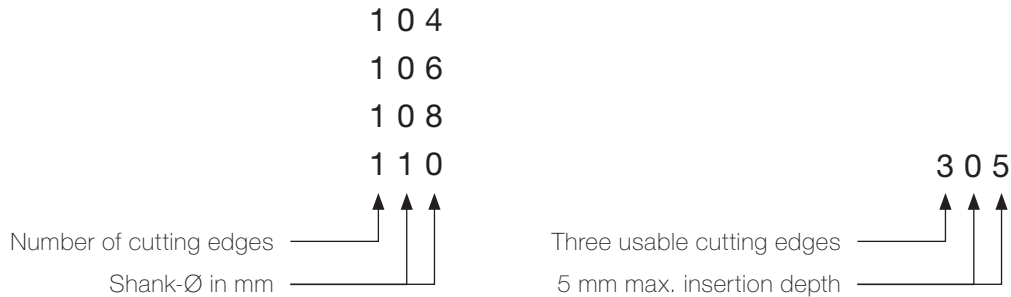
System 305



Tool description: Example: GE305.0250.020.BA.04.N



Explanation of the system



When ordering please always state the
Article No. and the Code No. i.e.:
Article GG104.VM02.040.04.15.R,
TiN-coated = **25164 4.001**

Ordering example

Micro-precision tools for internal threading

Cutting insert for internal threading, full profile - metric standard threads



• pitch P = 0.4-0.8

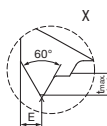
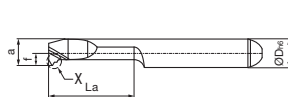
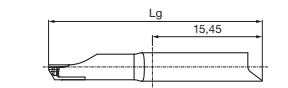
for tool holders type GH104/GB104 see from page 16

GÜHRING NAVIGATOR

Cutting data page 150

| Tool material | Solid carbide | | |
|---------------|---------------|-------------|--------|
| Type | GG 104 | GG 104 | GG 104 |
| Surface | Ⓢ | ⓐ | Ⓞ |
| | TiN | TiAlN-nanoA | bright |

System 104



Right hand version shown
Left hand version mirror image

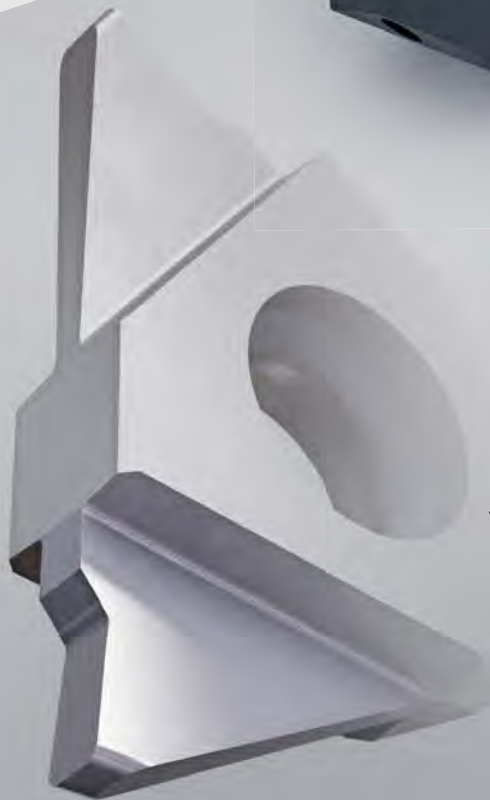
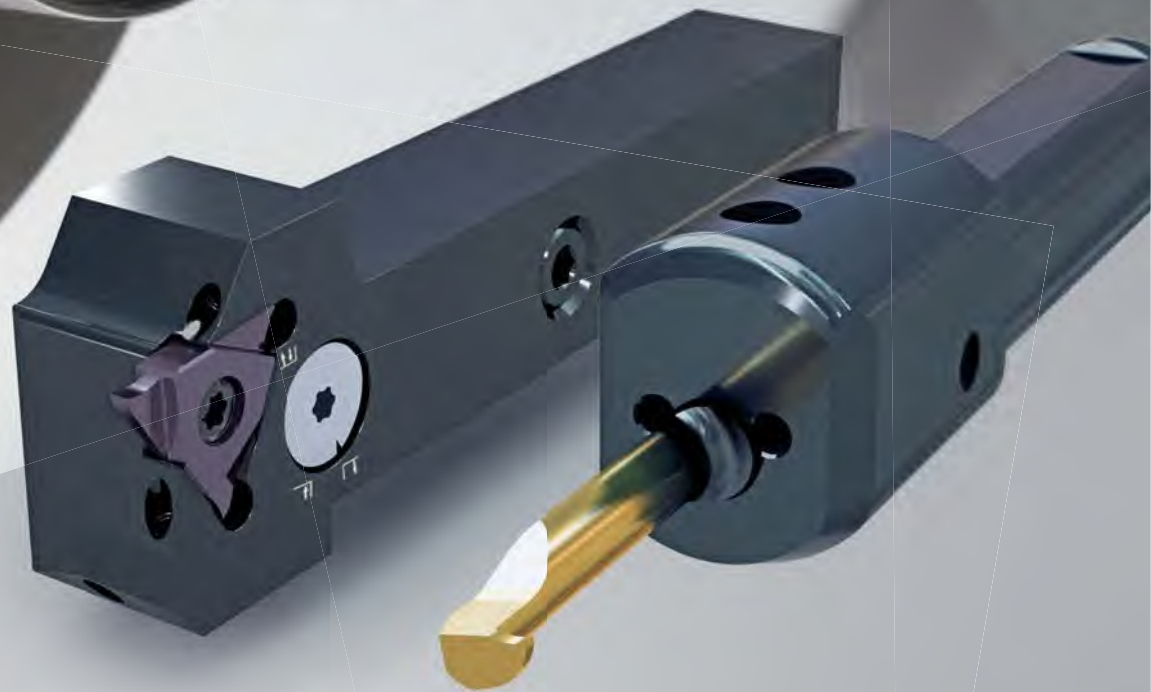
Article no. **25164** **25166** **25170**

Cutting direction **(R)** **(R)** **(R)**

Article No.

| Code no. | Description | G | P | D min | f | E | a | t max | La | Lg | D h6 |
|----------|------------------------|----|------|-------|------|------|------|-------|-------|-------|------|
| | | | mm | mm | mm | mm | mm | mm | mm | mm | mm |
| 4.001 | GG104.VM02.040.04.15.R | M2 | 0.40 | 1.50 | 1.95 | 0.20 | 1.35 | 0.25 | 4.00 | 25.00 | 4.00 |
| 4.002 | GG104.VM02.040.07.15.R | M2 | 0.40 | 1.50 | 1.95 | 0.20 | 1.35 | 0.25 | 7.00 | 25.00 | 4.00 |
| 4.003 | GG104.VM02.040.12.15.R | M2 | 0.40 | 1.50 | 1.95 | 0.20 | 1.35 | 0.25 | 12.00 | 30.00 | 4.00 |
| 4.004 | GG104.VM03.050.04.24.R | M3 | 0.50 | 2.40 | 1.95 | 0.30 | 1.95 | 0.35 | 4.00 | 25.00 | 4.00 |
| 4.005 | GG104.VM03.050.07.24.R | M3 | 0.50 | 2.40 | 1.95 | 0.30 | 1.95 | 0.35 | 7.00 | 25.00 | 4.00 |

Code No.



GROOVING SYSTEMS
Highest quality and flexibility
thanks to maximum manufacturing
depth. All from one supplier.



SYSTEM 104

| | page |
|--|------|
| Micro-precision tools from Ø 0.7 mm | 15 |
| Tool holder | 16 |
| Cutting inserts | 29 |
| Broaching from Ø 1.5 mm | 15 |
| Tool holder | 28 |
| Cutting inserts | 57 |



SYSTEM 106

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|--|------|
| Micro-precision tools from Ø 5 mm | 61 |
| Tool holder | 62 |
| Cutting inserts | 75 |
| Broaching from Ø 6 mm | 61 |
| Tool holder | 74 |
| Cutting inserts | 119 |



SYSTEM 108

| | page |
|--|------|
| Micro-precision tools from Ø 7 mm | 123 |
| Tool holder | 124 |
| Cutting inserts | 130 |



SYSTEM 110

| | page |
|--|------|
| Micro-precision tools for special solutions | 149 |
| Tool holder | 151 |



SYSTEM 305

| | page |
|---------------------------------------|------|
| Grooving and parting off | 155 |
| Tool holder | 156 |
| Indexable inserts | 171 |

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Accessories from page 196

Special solutions from page 198

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104





SYSTEM 104

MICRO-PRECISION TOOLS




Round shank holder
from page 16



Square shank holder
from page 23

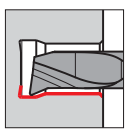


Modular holder
from page 25

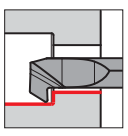


Round shank holder
Broaching
page 28

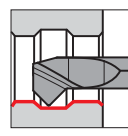
Tool holder



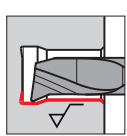
Boring out
and profiling, type GT
from page 29



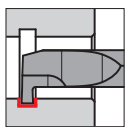
Back boring
and profiling, type GT
from page 40



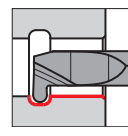
Boring out
and chamfering, type GT
page 42



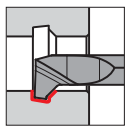
Boring out
with Wiper, type GJ
page 39



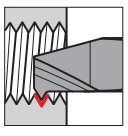
Internal grooving,
straight slots, type GE
page 43



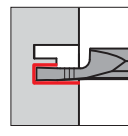
Internal grooving,
full radius slots, type GE
page 45



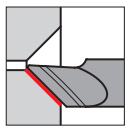
Internal grooving
and chamfering, type GV
page 46



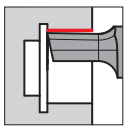
Internal threading,
type GG
from page 52



Axial grooving bores,
type GA
from page 47



Axial chamfering
bores, type GA
page 51



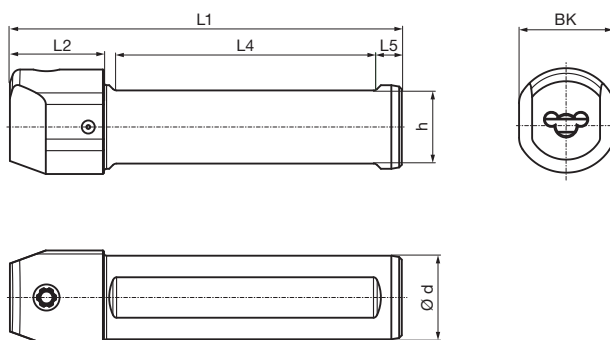
Broaching,
type GN
from page 57

Cutting inserts from hole-Ø 0.7 mm

Round shank holder, clamping screw top

- for inserts type 104
- with internal coolant supply

Type GB 104



Article no. **25000**

version left and right

| Code no. | Description | d | h | L1 | L2 | L4 | L5 | BK |
|----------|---------------------------|-------|-------|--------|-------|-------|------|------|
| | | mm | mm | mm | mm | mm | mm | mm |
| 4.001 | GB104.0010.075.00.15.N.IK | 10.00 | 9.00 | 75.00 | 18.00 | 50.00 | 5.00 | 12.0 |
| 4.002 | GB104.0012.075.00.15.N.IK | 12.00 | 11.00 | 75.00 | 18.00 | 50.00 | 5.00 | 14.0 |
| 4.015 | GB104.0500.354.00.15.N.IK | 12.70 | 11.00 | 89.92 | 17.78 | 54.86 | 5.08 | 13.9 |
| 4.016 | GB104.0625.354.00.15.N.IK | 15.87 | 14.00 | 89.92 | 17.78 | 54.86 | 5.08 | 17.7 |
| 4.003 | GB104.0016.075.00.15.N.IK | 16.00 | 14.00 | 75.00 | 18.00 | 50.00 | 5.00 | 18.0 |
| 4.017 | GB104.0750.380.00.15.N.IK | 19.05 | 17.04 | 96.52 | 17.78 | 69.85 | 5.08 | |
| 4.004 | GB104.0020.090.00.15.N.IK | 20.00 | 18.00 | 90.00 | | 55.00 | 5.00 | |
| 4.005 | GB104.0022.090.00.15.N.IK | 22.00 | 20.00 | 90.00 | | 55.00 | 5.00 | |
| 4.006 | GB104.0025.100.00.15.N.IK | 25.00 | 23.00 | 100.00 | | 55.00 | 5.00 | |
| 4.018 | GB104.1000.380.00.15.N.IK | 25.40 | 23.39 | 96.52 | | 69.85 | 5.08 | |

Spare parts

| Article no. | Clamping screw | Tightening torque |
|-------------|----------------|-------------------|
| 25900 | | Nm |
| Code 6.000 | M6x7.5x15IP | 4-4.5 |

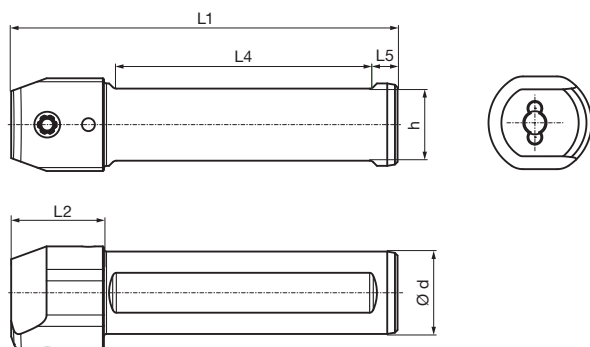
| Article no. | Torx-Plus Wrench |
|-------------|------------------|
| 25904 | |
| Code 15.000 | T15IP T-handle |



Round shank holder, clamping screw lateral

- for inserts type 104
- with internal coolant supply

| | |
|------|--------|
| Type | GB 104 |
|------|--------|



Article no. **25001**
version left and right

| Code no. | Description | d | h | L1 | L2 | L4 | L5 |
|----------|------------------------------|-------|-------|--------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm |
| 4.001 | GB104.0010.075.00.15.N.IK.90 | 10.00 | 9.00 | 75.00 | 18.00 | 50.00 | 5.00 |
| 4.002 | GB104.0012.075.00.15.N.IK.90 | 12.00 | 11.00 | 75.00 | 18.00 | 50.00 | 5.00 |
| 4.015 | GB104.0500.354.00.15.N.IK.90 | 12.70 | 11.00 | 89.92 | 17.78 | 54.86 | 5.08 |
| 4.016 | GB104.0625.354.00.15.N.IK.90 | 15.87 | 14.00 | 89.92 | 17.78 | 54.86 | 5.08 |
| 4.003 | GB104.0016.075.00.15.N.IK.90 | 16.00 | 14.00 | 75.00 | 18.00 | 50.00 | 5.00 |
| 4.017 | GB104.0750.380.00.15.N.IK.90 | 19.05 | 17.04 | 96.52 | 17.78 | 69.85 | 5.08 |
| 4.004 | GB104.0020.090.00.15.N.IK.90 | 20.00 | 18.00 | 90.00 | | 55.00 | 5.00 |
| 4.005 | GB104.0022.090.00.15.N.IK.90 | 22.00 | 20.00 | 90.00 | | 55.00 | 5.00 |
| 4.006 | GB104.0025.100.00.15.N.IK.90 | 25.00 | 23.00 | 100.00 | | 55.00 | 5.00 |
| 4.018 | GB104.1000.380.00.15.N.IK.90 | 25.40 | 23.39 | 96.52 | | 69.85 | 5.08 |

Spare parts

| Article no. | Clamping screw | Tightening torque |
|-------------|----------------|-------------------|
| 25900 | | Nm |
| Code 6.000 | M6x7.5x15IP | 4-4.5 |

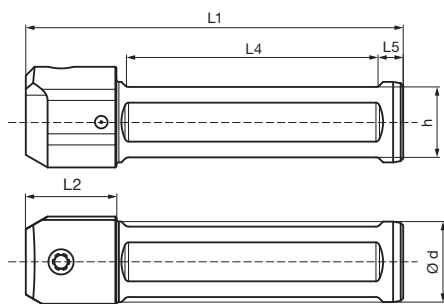
| Article no. | Torx-Plus Wrench |
|-------------|------------------|
| 25904 | |
| Code 15.000 | T15IP T-handle |



Round shank holder, clamping screw above, four clamping surfaces

- for inserts type 104
- with internal coolant supply

Type GB 104



Article no. **25018**

version left and right

| Code no. | Description | d | h | L1 | L2 | L4 | L5 | BK |
|----------|-------------------------------|-------|-------|--------|-------|-------|------|------|
| | | mm | mm | mm | mm | mm | mm | mm |
| 4.010 | GB104.0016.075.00.15.N.IK.VSP | 16.00 | 14.00 | 75.00 | 18.00 | 50.00 | 5.00 | 18.0 |
| 4.020 | GB104.0020.090.00.15.N.IK.VSP | 20.00 | 18.00 | 90.00 | | 55.00 | 5.00 | |
| 4.030 | GB104.0022.090.00.15.N.IK.VSP | 22.00 | 20.00 | 90.00 | | 55.00 | 5.00 | |
| 4.040 | GB104.0025.100.00.15.N.IK.VSP | 25.00 | 23.00 | 100.00 | | 55.00 | 5.00 | |

Spare parts

| Article no. | Clamping screw | Tightening torque |
|-------------|----------------|-------------------|
| 25900 | | Nm |
| Code 6.000 | M6x7.5x15IP | 4-4.5 |

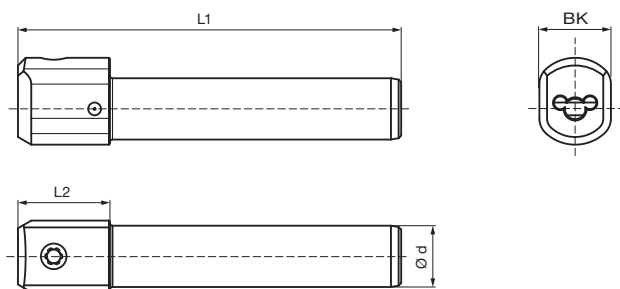
| Article no. | Torx-Plus Wrench |
|-------------|------------------|
| 25904 | |
| Code 15.000 | T15IP T-handle |



Round shank holder, clamping screw above, without clamping surfaces

- for inserts type 104
- with internal coolant supply

| | |
|------|--------|
| Type | GB 104 |
|------|--------|



Article no. **25017**
version left and right

| Code no. | Description | d | L1 | L2 | BK |
|----------|-------------------------------|-------|-------|-------|------|
| | | mm | mm | mm | mm |
| 4.010 | GB104.0010.075.00.15.N.IK.RND | 10.00 | 75.00 | 18.00 | 12.0 |
| 4.020 | GB104.0012.075.00.15.N.IK.RND | 12.00 | 75.00 | 18.00 | 14.0 |
| 4.030 | GB104.0016.075.00.15.N.IK.RND | 16.00 | 75.00 | 18.00 | 18.0 |

Spare parts

| Article no. | Clamping screw | Tightening torque |
|-------------|----------------|-------------------|
| 25900 | | Nm |
| Code 6.000 | M6x7.5x15IP | 4-4.5 |

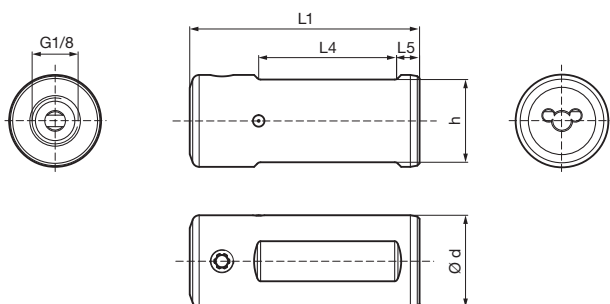
| Article no. | Torx-Plus Wrench |
|-------------|------------------|
| 25904 | |
| Code 15.000 | T15IP T-handle |



Round shank holder, clamping screw above, for Citizen machine

- for inserts type 104
- with internal coolant supply

Type GB 104



Article no. **25021**

version left and right

| Code no. | Description | d | h | L1 | L4 | L5 |
|----------|-------------------------------|-------|-------|--------|-------|------|
| | | mm | mm | mm | mm | mm |
| 4.110 | GB104.0750.040.00.15.N.IK.CIT | 19.05 | 17.04 | 40.00 | 20.32 | 5.08 |
| 4.120 | GB104.0750.050.00.15.N.IK.CIT | 19.05 | 17.04 | 50.00 | 31.75 | 5.08 |
| 4.130 | GB104.0750.070.00.15.N.IK.CIT | 19.05 | 17.04 | 70.00 | 44.45 | 5.08 |
| 4.140 | GB104.0750.100.00.15.N.IK.CIT | 19.05 | 17.04 | 100.00 | 76.20 | 5.08 |
| 4.010 | GB104.0020.050.00.15.N.IK.CIT | 20.00 | 18.00 | 50.00 | 30.00 | 5.00 |
| 4.020 | GB104.0020.030.00.15.N.IK.CIT | 20.00 | 18.00 | 30.00 | 13.00 | 5.00 |
| 4.150 | GB104.1000.060.00.15.N.IK.CIT | 25.40 | 23.39 | 60.00 | 38.10 | 5.08 |
| 4.160 | GB104.1000.100.00.15.N.IK.CIT | 25.40 | 23.39 | 100.00 | 76.20 | 5.08 |

Spare parts

| Article no. | Clamping screw | Tightening torque |
|-------------|----------------|-------------------|
| 25900 | | Nm |
| Code 6.000 | M6x7.5x15IP | 4-4.5 |

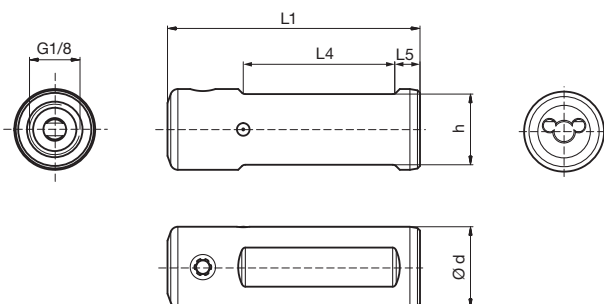
| Article no. | Torx-Plus Wrench |
|-------------|------------------|
| 25904 | |
| Code 15.000 | T15IP T-handle |



Round shank holder, clamping screw above, for Star machine

- for inserts type 104
- with internal coolant supply

| | |
|------|--------|
| Type | GB 104 |
|------|--------|



Article no. **25022**

version left and right

| Code no. | Description | d | h | L1 | L4 | L5 |
|----------|-------------------------------|-------|-------|--------|--------|------|
| | | mm | mm | mm | mm | mm |
| 4.010 | GB104.0016.030.00.15.N.IK.STA | 16.00 | 14.00 | 30.00 | 13.00 | 5.00 |
| 4.020 | GB104.0016.050.00.15.N.IK.STA | 16.00 | 14.00 | 50.00 | 30.00 | 5.00 |
| 4.030 | GB104.0016.070.00.15.N.IK.STA | 16.00 | 14.00 | 70.00 | 50.00 | 5.00 |
| 4.040 | GB104.0022.038.00.15.N.IK.STA | 22.00 | 20.00 | 38.00 | 18.00 | 5.00 |
| 4.050 | GB104.0022.050.00.15.N.IK.STA | 22.00 | 20.00 | 50.00 | 30.00 | 5.00 |
| 4.060 | GB104.0022.070.00.15.N.IK.STA | 22.00 | 20.00 | 70.00 | 50.00 | 5.00 |
| 4.070 | GB104.0022.100.00.15.N.IK.STA | 22.00 | 20.00 | 100.00 | 80.00 | 5.00 |
| 4.080 | GB104.0022.120.00.15.N.IK.STA | 22.00 | 20.00 | 120.00 | 100.00 | 5.00 |

Spare parts

| Article no. | Clamping screw | Tightening torque |
|-------------|----------------|-------------------|
| 25900 | | Nm |
| Code 6.000 | M6x7.5x15IP | 4-4.5 |

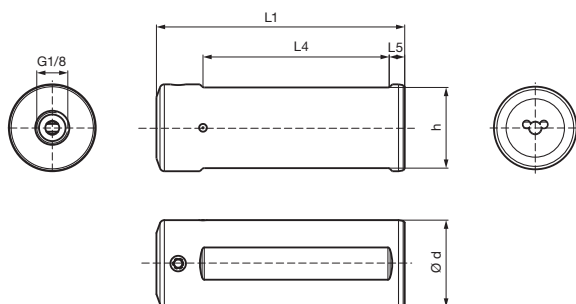
| Article no. | Torx-Plus Wrench |
|-------------|------------------|
| 25904 | |
| Code 15.000 | T15IP T-handle |



Round shank holder, clamping screw above, for Tornos machine

- for inserts type 104
- with internal coolant supply

Type GB 104



Article no. **25023**

version left and right

| Code no. | Description | d | h | L1 | L4 | L5 |
|----------|-------------------------------|-------|-------|--------|--------|------|
| | | mm | mm | mm | mm | mm |
| 4.010 | GB104.0018.310.00.15.N.IK.TOR | 18.00 | 16.00 | 310.00 | 290.00 | 5.00 |
| 4.020 | GB104.0020.170.00.15.N.IK.TOR | 20.00 | 18.00 | 170.00 | 150.00 | 5.00 |
| 4.030 | GB104.0020.185.00.15.N.IK.TOR | 20.00 | 18.00 | 185.00 | 165.00 | 5.00 |
| 4.040 | GB104.0025.100.00.15.N.IK.TOR | 25.00 | 23.00 | 100.00 | 80.00 | 5.00 |
| 4.050 | GB104.0025.150.00.15.N.IK.TOR | 25.00 | 23.00 | 150.00 | 130.00 | 5.00 |
| 4.060 | GB104.0028.080.00.15.N.IK.TOR | 28.00 | 26.00 | 80.00 | 60.00 | 5.00 |

Spare parts

| Article no. | Clamping screw | Tightening torque |
|-------------|----------------|-------------------|
| 25900 | | Nm |
| Code 6.000 | M6x7.5x15IP | 4-4.5 |

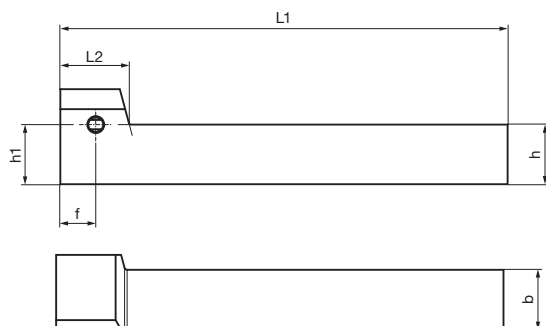
| Article no. | Torx-Plus Wrench |
|-------------|------------------|
| 25904 | |
| Code 15.000 | T15IP T-handle |



Square shank holder, 90° offset

- for inserts type 104
- without internal coolant supply

Type GH 104



Right hand version shown
Left hand version mirror image



Article no. **25002**

version right-hand

| Code no. | Description | b | h | h1 | f | L1 | L2 |
|----------|------------------------|-------|-------|-------|------|--------|-------|
| | | mm | mm | mm | mm | mm | mm |
| 4.001 | GH104.0808.090.90.15.R | 8.00 | 8.00 | 8.00 | 9.50 | 90.00 | 18.50 |
| 4.010 | GH104.0375.350.90.15.R | 9.52 | 9.52 | 9.52 | 7.62 | 88.90 | 16.51 |
| 4.002 | GH104.1010.090.90.15.R | 10.00 | 10.00 | 10.00 | 9.50 | 90.00 | 18.50 |
| 4.003 | GH104.1212.090.90.15.R | 12.00 | 12.00 | 12.00 | 9.50 | 90.00 | 18.50 |
| 4.011 | GH104.0500.350.90.15.R | 12.70 | 12.70 | 12.70 | 7.62 | 88.90 | 16.51 |
| 4.012 | GH104.0625.400.90.15.R | 15.87 | 15.87 | 15.87 | 7.62 | 101.60 | 16.51 |
| 4.004 | GH104.1616.120.90.15.R | 16.00 | 16.00 | 16.00 | 9.50 | 120.00 | 18.50 |

Article no. **25003**

version left-hand

| Code no. | Description | b | h | h1 | f | L1 | L2 |
|----------|------------------------|-------|-------|-------|------|--------|-------|
| | | mm | mm | mm | mm | mm | mm |
| 4.001 | GH104.0808.090.90.15.L | 8.00 | 8.00 | 8.00 | 9.50 | 90.00 | 18.50 |
| 4.010 | GH104.0375.350.90.15.L | 9.52 | 9.52 | 9.52 | 7.62 | 88.90 | 16.51 |
| 4.002 | GH104.1010.090.90.15.L | 10.00 | 10.00 | 10.00 | 9.50 | 90.00 | 18.50 |
| 4.003 | GH104.1212.090.90.15.L | 12.00 | 12.00 | 12.00 | 9.50 | 90.00 | 18.50 |
| 4.011 | GH104.0500.350.90.15.L | 12.70 | 12.70 | 12.70 | 7.62 | 88.90 | 16.51 |
| 4.012 | GH104.0625.400.90.15.L | 15.87 | 15.87 | 15.87 | 7.62 | 101.60 | 16.51 |
| 4.004 | GH104.1616.120.90.15.L | 16.00 | 16.00 | 16.00 | 9.50 | 120.00 | 18.50 |

Spare parts

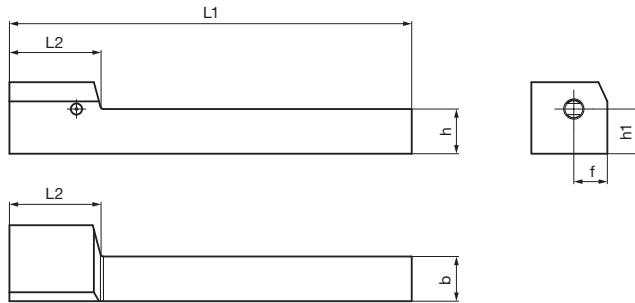
| Article no. | Clamping screw | Tightening torque |
|-------------|----------------|-------------------|
| 25900 | | Nm |
| Code 6.000 | M6x7.5x15IP | 4-4.5 |

| Article no. | Torx-Plus Wrench |
|-------------|------------------|
| 25904 | |
| Code 15.000 | T15IP T-handle |

Square shank holder, straight 0°

- for inserts type 104
- without internal coolant supply

Type GH 104



Right hand version shown
Left hand version mirror image

Article no. **25019**
version right-hand

| Code no. | Description | b | h | h1 | f | L1 | L2 |
|----------|------------------------|-------|-------|-------|------|--------|-------|
| | | mm | mm | mm | mm | mm | mm |
| 4.010 | GH104.0808.090.00.15.R | 8.00 | 8.00 | 8.00 | 7.50 | 90.00 | 20.50 |
| 4.100 | GH104.0375.350.00.15.R | 9.52 | 9.52 | 9.52 | 7.62 | 88.90 | 20.00 |
| 4.020 | GH104.1010.090.00.15.R | 10.00 | 10.00 | 10.00 | 7.50 | 90.00 | 20.50 |
| 4.030 | GH104.1212.090.00.15.R | 12.00 | 12.00 | 12.00 | 7.50 | 90.00 | 20.50 |
| 4.110 | GH104.0500.350.00.15.R | 12.70 | 12.70 | 12.70 | 7.62 | 88.90 | 20.00 |
| 4.120 | GH104.0625.400.00.15.R | 15.87 | 15.87 | 15.87 | 7.62 | 101.60 | 20.00 |
| 4.040 | GH104.1616.100.00.15.R | 16.00 | 16.00 | 16.00 | 7.50 | 100.00 | 20.50 |

Article no. **25020**
version left-hand

| Code no. | Description | b | h | h1 | f | L1 | L2 |
|----------|------------------------|-------|-------|-------|------|--------|-------|
| | | mm | mm | mm | mm | mm | mm |
| 4.010 | GH104.0808.090.00.15.L | 8.00 | 8.00 | 8.00 | 7.50 | 90.00 | 20.50 |
| 4.100 | GH104.0375.350.00.15.L | 9.52 | 9.52 | 9.52 | 7.62 | 88.90 | 20.00 |
| 4.020 | GH104.1010.090.00.15.L | 10.00 | 10.00 | 10.00 | 7.50 | 90.00 | 20.50 |
| 4.030 | GH104.1212.090.00.15.L | 12.00 | 12.00 | 12.00 | 7.50 | 90.00 | 20.50 |
| 4.110 | GH104.0500.350.00.15.L | 12.70 | 12.70 | 12.70 | 7.62 | 88.90 | 20.00 |
| 4.120 | GH104.0625.400.00.15.L | 15.87 | 15.87 | 15.87 | 7.62 | 101.60 | 20.00 |
| 4.040 | GH104.1616.100.00.15.L | 16.00 | 16.00 | 16.00 | 7.50 | 100.00 | 20.50 |

Spare parts

| Article no. | Clamping screw | Tightening torque |
|-------------|----------------|-------------------|
| 25900 | | Nm |
| Code 6.000 | M6x7.5x15IP | 4-4.5 |

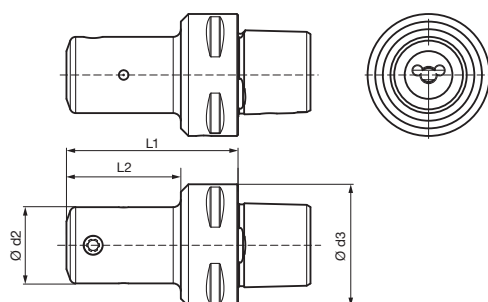
| Article no. | Torx-Plus Wrench |
|-------------|------------------|
| 25904 | |
| Code 15.000 | T15IP T-handle |


Polygon shank holder, to ISO 26623, straight 0°

- for inserts type 104
- with internal coolant supply

| | |
|------|--------|
| Type | GH 104 |
|------|--------|

System 104



| | |
|-------------|--------------|
| Article no. | 25010 |
|-------------|--------------|

| | |
|---------|----------------|
| version | left and right |
|---------|----------------|

| Code no. | Description | d2 | d3 | L1 | L2 |
|----------|---------------------------|-------|--------|-------|-------|
| | | mm | | mm | mm |
| 4.001 | GH104.PO32.045.00.15.N.IK | 20.00 | PSC 32 | 45.00 | 30.00 |
| 4.002 | GH104.PO40.050.00.15.N.IK | 20.00 | PSC 40 | 50.00 | 30.00 |
| 4.003 | GH104.PO50.050.00.15.N.IK | 20.00 | PSC 50 | 50.00 | 30.00 |
| 4.004 | GH104.PO63.052.00.15.N.IK | 20.00 | PSC 63 | 52.00 | 30.00 |

Spare parts

| Article no. | Clamping screw | Tightening torque |
|-------------|----------------|-------------------|
| 25900 | | Nm |
| Code 6.000 | M6x7.5x15IP | 4-4.5 |

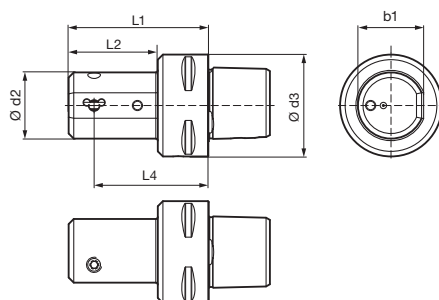
| Article no. | Torx-Plus Wrench |
|-------------|------------------|
| 25904 | |
| Code 15.000 | T15IP T-handle |



Polygon shank holder, to ISO 26623, off-set 90°

- for inserts type 104
- with internal coolant supply

Type GH 104



Right hand version shown
Left hand version mirror image

Article no. **25012**

version right-hand

| Code no. | Description | d2 | d3 | L1 | L2 | L4 | b1 |
|----------|---------------------------|-------|--------|-------|-------|-------|-------|
| | | mm | | mm | mm | mm | mm |
| 4.001 | GH104.PO32.045.90.15.R.IK | 26.00 | PSC 32 | 55.00 | 40.00 | 45.00 | 25.00 |
| 4.002 | GH104.PO40.050.90.15.R.IK | 26.00 | PSC 40 | 55.00 | 35.00 | 45.00 | 25.00 |
| 4.003 | GH104.PO50.050.90.15.R.IK | 26.00 | PSC 50 | 55.00 | 35.00 | 45.00 | 25.00 |
| 4.004 | GH104.PO63.052.90.15.R.IK | 26.00 | PSC 63 | 55.00 | 33.00 | 45.00 | 25.00 |

Article no. **25013**

version left-hand

| Code no. | Description | d2 | d3 | L1 | L2 | L4 | b1 |
|----------|---------------------------|-------|--------|-------|-------|-------|-------|
| | | mm | | mm | mm | mm | mm |
| 4.001 | GH104.PO32.045.90.15.L.IK | 26.00 | PSC 32 | 55.00 | 40.00 | 45.00 | 25.00 |
| 4.002 | GH104.PO40.050.90.15.L.IK | 26.00 | PSC 40 | 55.00 | 35.00 | 45.00 | 25.00 |
| 4.003 | GH104.PO50.050.90.15.L.IK | 26.00 | PSC 50 | 55.00 | 35.00 | 45.00 | 25.00 |
| 4.004 | GH104.PO63.052.90.15.L.IK | 26.00 | PSC 63 | 55.00 | 33.00 | 45.00 | 25.00 |

Spare parts

| Article no. | Clamping screw | Tightening torque |
|-------------|----------------|-------------------|
| 25900 | | Nm |
| Code 6.000 | M6x7.5x15IP | 4-4.5 |

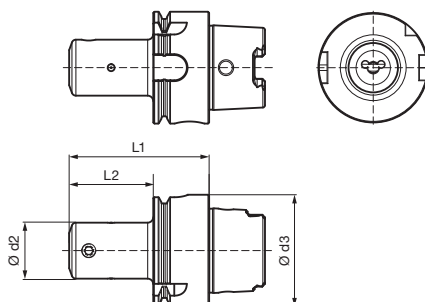
| Article no. | Torx-Plus Wrench |
|-------------|------------------|
| 25904 | |
| Code 15.000 | T15IP T-handle |


HSK-T holder, to ISO 12164-3, straight 0°

- for inserts type 104
- with internal coolant supply

| | |
|------|--------|
| Type | GH 104 |
|------|--------|

System 104



| | |
|-------------|--------------|
| Article no. | 25016 |
|-------------|--------------|

| | |
|---------|----------------|
| version | left and right |
|---------|----------------|

| Code no. | Description | d2 | d3 | L1 | L2 |
|----------|---------------------------|-------|----------|-------|-------|
| | | mm | | mm | mm |
| 4.001 | GH104.HS40.050.00.15.N.IK | 20.00 | HSK-T 40 | 50.00 | 30.00 |
| 4.002 | GH104.HS63.056.00.15.N.IK | 20.00 | HSK-T 63 | 56.00 | 30.00 |

Spare parts

| Article no. | Clamping screw | Tightening torque |
|-------------|----------------|-------------------|
| 25900 | | Nm |
| Code 6.000 | M6x7.5x15IP | 4-4.5 |

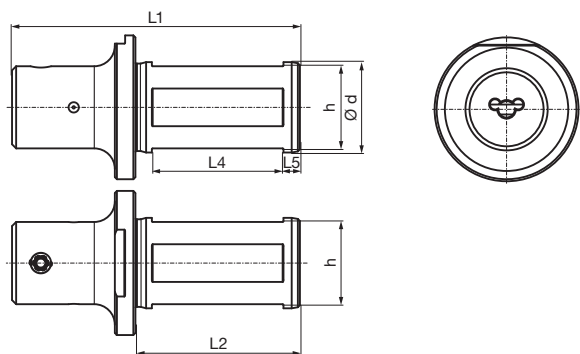
| Article no. | Torx-Plus Wrench |
|-------------|------------------|
| 25904 | |
| Code 15.000 | T15IP T-handle |



Round shank holder, 4 clamping surfaces

- for inserts type 104
- with internal coolant supply

Type GB 104



Article no. **25006**

| Code no. | Description | d | h | L1 | L2 | L4 | L5 |
|----------|---------------------------|-------|-------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm |
| 4.010 | GB104.0750.275.00.15.S.IK | 19.05 | 17.05 | 69.85 | 40.00 | 32.00 | 4.00 |
| 4.001 | GB104.0020.070.00.15.S.IK | 20.00 | 18.00 | 70.00 | 40.00 | 32.00 | 4.00 |
| 4.002 | GB104.0022.070.00.15.S.IK | 22.00 | 20.00 | 70.00 | 40.00 | 32.00 | 4.00 |
| 4.003 | GB104.0025.070.00.15.S.IK | 25.00 | 23.00 | 70.00 | 40.00 | 32.00 | 4.00 |
| 4.011 | GB104.1000.275.00.15.S.IK | 25.40 | 23.40 | 69.85 | 40.00 | 32.00 | 4.00 |

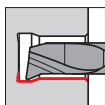
Spare parts

| Article no. | Clamping screw | Tightening torque |
|-------------|----------------|-------------------|
| 25900 | | Nm |
| Code 6.000 | M6x7.5x15IP | 4-4.5 |

| Article no. | Torx-Plus Wrench |
|-------------|------------------|
| 25904 | |
| Code 15.000 | T15IP T-handle |



Cutting insert for boring out and profiling

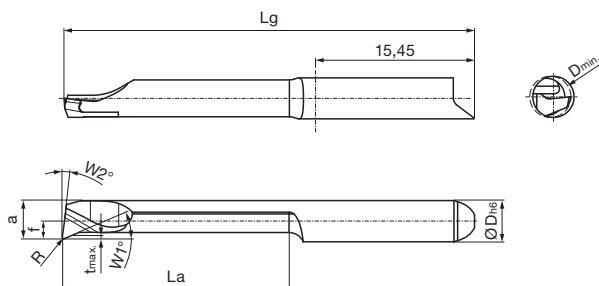


• radial free 23°

for tool holders type GH104/GB104 see from page 16

GUHRING NAVIGATOR

Cutting data page 184



Right hand version shown
Left hand version mirror image

| Tool material | Solid carbide | | | |
|---------------|---------------|-------------|--------|--------|
| | Type | GT 104 | GT 104 | GT 104 |
| Surface | S | a | ○ | |
| | TiN | TiAlN-nanoA | bright | |



| Article no. | 25050 | 25052 | 25056 |
|-------------------|------------|------------|------------|
| Cutting direction | (R) | (R) | (R) |

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 4.001 | GT104.2306.005.03.07.R | 0.70 | 0.05 | 23 | 8 | 1.95 | 0.60 | 0.05 | 3.00 | 25.00 | 4.00 |
| 4.002 | GT104.2309.005.04.10.R | 1.00 | 0.05 | 23 | 8 | 1.95 | 0.90 | 0.10 | 4.00 | 25.00 | 4.00 |
| 4.004 | GT104.2314.005.04.15.R | 1.50 | 0.05 | 23 | 8 | 1.95 | 1.40 | 0.15 | 4.00 | 25.00 | 4.00 |
| 4.010 | GT104.2319.005.04.20.R | 2.00 | 0.05 | 23 | 8 | 1.95 | 1.90 | 0.15 | 4.00 | 25.00 | 4.00 |
| 4.003 | GT104.2309.005.07.10.R | 1.00 | 0.05 | 23 | 8 | 1.95 | 0.90 | 0.10 | 7.00 | 25.00 | 4.00 |
| 4.005 | GT104.2314.005.07.15.R | 1.50 | 0.05 | 23 | 8 | 1.95 | 1.40 | 0.15 | 7.00 | 25.00 | 4.00 |
| 4.011 | GT104.2319.005.07.20.R | 2.00 | 0.05 | 23 | 8 | 1.95 | 1.90 | 0.15 | 7.00 | 25.00 | 4.00 |
| 4.022 | GT104.2326.005.07.30.R | 3.00 | 0.05 | 23 | 8 | 1.95 | 2.60 | 0.20 | 7.00 | 25.00 | 4.00 |
| 4.006 | GT104.2314.005.12.15.R | 1.50 | 0.05 | 23 | 8 | 1.95 | 1.40 | 0.15 | 12.00 | 30.00 | 4.00 |
| 4.012 | GT104.2319.005.12.20.R | 2.00 | 0.05 | 23 | 8 | 1.95 | 1.90 | 0.15 | 12.00 | 30.00 | 4.00 |
| 4.023 | GT104.2326.005.12.30.R | 3.00 | 0.05 | 23 | 8 | 1.95 | 2.60 | 0.20 | 12.00 | 30.00 | 4.00 |
| 4.034 | GT104.2337.005.12.40.R | 4.00 | 0.05 | 23 | 8 | 1.70 | 3.70 | 0.30 | 12.00 | 30.00 | 4.00 |
| 4.013 | GT104.2319.005.17.20.R | 2.00 | 0.05 | 23 | 8 | 1.95 | 1.90 | 0.15 | 17.00 | 35.00 | 4.00 |
| 4.024 | GT104.2326.005.17.30.R | 3.00 | 0.05 | 23 | 8 | 1.95 | 2.60 | 0.20 | 17.00 | 35.00 | 4.00 |
| 4.035 | GT104.2337.005.17.40.R | 4.00 | 0.05 | 23 | 8 | 1.70 | 3.70 | 0.30 | 17.00 | 35.00 | 4.00 |
| 4.025 | GT104.2326.005.22.30.R | 3.00 | 0.05 | 23 | 8 | 1.95 | 2.60 | 0.20 | 22.00 | 40.00 | 4.00 |
| 4.036 | GT104.2337.005.22.40.R | 4.00 | 0.05 | 23 | 8 | 1.70 | 3.70 | 0.30 | 22.00 | 40.00 | 4.00 |
| 4.037 | GT104.2337.005.27.40.R | 4.00 | 0.05 | 23 | 8 | 1.70 | 3.70 | 0.30 | 27.00 | 45.00 | 4.00 |
| 4.038 | GT104.2337.005.32.40.R | 4.00 | 0.05 | 23 | 8 | 1.70 | 3.70 | 0.30 | 32.00 | 50.00 | 4.00 |
| 4.007 | GT104.2314.010.04.15.R | 1.50 | 0.10 | 23 | 8 | 1.95 | 1.40 | 0.15 | 4.00 | 25.00 | 4.00 |
| 4.014 | GT104.2319.010.04.20.R | 2.00 | 0.10 | 23 | 8 | 1.95 | 1.90 | 0.15 | 4.00 | 25.00 | 4.00 |
| 4.008 | GT104.2314.010.07.15.R | 1.50 | 0.10 | 23 | 8 | 1.95 | 1.40 | 0.15 | 7.00 | 25.00 | 4.00 |
| 4.015 | GT104.2319.010.07.20.R | 2.00 | 0.10 | 23 | 8 | 1.95 | 1.90 | 0.15 | 7.00 | 25.00 | 4.00 |
| 4.026 | GT104.2326.010.07.30.R | 3.00 | 0.10 | 23 | 8 | 1.95 | 2.60 | 0.20 | 7.00 | 25.00 | 4.00 |
| 4.009 | GT104.2314.010.12.15.R | 1.50 | 0.10 | 23 | 8 | 1.95 | 1.40 | 0.15 | 12.00 | 30.00 | 4.00 |
| 4.016 | GT104.2319.010.12.20.R | 2.00 | 0.10 | 23 | 8 | 1.95 | 1.90 | 0.15 | 12.00 | 30.00 | 4.00 |
| 4.027 | GT104.2326.010.12.30.R | 3.00 | 0.10 | 23 | 8 | 1.95 | 2.60 | 0.20 | 12.00 | 30.00 | 4.00 |
| 4.017 | GT104.2319.010.17.20.R | 2.00 | 0.10 | 23 | 8 | 1.95 | 1.90 | 0.15 | 17.00 | 35.00 | 4.00 |
| 4.028 | GT104.2326.010.17.30.R | 3.00 | 0.10 | 23 | 8 | 1.95 | 2.60 | 0.20 | 17.00 | 35.00 | 4.00 |
| 4.029 | GT104.2326.010.22.30.R | 3.00 | 0.10 | 23 | 8 | 1.95 | 2.60 | 0.20 | 22.00 | 40.00 | 4.00 |
| 4.018 | GT104.2319.015.04.20.R | 2.00 | 0.15 | 23 | 8 | 1.95 | 1.90 | 0.15 | 4.00 | 25.00 | 4.00 |
| 4.019 | GT104.2319.015.07.20.R | 2.00 | 0.15 | 23 | 8 | 1.95 | 1.90 | 0.15 | 7.00 | 25.00 | 4.00 |
| 4.020 | GT104.2319.015.12.20.R | 2.00 | 0.15 | 23 | 8 | 1.95 | 1.90 | 0.15 | 12.00 | 30.00 | 4.00 |
| 4.039 | GT104.2337.015.12.40.R | 4.00 | 0.15 | 23 | 8 | 1.70 | 3.70 | 0.30 | 12.00 | 30.00 | 4.00 |
| 4.021 | GT104.2319.015.17.20.R | 2.00 | 0.15 | 23 | 8 | 1.95 | 1.90 | 0.15 | 17.00 | 35.00 | 4.00 |
| 4.040 | GT104.2337.015.17.40.R | 4.00 | 0.15 | 23 | 8 | 1.70 | 3.70 | 0.30 | 17.00 | 35.00 | 4.00 |
| 4.041 | GT104.2337.015.22.40.R | 4.00 | 0.15 | 23 | 8 | 1.70 | 3.70 | 0.30 | 22.00 | 40.00 | 4.00 |
| 4.042 | GT104.2337.015.27.40.R | 4.00 | 0.15 | 23 | 8 | 1.70 | 3.70 | 0.30 | 27.00 | 45.00 | 4.00 |
| 4.043 | GT104.2337.015.32.40.R | 4.00 | 0.15 | 23 | 8 | 1.70 | 3.70 | 0.30 | 32.00 | 50.00 | 4.00 |
| 4.030 | GT104.2326.020.07.30.R | 3.00 | 0.20 | 23 | 8 | 1.95 | 2.60 | 0.20 | 7.00 | 25.00 | 4.00 |
| 4.031 | GT104.2326.020.12.30.R | 3.00 | 0.20 | 23 | 8 | 1.95 | 2.60 | 0.20 | 12.00 | 30.00 | 4.00 |
| 4.032 | GT104.2326.020.17.30.R | 3.00 | 0.20 | 23 | 8 | 1.95 | 2.60 | 0.20 | 17.00 | 35.00 | 4.00 |

Article no. **25050** **25052** **25056**

Cutting direction   

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 4.033 | GT104.2326.020.22.30.R | 3.00 | 0.20 | 23 | 8 | 1.95 | 2.60 | 0.20 | 22.00 | 40.00 | 4.00 |
| 4.044 | GT104.2337.025.12.40.R | 4.00 | 0.25 | 23 | 8 | 1.70 | 3.70 | 0.30 | 12.00 | 30.00 | 4.00 |
| 4.045 | GT104.2337.025.17.40.R | 4.00 | 0.25 | 23 | 8 | 1.70 | 3.70 | 0.30 | 17.00 | 35.00 | 4.00 |
| 4.046 | GT104.2337.025.22.40.R | 4.00 | 0.25 | 23 | 8 | 1.70 | 3.70 | 0.30 | 22.00 | 40.00 | 4.00 |
| 4.047 | GT104.2337.025.27.40.R | 4.00 | 0.25 | 23 | 8 | 1.70 | 3.70 | 0.30 | 27.00 | 45.00 | 4.00 |
| 4.048 | GT104.2337.025.32.40.R | 4.00 | 0.25 | 23 | 8 | 1.70 | 3.70 | 0.30 | 32.00 | 50.00 | 4.00 |

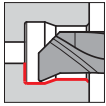
Article no. **25051** **25053** **25057**

Cutting direction   

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 4.001 | GT104.2306.005.03.07.L | 0.70 | 0.05 | 23 | 8 | 1.95 | 0.60 | 0.05 | 3.00 | 25.00 | 4.00 |
| 4.002 | GT104.2309.005.04.10.L | 1.00 | 0.05 | 23 | 8 | 1.95 | 0.90 | 0.10 | 4.00 | 25.00 | 4.00 |
| 4.004 | GT104.2314.005.04.15.L | 1.50 | 0.05 | 23 | 8 | 1.95 | 1.40 | 0.15 | 4.00 | 25.00 | 4.00 |
| 4.010 | GT104.2319.005.04.20.L | 2.00 | 0.05 | 23 | 8 | 1.95 | 1.90 | 0.15 | 4.00 | 25.00 | 4.00 |
| 4.003 | GT104.2309.005.07.10.L | 1.00 | 0.05 | 23 | 8 | 1.95 | 0.90 | 0.10 | 7.00 | 25.00 | 4.00 |
| 4.005 | GT104.2314.005.07.15.L | 1.50 | 0.05 | 23 | 8 | 1.95 | 1.40 | 0.15 | 7.00 | 25.00 | 4.00 |
| 4.011 | GT104.2319.005.07.20.L | 2.00 | 0.05 | 23 | 8 | 1.95 | 1.90 | 0.15 | 7.00 | 25.00 | 4.00 |
| 4.022 | GT104.2326.005.07.30.L | 3.00 | 0.05 | 23 | 8 | 1.95 | 2.60 | 0.20 | 7.00 | 25.00 | 4.00 |
| 4.006 | GT104.2314.005.12.15.L | 1.50 | 0.05 | 23 | 8 | 1.95 | 1.40 | 0.15 | 12.00 | 30.00 | 4.00 |
| 4.012 | GT104.2319.005.12.20.L | 2.00 | 0.05 | 23 | 8 | 1.95 | 1.90 | 0.15 | 12.00 | 30.00 | 4.00 |
| 4.023 | GT104.2326.005.12.30.L | 3.00 | 0.05 | 23 | 8 | 1.95 | 2.60 | 0.20 | 12.00 | 30.00 | 4.00 |
| 4.034 | GT104.2337.005.12.40.L | 4.00 | 0.05 | 23 | 8 | 1.70 | 3.70 | 0.30 | 12.00 | 30.00 | 4.00 |
| 4.013 | GT104.2319.005.17.20.L | 2.00 | 0.05 | 23 | 8 | 1.95 | 1.90 | 0.15 | 17.00 | 35.00 | 4.00 |
| 4.024 | GT104.2326.005.17.30.L | 3.00 | 0.05 | 23 | 8 | 1.95 | 2.60 | 0.20 | 17.00 | 35.00 | 4.00 |
| 4.035 | GT104.2337.005.17.40.L | 4.00 | 0.05 | 23 | 8 | 1.70 | 3.70 | 0.30 | 17.00 | 35.00 | 4.00 |
| 4.025 | GT104.2326.005.22.30.L | 3.00 | 0.05 | 23 | 8 | 1.95 | 2.60 | 0.20 | 22.00 | 40.00 | 4.00 |
| 4.036 | GT104.2337.005.22.40.L | 4.00 | 0.05 | 23 | 8 | 1.70 | 3.70 | 0.30 | 22.00 | 40.00 | 4.00 |
| 4.037 | GT104.2337.005.27.40.L | 4.00 | 0.05 | 23 | 8 | 1.70 | 3.70 | 0.30 | 27.00 | 45.00 | 4.00 |
| 4.038 | GT104.2337.005.32.40.L | 4.00 | 0.05 | 23 | 8 | 1.70 | 3.70 | 0.30 | 32.00 | 50.00 | 4.00 |
| 4.007 | GT104.2314.010.04.15.L | 1.50 | 0.10 | 23 | 8 | 1.95 | 1.40 | 0.15 | 4.00 | 25.00 | 4.00 |
| 4.014 | GT104.2319.010.04.20.L | 2.00 | 0.10 | 23 | 8 | 1.95 | 1.90 | 0.15 | 4.00 | 25.00 | 4.00 |
| 4.008 | GT104.2314.010.07.15.L | 1.50 | 0.10 | 23 | 8 | 1.95 | 1.40 | 0.15 | 7.00 | 25.00 | 4.00 |
| 4.015 | GT104.2319.010.07.20.L | 2.00 | 0.10 | 23 | 8 | 1.95 | 1.90 | 0.15 | 7.00 | 25.00 | 4.00 |
| 4.026 | GT104.2326.010.07.30.L | 3.00 | 0.10 | 23 | 8 | 1.95 | 2.60 | 0.20 | 7.00 | 25.00 | 4.00 |
| 4.009 | GT104.2314.010.12.15.L | 1.50 | 0.10 | 23 | 8 | 1.95 | 1.40 | 0.15 | 12.00 | 30.00 | 4.00 |
| 4.016 | GT104.2319.010.12.20.L | 2.00 | 0.10 | 23 | 8 | 1.95 | 1.90 | 0.15 | 12.00 | 30.00 | 4.00 |
| 4.027 | GT104.2326.010.12.30.L | 3.00 | 0.10 | 23 | 8 | 1.95 | 2.60 | 0.20 | 12.00 | 30.00 | 4.00 |
| 4.017 | GT104.2319.010.17.20.L | 2.00 | 0.10 | 23 | 8 | 1.95 | 1.90 | 0.15 | 17.00 | 35.00 | 4.00 |
| 4.028 | GT104.2326.010.17.30.L | 3.00 | 0.10 | 23 | 8 | 1.95 | 2.60 | 0.20 | 17.00 | 35.00 | 4.00 |
| 4.029 | GT104.2326.010.22.30.L | 3.00 | 0.10 | 23 | 8 | 1.95 | 2.60 | 0.20 | 22.00 | 40.00 | 4.00 |
| 4.018 | GT104.2319.015.04.20.L | 2.00 | 0.15 | 23 | 8 | 1.95 | 1.90 | 0.15 | 4.00 | 25.00 | 4.00 |
| 4.019 | GT104.2319.015.07.20.L | 2.00 | 0.15 | 23 | 8 | 1.95 | 1.90 | 0.15 | 7.00 | 25.00 | 4.00 |
| 4.020 | GT104.2319.015.12.20.L | 2.00 | 0.15 | 23 | 8 | 1.95 | 1.90 | 0.15 | 12.00 | 30.00 | 4.00 |
| 4.039 | GT104.2337.015.12.40.L | 4.00 | 0.15 | 23 | 8 | 1.70 | 3.70 | 0.30 | 12.00 | 30.00 | 4.00 |
| 4.021 | GT104.2319.015.17.20.L | 2.00 | 0.15 | 23 | 8 | 1.95 | 1.90 | 0.15 | 17.00 | 35.00 | 4.00 |
| 4.040 | GT104.2337.015.17.40.L | 4.00 | 0.15 | 23 | 8 | 1.70 | 3.70 | 0.30 | 17.00 | 35.00 | 4.00 |
| 4.041 | GT104.2337.015.22.40.L | 4.00 | 0.15 | 23 | 8 | 1.70 | 3.70 | 0.30 | 22.00 | 40.00 | 4.00 |
| 4.042 | GT104.2337.015.27.40.L | 4.00 | 0.15 | 23 | 8 | 1.70 | 3.70 | 0.30 | 27.00 | 45.00 | 4.00 |
| 4.043 | GT104.2337.015.32.40.L | 4.00 | 0.15 | 23 | 8 | 1.70 | 3.70 | 0.30 | 32.00 | 50.00 | 4.00 |
| 4.030 | GT104.2326.020.07.30.L | 3.00 | 0.20 | 23 | 8 | 1.95 | 2.60 | 0.20 | 7.00 | 25.00 | 4.00 |
| 4.031 | GT104.2326.020.12.30.L | 3.00 | 0.20 | 23 | 8 | 1.95 | 2.60 | 0.20 | 12.00 | 30.00 | 4.00 |
| 4.032 | GT104.2326.020.17.30.L | 3.00 | 0.20 | 23 | 8 | 1.95 | 2.60 | 0.20 | 17.00 | 35.00 | 4.00 |
| 4.033 | GT104.2326.020.22.30.L | 3.00 | 0.20 | 23 | 8 | 1.95 | 2.60 | 0.20 | 22.00 | 40.00 | 4.00 |
| 4.044 | GT104.2337.025.12.40.L | 4.00 | 0.25 | 23 | 8 | 1.70 | 3.70 | 0.30 | 12.00 | 30.00 | 4.00 |
| 4.045 | GT104.2337.025.17.40.L | 4.00 | 0.25 | 23 | 8 | 1.70 | 3.70 | 0.30 | 17.00 | 35.00 | 4.00 |
| 4.046 | GT104.2337.025.22.40.L | 4.00 | 0.25 | 23 | 8 | 1.70 | 3.70 | 0.30 | 22.00 | 40.00 | 4.00 |
| 4.047 | GT104.2337.025.27.40.L | 4.00 | 0.25 | 23 | 8 | 1.70 | 3.70 | 0.30 | 27.00 | 45.00 | 4.00 |
| 4.048 | GT104.2337.025.32.40.L | 4.00 | 0.25 | 23 | 8 | 1.70 | 3.70 | 0.30 | 32.00 | 50.00 | 4.00 |



Cutting insert for boring out and profiling

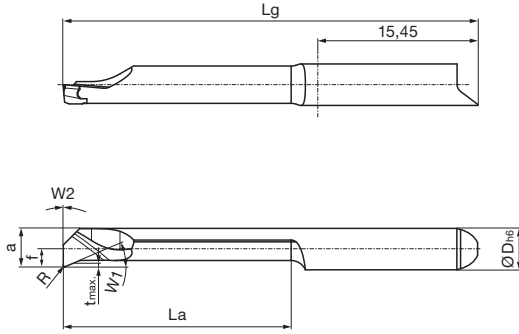


• face flat 90°

for tool holders type GH104/GB104 see from page 16

GUHRING NAVIGATOR

Cutting data page 184



Right hand version shown
Left hand version mirror image

| | | | |
|-------------------|--------------|--------------|--------------|
| Article no. | 25058 | 25060 | 25064 |
| Cutting direction | | | |

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 4.001 | GT104.9006.005.03.07.R | 0.70 | 0.05 | 23 | 0 | 1.95 | 0.60 | 0.05 | 3.00 | 25.00 | 4.00 |
| 4.002 | GT104.9009.005.04.10.R | 1.00 | 0.05 | 23 | 0 | 1.95 | 0.90 | 0.10 | 4.00 | 25.00 | 4.00 |
| 4.004 | GT104.9014.005.04.15.R | 1.50 | 0.05 | 23 | 0 | 1.95 | 1.40 | 0.15 | 4.00 | 25.00 | 4.00 |
| 4.010 | GT104.9019.005.04.20.R | 2.00 | 0.05 | 23 | 0 | 1.95 | 1.90 | 0.15 | 4.00 | 25.00 | 4.00 |
| 4.003 | GT104.9009.005.07.10.R | 1.00 | 0.05 | 23 | 0 | 1.95 | 0.90 | 0.10 | 7.00 | 25.00 | 4.00 |
| 4.005 | GT104.9014.005.07.15.R | 1.50 | 0.05 | 23 | 0 | 1.95 | 1.40 | 0.15 | 7.00 | 25.00 | 4.00 |
| 4.011 | GT104.9019.005.07.20.R | 2.00 | 0.05 | 23 | 0 | 1.95 | 1.90 | 0.15 | 7.00 | 25.00 | 4.00 |
| 4.022 | GT104.9026.005.07.30.R | 3.00 | 0.05 | 23 | 0 | 1.95 | 2.60 | 0.20 | 7.00 | 25.00 | 4.00 |
| 4.006 | GT104.9014.005.12.15.R | 1.50 | 0.05 | 23 | 0 | 1.95 | 1.40 | 0.15 | 12.00 | 30.00 | 4.00 |
| 4.012 | GT104.9019.005.12.20.R | 2.00 | 0.05 | 23 | 0 | 1.95 | 1.90 | 0.15 | 12.00 | 30.00 | 4.00 |
| 4.023 | GT104.9026.005.12.30.R | 3.00 | 0.05 | 23 | 0 | 1.95 | 2.60 | 0.20 | 12.00 | 30.00 | 4.00 |
| 4.034 | GT104.9037.005.12.40.R | 4.00 | 0.05 | 23 | 0 | 1.70 | 3.70 | 0.30 | 12.00 | 30.00 | 4.00 |
| 4.013 | GT104.9019.005.17.20.R | 2.00 | 0.05 | 23 | 0 | 1.95 | 1.90 | 0.15 | 17.00 | 35.00 | 4.00 |
| 4.024 | GT104.9026.005.17.30.R | 3.00 | 0.05 | 23 | 0 | 1.95 | 2.60 | 0.20 | 17.00 | 35.00 | 4.00 |
| 4.035 | GT104.9037.005.17.40.R | 4.00 | 0.05 | 23 | 0 | 1.70 | 3.70 | 0.30 | 17.00 | 35.00 | 4.00 |
| 4.025 | GT104.9026.005.22.30.R | 3.00 | 0.05 | 23 | 0 | 1.95 | 2.60 | 0.20 | 22.00 | 40.00 | 4.00 |
| 4.036 | GT104.9037.005.22.40.R | 4.00 | 0.05 | 23 | 0 | 1.70 | 3.70 | 0.30 | 22.00 | 40.00 | 4.00 |
| 4.037 | GT104.9037.005.27.40.R | 4.00 | 0.05 | 23 | 0 | 1.70 | 3.70 | 0.30 | 27.00 | 45.00 | 4.00 |
| 4.038 | GT104.9037.005.32.40.R | 4.00 | 0.05 | 23 | 0 | 1.70 | 3.70 | 0.30 | 32.00 | 50.00 | 4.00 |
| 4.007 | GT104.9014.010.04.15.R | 1.50 | 0.10 | 23 | 0 | 1.95 | 1.40 | 0.15 | 4.00 | 25.00 | 4.00 |
| 4.014 | GT104.9019.010.04.20.R | 2.00 | 0.10 | 23 | 0 | 1.95 | 1.90 | 0.15 | 4.00 | 25.00 | 4.00 |
| 4.008 | GT104.9014.010.07.15.R | 1.50 | 0.10 | 23 | 0 | 1.95 | 1.40 | 0.15 | 7.00 | 25.00 | 4.00 |
| 4.015 | GT104.9019.010.07.20.R | 2.00 | 0.10 | 23 | 0 | 1.95 | 1.90 | 0.15 | 7.00 | 25.00 | 4.00 |
| 4.026 | GT104.9026.010.07.30.R | 3.00 | 0.10 | 23 | 0 | 1.95 | 2.60 | 0.20 | 7.00 | 25.00 | 4.00 |
| 4.009 | GT104.9014.010.12.15.R | 1.50 | 0.10 | 23 | 0 | 1.95 | 1.40 | 0.15 | 12.00 | 30.00 | 4.00 |
| 4.016 | GT104.9019.010.12.20.R | 2.00 | 0.10 | 23 | 0 | 1.95 | 1.90 | 0.15 | 12.00 | 30.00 | 4.00 |
| 4.027 | GT104.9026.010.12.30.R | 3.00 | 0.10 | 23 | 0 | 1.95 | 2.60 | 0.20 | 12.00 | 30.00 | 4.00 |
| 4.017 | GT104.9019.010.17.20.R | 2.00 | 0.10 | 23 | 0 | 1.95 | 1.90 | 0.15 | 17.00 | 35.00 | 4.00 |
| 4.028 | GT104.9026.010.17.30.R | 3.00 | 0.10 | 23 | 0 | 1.95 | 2.60 | 0.20 | 17.00 | 35.00 | 4.00 |
| 4.029 | GT104.9026.010.22.30.R | 3.00 | 0.10 | 23 | 0 | 1.95 | 2.60 | 0.20 | 22.00 | 40.00 | 4.00 |
| 4.018 | GT104.9019.015.04.20.R | 2.00 | 0.15 | 23 | 0 | 1.95 | 1.90 | 0.15 | 4.00 | 25.00 | 4.00 |
| 4.019 | GT104.9019.015.07.20.R | 2.00 | 0.15 | 23 | 0 | 1.95 | 1.90 | 0.15 | 7.00 | 25.00 | 4.00 |
| 4.020 | GT104.9019.015.12.20.R | 2.00 | 0.15 | 23 | 0 | 1.95 | 1.90 | 0.15 | 12.00 | 30.00 | 4.00 |
| 4.039 | GT104.9037.015.12.40.R | 4.00 | 0.15 | 23 | 0 | 1.70 | 3.70 | 0.30 | 12.00 | 30.00 | 4.00 |
| 4.021 | GT104.9019.015.17.20.R | 2.00 | 0.15 | 23 | 0 | 1.95 | 1.90 | 0.15 | 17.00 | 35.00 | 4.00 |
| 4.040 | GT104.9037.015.17.40.R | 4.00 | 0.15 | 23 | 0 | 1.70 | 3.70 | 0.30 | 17.00 | 35.00 | 4.00 |
| 4.041 | GT104.9037.015.22.40.R | 4.00 | 0.15 | 23 | 0 | 1.70 | 3.70 | 0.30 | 22.00 | 40.00 | 4.00 |
| 4.042 | GT104.9037.015.27.40.R | 4.00 | 0.15 | 23 | 0 | 1.70 | 3.70 | 0.30 | 27.00 | 45.00 | 4.00 |
| 4.043 | GT104.9037.015.32.40.R | 4.00 | 0.15 | 23 | 0 | 1.70 | 3.70 | 0.30 | 32.00 | 50.00 | 4.00 |
| 4.030 | GT104.9026.020.07.30.R | 3.00 | 0.20 | 23 | 0 | 1.95 | 2.60 | 0.20 | 7.00 | 25.00 | 4.00 |
| 4.031 | GT104.9026.020.12.30.R | 3.00 | 0.20 | 23 | 0 | 1.95 | 2.60 | 0.20 | 12.00 | 30.00 | 4.00 |
| 4.032 | GT104.9026.020.17.30.R | 3.00 | 0.20 | 23 | 0 | 1.95 | 2.60 | 0.20 | 17.00 | 35.00 | 4.00 |

System 104

Article no. **25058** **25060** **25064**

Cutting direction   

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 4.033 | GT104.9026.020.22.30.R | 3.00 | 0.20 | 23 | 0 | 1.95 | 2.60 | 0.20 | 22.00 | 40.00 | 4.00 |
| 4.044 | GT104.9037.025.12.40.R | 4.00 | 0.25 | 23 | 0 | 1.70 | 3.70 | 0.30 | 12.00 | 30.00 | 4.00 |
| 4.045 | GT104.9037.025.17.40.R | 4.00 | 0.25 | 23 | 0 | 1.70 | 3.70 | 0.30 | 17.00 | 35.00 | 4.00 |
| 4.046 | GT104.9037.025.22.40.R | 4.00 | 0.25 | 23 | 0 | 1.70 | 3.70 | 0.30 | 22.00 | 40.00 | 4.00 |
| 4.047 | GT104.9037.025.27.40.R | 4.00 | 0.25 | 23 | 0 | 1.70 | 3.70 | 0.30 | 27.00 | 45.00 | 4.00 |
| 4.048 | GT104.9037.025.32.40.R | 4.00 | 0.25 | 23 | 0 | 1.70 | 3.70 | 0.30 | 32.00 | 50.00 | 4.00 |

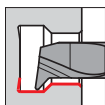
Article no. **25059** **25061** **25065**

Cutting direction   

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 4.001 | GT104.9006.005.03.07.L | 0.70 | 0.05 | 23 | 0 | 1.95 | 0.60 | 0.05 | 3.00 | 25.00 | 4.00 |
| 4.002 | GT104.9009.005.04.10.L | 1.00 | 0.05 | 23 | 0 | 1.95 | 0.90 | 0.10 | 4.00 | 25.00 | 4.00 |
| 4.004 | GT104.9014.005.04.15.L | 1.50 | 0.05 | 23 | 0 | 1.95 | 1.40 | 0.15 | 4.00 | 25.00 | 4.00 |
| 4.010 | GT104.9019.005.04.20.L | 2.00 | 0.05 | 23 | 0 | 1.95 | 1.90 | 0.15 | 4.00 | 25.00 | 4.00 |
| 4.003 | GT104.9009.005.07.10.L | 1.00 | 0.05 | 23 | 0 | 1.95 | 0.90 | 0.10 | 7.00 | 25.00 | 4.00 |
| 4.005 | GT104.9014.005.07.15.L | 1.50 | 0.05 | 23 | 0 | 1.95 | 1.40 | 0.15 | 7.00 | 25.00 | 4.00 |
| 4.011 | GT104.9019.005.07.20.L | 2.00 | 0.05 | 23 | 0 | 1.95 | 1.90 | 0.15 | 7.00 | 25.00 | 4.00 |
| 4.022 | GT104.9026.005.07.30.L | 3.00 | 0.05 | 23 | 0 | 1.95 | 2.60 | 0.20 | 7.00 | 25.00 | 4.00 |
| 4.006 | GT104.9014.005.12.15.L | 1.50 | 0.05 | 23 | 0 | 1.95 | 1.40 | 0.15 | 12.00 | 30.00 | 4.00 |
| 4.012 | GT104.9019.005.12.20.L | 2.00 | 0.05 | 23 | 0 | 1.95 | 1.90 | 0.15 | 12.00 | 30.00 | 4.00 |
| 4.023 | GT104.9026.005.12.30.L | 3.00 | 0.05 | 23 | 0 | 1.95 | 2.60 | 0.20 | 12.00 | 30.00 | 4.00 |
| 4.034 | GT104.9037.005.12.40.L | 4.00 | 0.05 | 23 | 0 | 1.70 | 3.70 | 0.30 | 12.00 | 30.00 | 4.00 |
| 4.013 | GT104.9019.005.17.20.L | 2.00 | 0.05 | 23 | 0 | 1.95 | 1.90 | 0.15 | 17.00 | 35.00 | 4.00 |
| 4.024 | GT104.9026.005.17.30.L | 3.00 | 0.05 | 23 | 0 | 1.95 | 2.60 | 0.20 | 17.00 | 35.00 | 4.00 |
| 4.035 | GT104.9037.005.17.40.L | 4.00 | 0.05 | 23 | 0 | 1.70 | 3.70 | 0.30 | 17.00 | 35.00 | 4.00 |
| 4.025 | GT104.9026.005.22.30.L | 3.00 | 0.05 | 23 | 0 | 1.95 | 2.60 | 0.20 | 22.00 | 40.00 | 4.00 |
| 4.036 | GT104.9037.005.22.40.L | 4.00 | 0.05 | 23 | 0 | 1.70 | 3.70 | 0.30 | 22.00 | 40.00 | 4.00 |
| 4.037 | GT104.9037.005.27.40.L | 4.00 | 0.05 | 23 | 0 | 1.70 | 3.70 | 0.30 | 27.00 | 45.00 | 4.00 |
| 4.038 | GT104.9037.005.32.40.L | 4.00 | 0.05 | 23 | 0 | 1.70 | 3.70 | 0.30 | 32.00 | 50.00 | 4.00 |
| 4.007 | GT104.9014.010.04.15.L | 1.50 | 0.10 | 23 | 0 | 1.95 | 1.40 | 0.15 | 4.00 | 25.00 | 4.00 |
| 4.014 | GT104.9019.010.04.20.L | 2.00 | 0.10 | 23 | 0 | 1.95 | 1.90 | 0.15 | 4.00 | 25.00 | 4.00 |
| 4.008 | GT104.9014.010.07.15.L | 1.50 | 0.10 | 23 | 0 | 1.95 | 1.40 | 0.15 | 7.00 | 25.00 | 4.00 |
| 4.015 | GT104.9019.010.07.20.L | 2.00 | 0.10 | 23 | 0 | 1.95 | 1.90 | 0.15 | 7.00 | 25.00 | 4.00 |
| 4.026 | GT104.9026.010.07.30.L | 3.00 | 0.10 | 23 | 0 | 1.95 | 2.60 | 0.20 | 7.00 | 25.00 | 4.00 |
| 4.009 | GT104.9014.010.12.15.L | 1.50 | 0.10 | 23 | 0 | 1.95 | 1.40 | 0.15 | 12.00 | 30.00 | 4.00 |
| 4.016 | GT104.9019.010.12.20.L | 2.00 | 0.10 | 23 | 0 | 1.95 | 1.90 | 0.15 | 12.00 | 30.00 | 4.00 |
| 4.027 | GT104.9026.010.12.30.L | 3.00 | 0.10 | 23 | 0 | 1.95 | 2.60 | 0.20 | 12.00 | 30.00 | 4.00 |
| 4.017 | GT104.9019.010.17.20.L | 2.00 | 0.10 | 23 | 0 | 1.95 | 1.90 | 0.15 | 17.00 | 35.00 | 4.00 |
| 4.028 | GT104.9026.010.17.30.L | 3.00 | 0.10 | 23 | 0 | 1.95 | 2.60 | 0.20 | 17.00 | 35.00 | 4.00 |
| 4.029 | GT104.9026.010.22.30.L | 3.00 | 0.10 | 23 | 0 | 1.95 | 2.60 | 0.20 | 22.00 | 40.00 | 4.00 |
| 4.018 | GT104.9019.015.04.20.L | 2.00 | 0.15 | 23 | 0 | 1.95 | 1.90 | 0.15 | 4.00 | 25.00 | 4.00 |
| 4.019 | GT104.9019.015.07.20.L | 2.00 | 0.15 | 23 | 0 | 1.95 | 1.90 | 0.15 | 7.00 | 25.00 | 4.00 |
| 4.020 | GT104.9019.015.12.20.L | 2.00 | 0.15 | 23 | 0 | 1.95 | 1.90 | 0.15 | 12.00 | 30.00 | 4.00 |
| 4.039 | GT104.9037.015.12.40.L | 4.00 | 0.15 | 23 | 0 | 1.70 | 3.70 | 0.30 | 12.00 | 30.00 | 4.00 |
| 4.021 | GT104.9019.015.17.20.L | 2.00 | 0.15 | 23 | 0 | 1.95 | 1.90 | 0.15 | 17.00 | 35.00 | 4.00 |
| 4.040 | GT104.9037.015.17.40.L | 4.00 | 0.15 | 23 | 0 | 1.70 | 3.70 | 0.30 | 17.00 | 35.00 | 4.00 |
| 4.041 | GT104.9037.015.22.40.L | 4.00 | 0.15 | 23 | 0 | 1.70 | 3.70 | 0.30 | 22.00 | 40.00 | 4.00 |
| 4.042 | GT104.9037.015.27.40.L | 4.00 | 0.15 | 23 | 0 | 1.70 | 3.70 | 0.30 | 27.00 | 45.00 | 4.00 |
| 4.043 | GT104.9037.015.32.40.L | 4.00 | 0.15 | 23 | 0 | 1.70 | 3.70 | 0.30 | 32.00 | 50.00 | 4.00 |
| 4.030 | GT104.9026.020.07.30.L | 3.00 | 0.20 | 23 | 0 | 1.95 | 2.60 | 0.20 | 7.00 | 25.00 | 4.00 |
| 4.031 | GT104.9026.020.12.30.L | 3.00 | 0.20 | 23 | 0 | 1.95 | 2.60 | 0.20 | 12.00 | 30.00 | 4.00 |
| 4.032 | GT104.9026.020.17.30.L | 3.00 | 0.20 | 23 | 0 | 1.95 | 2.60 | 0.20 | 17.00 | 35.00 | 4.00 |
| 4.033 | GT104.9026.020.22.30.L | 3.00 | 0.20 | 23 | 0 | 1.95 | 2.60 | 0.20 | 22.00 | 40.00 | 4.00 |
| 4.044 | GT104.9037.025.12.40.L | 4.00 | 0.25 | 23 | 0 | 1.70 | 3.70 | 0.30 | 12.00 | 30.00 | 4.00 |
| 4.045 | GT104.9037.025.17.40.L | 4.00 | 0.25 | 23 | 0 | 1.70 | 3.70 | 0.30 | 17.00 | 35.00 | 4.00 |
| 4.046 | GT104.9037.025.22.40.L | 4.00 | 0.25 | 23 | 0 | 1.70 | 3.70 | 0.30 | 22.00 | 40.00 | 4.00 |
| 4.047 | GT104.9037.025.27.40.L | 4.00 | 0.25 | 23 | 0 | 1.70 | 3.70 | 0.30 | 27.00 | 45.00 | 4.00 |
| 4.048 | GT104.9037.025.32.40.L | 4.00 | 0.25 | 23 | 0 | 1.70 | 3.70 | 0.30 | 32.00 | 50.00 | 4.00 |



Cutting insert for boring out and profiling



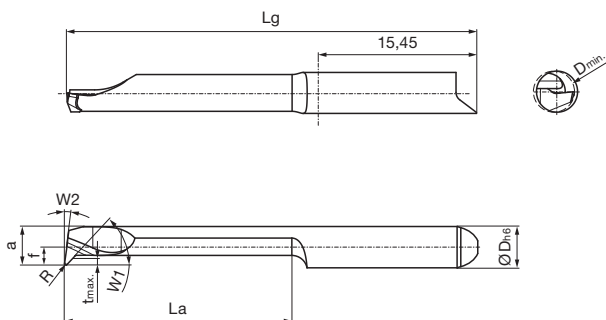
• radial free 47°

for tool holders type GH104/GB104 see from page 16

GUHRING NAVIGATOR

Cutting data page 184

| Tool material | Solid carbide | | |
|---------------|---------------|-------------|--------|
| | Type | GT 104 | GT 104 |
| Surface | S | a | ○ |
| | TiN | TiAlN-nanoA | bright |



Right hand version shown
Left hand version mirror image



Article no. **25066** **25068** **25072**

Cutting direction **(R)** **(R)** **(R)**

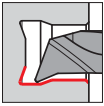
| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 4.001 | GT104.4717.005.04.20.R | 2.00 | 0.05 | 47 | 8 | 1.95 | 1.70 | 0.35 | 4.00 | 25.00 | 4.00 |
| 4.002 | GT104.4717.005.07.20.R | 2.00 | 0.05 | 47 | 8 | 1.95 | 1.70 | 0.35 | 7.00 | 25.00 | 4.00 |
| 4.013 | GT104.4727.005.07.30.R | 3.00 | 0.05 | 47 | 8 | 1.95 | 2.70 | 0.55 | 7.00 | 25.00 | 4.00 |
| 4.003 | GT104.4717.005.12.20.R | 2.00 | 0.05 | 47 | 8 | 1.95 | 1.70 | 0.35 | 12.00 | 30.00 | 4.00 |
| 4.014 | GT104.4727.005.12.30.R | 3.00 | 0.05 | 47 | 8 | 1.95 | 2.70 | 0.55 | 12.00 | 30.00 | 4.00 |
| 4.025 | GT104.4737.005.12.40.R | 4.00 | 0.05 | 47 | 8 | 1.70 | 3.70 | 0.60 | 12.00 | 30.00 | 4.00 |
| 4.004 | GT104.4717.005.17.20.R | 2.00 | 0.05 | 47 | 8 | 1.95 | 1.70 | 0.35 | 17.00 | 35.00 | 4.00 |
| 4.015 | GT104.4727.005.17.30.R | 3.00 | 0.05 | 47 | 8 | 1.95 | 2.70 | 0.55 | 17.00 | 35.00 | 4.00 |
| 4.026 | GT104.4737.005.17.40.R | 4.00 | 0.05 | 47 | 8 | 1.70 | 3.70 | 0.60 | 17.00 | 35.00 | 4.00 |
| 4.016 | GT104.4727.005.22.30.R | 3.00 | 0.05 | 47 | 8 | 1.95 | 2.70 | 0.55 | 22.00 | 40.00 | 4.00 |
| 4.027 | GT104.4737.005.22.40.R | 4.00 | 0.05 | 47 | 8 | 1.70 | 3.70 | 0.60 | 22.00 | 40.00 | 4.00 |
| 4.028 | GT104.4737.005.27.40.R | 4.00 | 0.05 | 47 | 8 | 1.70 | 3.70 | 0.60 | 27.00 | 45.00 | 4.00 |
| 4.029 | GT104.4737.005.32.40.R | 4.00 | 0.05 | 47 | 8 | 1.70 | 3.70 | 0.60 | 32.00 | 50.00 | 4.00 |
| 4.005 | GT104.4717.010.04.20.R | 2.00 | 0.10 | 47 | 8 | 1.95 | 1.70 | 0.35 | 4.00 | 25.00 | 4.00 |
| 4.006 | GT104.4717.010.07.20.R | 2.00 | 0.10 | 47 | 8 | 1.95 | 1.70 | 0.35 | 7.00 | 25.00 | 4.00 |
| 4.017 | GT104.4727.010.07.30.R | 3.00 | 0.10 | 47 | 8 | 1.95 | 2.70 | 0.55 | 7.00 | 25.00 | 4.00 |
| 4.007 | GT104.4717.010.12.20.R | 2.00 | 0.10 | 47 | 8 | 1.95 | 1.70 | 0.35 | 12.00 | 30.00 | 4.00 |
| 4.018 | GT104.4727.010.12.30.R | 3.00 | 0.10 | 47 | 8 | 1.95 | 2.70 | 0.55 | 12.00 | 30.00 | 4.00 |
| 4.008 | GT104.4717.010.17.20.R | 2.00 | 0.10 | 47 | 8 | 1.95 | 1.70 | 0.35 | 17.00 | 35.00 | 4.00 |
| 4.019 | GT104.4727.010.17.30.R | 3.00 | 0.10 | 47 | 8 | 1.95 | 2.70 | 0.55 | 17.00 | 35.00 | 4.00 |
| 4.020 | GT104.4727.010.22.30.R | 3.00 | 0.10 | 47 | 8 | 1.95 | 2.70 | 0.55 | 22.00 | 40.00 | 4.00 |
| 4.009 | GT104.4717.015.04.20.R | 2.00 | 0.15 | 47 | 8 | 1.95 | 1.70 | 0.35 | 4.00 | 25.00 | 4.00 |
| 4.010 | GT104.4717.015.07.20.R | 2.00 | 0.15 | 47 | 8 | 1.95 | 1.70 | 0.35 | 7.00 | 25.00 | 4.00 |
| 4.011 | GT104.4717.015.12.20.R | 2.00 | 0.15 | 47 | 8 | 1.95 | 1.70 | 0.35 | 12.00 | 30.00 | 4.00 |
| 4.030 | GT104.4737.015.12.40.R | 4.00 | 0.15 | 47 | 8 | 1.70 | 3.70 | 0.60 | 12.00 | 30.00 | 4.00 |
| 4.012 | GT104.4717.015.17.20.R | 2.00 | 0.15 | 47 | 8 | 1.95 | 1.70 | 0.35 | 17.00 | 35.00 | 4.00 |
| 4.031 | GT104.4737.015.17.40.R | 4.00 | 0.15 | 47 | 8 | 1.70 | 3.70 | 0.60 | 17.00 | 35.00 | 4.00 |
| 4.032 | GT104.4737.015.22.40.R | 4.00 | 0.15 | 47 | 8 | 1.70 | 3.70 | 0.60 | 22.00 | 40.00 | 4.00 |
| 4.033 | GT104.4737.015.27.40.R | 4.00 | 0.15 | 47 | 8 | 1.70 | 3.70 | 0.60 | 27.00 | 45.00 | 4.00 |
| 4.034 | GT104.4737.015.32.40.R | 4.00 | 0.15 | 47 | 8 | 1.70 | 3.70 | 0.60 | 32.00 | 50.00 | 4.00 |
| 4.021 | GT104.4727.025.07.30.R | 3.00 | 0.25 | 47 | 8 | 1.95 | 2.70 | 0.55 | 7.00 | 25.00 | 4.00 |
| 4.022 | GT104.4727.025.12.30.R | 3.00 | 0.25 | 47 | 8 | 1.95 | 2.70 | 0.55 | 12.00 | 30.00 | 4.00 |
| 4.035 | GT104.4737.025.12.40.R | 4.00 | 0.25 | 47 | 8 | 1.70 | 3.70 | 0.60 | 12.00 | 30.00 | 4.00 |
| 4.023 | GT104.4727.025.17.30.R | 3.00 | 0.25 | 47 | 8 | 1.95 | 2.70 | 0.55 | 17.00 | 35.00 | 4.00 |
| 4.036 | GT104.4737.025.17.40.R | 4.00 | 0.25 | 47 | 8 | 1.70 | 3.70 | 0.60 | 17.00 | 35.00 | 4.00 |
| 4.024 | GT104.4727.025.22.30.R | 3.00 | 0.25 | 47 | 8 | 1.95 | 2.70 | 0.55 | 22.00 | 40.00 | 4.00 |
| 4.037 | GT104.4737.025.22.40.R | 4.00 | 0.25 | 47 | 8 | 1.70 | 3.70 | 0.60 | 22.00 | 40.00 | 4.00 |
| 4.038 | GT104.4737.025.27.40.R | 4.00 | 0.25 | 47 | 8 | 1.70 | 3.70 | 0.60 | 27.00 | 45.00 | 4.00 |
| 4.039 | GT104.4737.025.32.40.R | 4.00 | 0.25 | 47 | 8 | 1.70 | 3.70 | 0.60 | 32.00 | 50.00 | 4.00 |

Article no. **25067** **25069** **25073**Cutting direction   

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 4.001 | GT104.4717.005.04.20.L | 2.00 | 0.05 | 47 | 8 | 1.95 | 1.70 | 0.35 | 4.00 | 25.00 | 4.00 |
| 4.002 | GT104.4717.005.07.20.L | 2.00 | 0.05 | 47 | 8 | 1.95 | 1.70 | 0.35 | 7.00 | 25.00 | 4.00 |
| 4.013 | GT104.4727.005.07.30.L | 3.00 | 0.05 | 47 | 8 | 1.95 | 2.70 | 0.55 | 7.00 | 25.00 | 4.00 |
| 4.003 | GT104.4717.005.12.20.L | 2.00 | 0.05 | 47 | 8 | 1.95 | 1.70 | 0.35 | 12.00 | 30.00 | 4.00 |
| 4.014 | GT104.4727.005.12.30.L | 3.00 | 0.05 | 47 | 8 | 1.95 | 2.70 | 0.55 | 12.00 | 30.00 | 4.00 |
| 4.025 | GT104.4737.005.12.40.L | 4.00 | 0.05 | 47 | 8 | 1.70 | 3.70 | 0.60 | 12.00 | 30.00 | 4.00 |
| 4.004 | GT104.4717.005.17.20.L | 2.00 | 0.05 | 47 | 8 | 1.95 | 1.70 | 0.35 | 17.00 | 35.00 | 4.00 |
| 4.015 | GT104.4727.005.17.30.L | 3.00 | 0.05 | 47 | 8 | 1.95 | 2.70 | 0.55 | 17.00 | 35.00 | 4.00 |
| 4.026 | GT104.4737.005.17.40.L | 4.00 | 0.05 | 47 | 8 | 1.70 | 3.70 | 0.60 | 17.00 | 35.00 | 4.00 |
| 4.016 | GT104.4727.010.22.30.L | 3.00 | 0.05 | 47 | 8 | 1.95 | 2.70 | 0.55 | 22.00 | 40.00 | 4.00 |
| 4.027 | GT104.4737.005.22.40.L | 4.00 | 0.05 | 47 | 8 | 1.70 | 3.70 | 0.60 | 22.00 | 40.00 | 4.00 |
| 4.028 | GT104.4737.005.27.40.L | 4.00 | 0.05 | 47 | 8 | 1.70 | 3.70 | 0.60 | 27.00 | 45.00 | 4.00 |
| 4.029 | GT104.4737.005.32.40.L | 4.00 | 0.05 | 47 | 8 | 1.70 | 3.70 | 0.60 | 32.00 | 50.00 | 4.00 |
| 4.005 | GT104.4717.010.04.20.L | 2.00 | 0.10 | 47 | 8 | 1.95 | 1.70 | 0.35 | 4.00 | 25.00 | 4.00 |
| 4.006 | GT104.4717.010.07.20.L | 2.00 | 0.10 | 47 | 8 | 1.95 | 1.70 | 0.35 | 7.00 | 25.00 | 4.00 |
| 4.017 | GT104.4727.010.07.30.L | 3.00 | 0.10 | 47 | 8 | 1.95 | 2.70 | 0.55 | 7.00 | 25.00 | 4.00 |
| 4.007 | GT104.4717.010.12.20.L | 2.00 | 0.10 | 47 | 8 | 1.95 | 1.70 | 0.35 | 12.00 | 30.00 | 4.00 |
| 4.018 | GT104.4727.010.12.30.L | 3.00 | 0.10 | 47 | 8 | 1.95 | 2.70 | 0.55 | 12.00 | 30.00 | 4.00 |
| 4.008 | GT104.4717.010.17.20.L | 2.00 | 0.10 | 47 | 8 | 1.95 | 1.70 | 0.35 | 17.00 | 35.00 | 4.00 |
| 4.019 | GT104.4727.010.17.30.L | 3.00 | 0.10 | 47 | 8 | 1.95 | 2.70 | 0.55 | 17.00 | 35.00 | 4.00 |
| 4.020 | GT104.4727.010.22.30.L | 3.00 | 0.10 | 47 | 8 | 1.95 | 2.70 | 0.55 | 22.00 | 40.00 | 4.00 |
| 4.009 | GT104.4717.015.04.20.L | 2.00 | 0.15 | 47 | 8 | 1.95 | 1.70 | 0.35 | 4.00 | 25.00 | 4.00 |
| 4.010 | GT104.4717.015.07.20.L | 2.00 | 0.15 | 47 | 8 | 1.95 | 1.70 | 0.35 | 7.00 | 25.00 | 4.00 |
| 4.011 | GT104.4717.015.12.20.L | 2.00 | 0.15 | 47 | 8 | 1.95 | 1.70 | 0.35 | 12.00 | 30.00 | 4.00 |
| 4.030 | GT104.4737.015.12.40.L | 4.00 | 0.15 | 47 | 8 | 1.70 | 3.70 | 0.60 | 12.00 | 30.00 | 4.00 |
| 4.012 | GT104.4717.015.17.20.L | 2.00 | 0.15 | 47 | 8 | 1.95 | 1.70 | 0.35 | 17.00 | 35.00 | 4.00 |
| 4.031 | GT104.4737.015.17.40.L | 4.00 | 0.15 | 47 | 8 | 1.70 | 3.70 | 0.60 | 17.00 | 35.00 | 4.00 |
| 4.032 | GT104.4737.015.22.40.L | 4.00 | 0.15 | 47 | 8 | 1.70 | 3.70 | 0.60 | 22.00 | 40.00 | 4.00 |
| 4.033 | GT104.4737.015.27.40.L | 4.00 | 0.15 | 47 | 8 | 1.70 | 3.70 | 0.60 | 27.00 | 45.00 | 4.00 |
| 4.034 | GT104.4737.015.32.40.L | 4.00 | 0.15 | 47 | 8 | 1.70 | 3.70 | 0.60 | 32.00 | 50.00 | 4.00 |
| 4.021 | GT104.4727.025.07.30.L | 3.00 | 0.25 | 47 | 8 | 1.95 | 2.70 | 0.55 | 7.00 | 25.00 | 4.00 |
| 4.022 | GT104.4727.025.12.30.L | 3.00 | 0.25 | 47 | 8 | 1.95 | 2.70 | 0.55 | 12.00 | 30.00 | 4.00 |
| 4.035 | GT104.4737.025.12.40.L | 4.00 | 0.25 | 47 | 8 | 1.70 | 3.70 | 0.60 | 12.00 | 30.00 | 4.00 |
| 4.023 | GT104.4727.025.17.30.L | 3.00 | 0.25 | 47 | 8 | 1.95 | 2.70 | 0.55 | 17.00 | 35.00 | 4.00 |
| 4.036 | GT104.4737.025.17.40.L | 4.00 | 0.25 | 47 | 8 | 1.70 | 3.70 | 0.60 | 17.00 | 35.00 | 4.00 |
| 4.024 | GT104.4727.025.22.30.L | 3.00 | 0.25 | 47 | 8 | 1.95 | 2.70 | 0.55 | 22.00 | 40.00 | 4.00 |
| 4.037 | GT104.4737.025.22.40.L | 4.00 | 0.25 | 47 | 8 | 1.70 | 3.70 | 0.60 | 22.00 | 40.00 | 4.00 |
| 4.038 | GT104.4737.025.27.40.L | 4.00 | 0.25 | 47 | 8 | 1.70 | 3.70 | 0.60 | 27.00 | 45.00 | 4.00 |
| 4.039 | GT104.4737.025.32.40.L | 4.00 | 0.25 | 47 | 8 | 1.70 | 3.70 | 0.60 | 32.00 | 50.00 | 4.00 |



Cutting insert for boring out and profiling

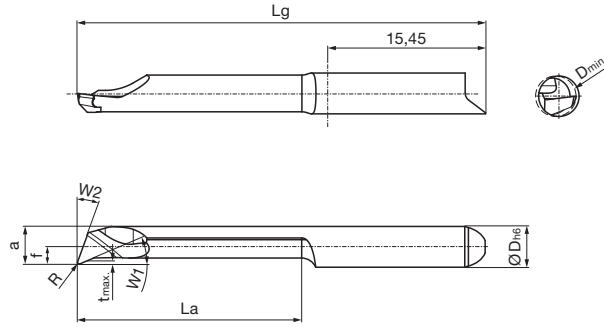


• face free 20°

for tool holders type GH104/GB104 see from page 16

GUHRING NAVIGATOR

Cutting data page 184



Right hand version shown
Left hand version mirror image

Article no. **25074** **25076** **25080**

Cutting direction

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 4.001 | GT104.2026.005.07.30.R | 3.00 | 0.05 | 23 | 20 | 1.95 | 2.60 | 0.20 | 7.00 | 25.00 | 4.00 |
| 4.002 | GT104.2026.005.12.30.R | 3.00 | 0.05 | 23 | 20 | 1.95 | 2.60 | 0.20 | 12.00 | 30.00 | 4.00 |
| 4.013 | GT104.2037.005.12.40.R | 4.00 | 0.05 | 23 | 20 | 1.70 | 3.70 | 0.30 | 12.00 | 30.00 | 4.00 |
| 4.003 | GT104.2026.005.17.30.R | 3.00 | 0.05 | 23 | 20 | 1.95 | 2.60 | 0.20 | 17.00 | 35.00 | 4.00 |
| 4.014 | GT104.2037.005.17.40.R | 4.00 | 0.05 | 23 | 20 | 1.70 | 3.70 | 0.30 | 17.00 | 35.00 | 4.00 |
| 4.004 | GT104.2026.005.22.30.R | 3.00 | 0.05 | 23 | 20 | 1.95 | 2.60 | 0.20 | 22.00 | 40.00 | 4.00 |
| 4.015 | GT104.2037.005.22.40.R | 4.00 | 0.05 | 23 | 20 | 1.70 | 3.70 | 0.30 | 22.00 | 40.00 | 4.00 |
| 4.016 | GT104.2037.005.27.40.R | 4.00 | 0.05 | 23 | 20 | 1.70 | 3.70 | 0.30 | 27.00 | 45.00 | 4.00 |
| 4.017 | GT104.2037.005.32.40.R | 4.00 | 0.05 | 23 | 20 | 1.70 | 3.70 | 0.30 | 32.00 | 50.00 | 4.00 |
| 4.005 | GT104.2026.010.07.30.R | 3.00 | 0.10 | 23 | 20 | 1.95 | 2.60 | 0.20 | 7.00 | 25.00 | 4.00 |
| 4.006 | GT104.2026.010.12.30.R | 3.00 | 0.10 | 23 | 20 | 1.95 | 2.60 | 0.20 | 12.00 | 30.00 | 4.00 |
| 4.007 | GT104.2026.010.17.30.R | 3.00 | 0.10 | 23 | 20 | 1.95 | 2.60 | 0.20 | 17.00 | 35.00 | 4.00 |
| 4.008 | GT104.2026.010.22.30.R | 3.00 | 0.10 | 23 | 20 | 1.95 | 2.60 | 0.20 | 22.00 | 40.00 | 4.00 |
| 4.018 | GT104.2037.015.12.40.R | 4.00 | 0.15 | 23 | 20 | 1.70 | 3.70 | 0.30 | 12.00 | 30.00 | 4.00 |
| 4.019 | GT104.2037.015.17.40.R | 4.00 | 0.15 | 23 | 20 | 1.70 | 3.70 | 0.30 | 17.00 | 35.00 | 4.00 |
| 4.020 | GT104.2037.015.22.40.R | 4.00 | 0.15 | 23 | 20 | 1.70 | 3.70 | 0.30 | 22.00 | 40.00 | 4.00 |
| 4.021 | GT104.2037.015.27.40.R | 4.00 | 0.15 | 23 | 20 | 1.70 | 3.70 | 0.30 | 27.00 | 45.00 | 4.00 |
| 4.022 | GT104.2037.015.32.40.R | 4.00 | 0.15 | 23 | 20 | 1.70 | 3.70 | 0.30 | 32.00 | 50.00 | 4.00 |
| 4.009 | GT104.2026.020.07.30.R | 3.00 | 0.20 | 23 | 20 | 1.95 | 2.60 | 0.20 | 7.00 | 25.00 | 4.00 |
| 4.010 | GT104.2026.020.12.30.R | 3.00 | 0.20 | 23 | 20 | 1.95 | 2.60 | 0.20 | 12.00 | 30.00 | 4.00 |
| 4.011 | GT104.2026.020.17.30.R | 3.00 | 0.20 | 23 | 20 | 1.95 | 2.60 | 0.20 | 17.00 | 35.00 | 4.00 |
| 4.012 | GT104.2026.020.22.30.R | 3.00 | 0.20 | 23 | 20 | 1.95 | 2.60 | 0.20 | 22.00 | 40.00 | 4.00 |
| 4.023 | GT104.2037.025.12.40.R | 4.00 | 0.25 | 23 | 20 | 1.70 | 3.70 | 0.30 | 12.00 | 30.00 | 4.00 |
| 4.024 | GT104.2037.025.17.40.R | 4.00 | 0.25 | 23 | 20 | 1.70 | 3.70 | 0.30 | 17.00 | 35.00 | 4.00 |
| 4.025 | GT104.2037.025.22.40.R | 4.00 | 0.25 | 23 | 20 | 1.70 | 3.70 | 0.30 | 22.00 | 40.00 | 4.00 |
| 4.026 | GT104.2037.025.27.40.R | 4.00 | 0.25 | 23 | 20 | 1.70 | 3.70 | 0.30 | 27.00 | 45.00 | 4.00 |
| 4.027 | GT104.2037.025.32.40.R | 4.00 | 0.25 | 23 | 20 | 1.70 | 3.70 | 0.30 | 32.00 | 50.00 | 4.00 |

Article no. **25075** **25077** **25081**

Cutting direction

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 4.001 | GT104.2026.005.07.30.L | 3.00 | 0.05 | 23 | 20 | 1.95 | 2.60 | 0.20 | 7.00 | 25.00 | 4.00 |
| 4.002 | GT104.2026.005.12.30.L | 3.00 | 0.05 | 23 | 20 | 1.95 | 2.60 | 0.20 | 12.00 | 30.00 | 4.00 |
| 4.013 | GT104.2037.005.12.40.L | 4.00 | 0.05 | 23 | 20 | 1.70 | 3.70 | 0.30 | 12.00 | 30.00 | 4.00 |
| 4.003 | GT104.2026.005.17.30.L | 3.00 | 0.05 | 23 | 20 | 1.95 | 2.60 | 0.20 | 17.00 | 35.00 | 4.00 |
| 4.014 | GT104.2037.005.17.40.L | 4.00 | 0.05 | 23 | 20 | 1.70 | 3.70 | 0.30 | 17.00 | 35.00 | 4.00 |
| 4.004 | GT104.2026.005.22.30.L | 3.00 | 0.05 | 23 | 20 | 1.95 | 2.60 | 0.20 | 22.00 | 40.00 | 4.00 |



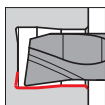
Article no. **25075** **25077** **25081**

Cutting direction

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 4.015 | GT104.2037.005.22.40.L | 4.00 | 0.05 | 23 | 20 | 1.70 | 3.70 | 0.30 | 22.00 | 40.00 | 4.00 |
| 4.016 | GT104.2037.005.27.40.L | 4.00 | 0.05 | 23 | 20 | 1.70 | 3.70 | 0.30 | 27.00 | 45.00 | 4.00 |
| 4.017 | GT104.2037.005.32.40.L | 4.00 | 0.05 | 23 | 20 | 1.70 | 3.70 | 0.30 | 32.00 | 50.00 | 4.00 |
| 4.005 | GT104.2026.010.07.30.L | 3.00 | 0.10 | 23 | 20 | 1.95 | 2.60 | 0.20 | 7.00 | 25.00 | 4.00 |
| 4.006 | GT104.2026.010.12.30.L | 3.00 | 0.10 | 23 | 20 | 1.95 | 2.60 | 0.20 | 12.00 | 30.00 | 4.00 |
| 4.007 | GT104.2026.010.17.30.L | 3.00 | 0.10 | 23 | 20 | 1.95 | 2.60 | 0.20 | 17.00 | 35.00 | 4.00 |
| 4.008 | GT104.2026.010.22.30.L | 3.00 | 0.10 | 23 | 20 | 1.95 | 2.60 | 0.20 | 22.00 | 40.00 | 4.00 |
| 4.018 | GT104.2037.015.12.40.L | 4.00 | 0.15 | 23 | 20 | 1.70 | 3.70 | 0.30 | 12.00 | 30.00 | 4.00 |
| 4.019 | GT104.2037.015.17.40.L | 4.00 | 0.15 | 23 | 20 | 1.70 | 3.70 | 0.30 | 17.00 | 35.00 | 4.00 |
| 4.020 | GT104.2037.015.22.40.L | 4.00 | 0.15 | 23 | 20 | 1.70 | 3.70 | 0.30 | 22.00 | 40.00 | 4.00 |
| 4.021 | GT104.2037.015.27.40.L | 4.00 | 0.15 | 23 | 20 | 1.70 | 3.70 | 0.30 | 27.00 | 45.00 | 4.00 |
| 4.022 | GT104.2037.015.32.40.L | 4.00 | 0.15 | 23 | 20 | 1.70 | 3.70 | 0.30 | 32.00 | 50.00 | 4.00 |
| 4.009 | GT104.2026.020.07.30.L | 3.00 | 0.20 | 23 | 20 | 1.95 | 2.60 | 0.20 | 7.00 | 25.00 | 4.00 |
| 4.010 | GT104.2026.020.12.30.L | 3.00 | 0.20 | 23 | 20 | 1.95 | 2.60 | 0.20 | 12.00 | 30.00 | 4.00 |
| 4.011 | GT104.2026.020.17.30.L | 3.00 | 0.20 | 23 | 20 | 1.95 | 2.60 | 0.20 | 17.00 | 35.00 | 4.00 |
| 4.012 | GT104.2026.020.22.30.L | 3.00 | 0.20 | 23 | 20 | 1.95 | 2.60 | 0.20 | 22.00 | 40.00 | 4.00 |
| 4.023 | GT104.2037.025.12.40.L | 4.00 | 0.25 | 23 | 20 | 1.70 | 3.70 | 0.30 | 12.00 | 30.00 | 4.00 |
| 4.024 | GT104.2037.025.17.40.L | 4.00 | 0.25 | 23 | 20 | 1.70 | 3.70 | 0.30 | 17.00 | 35.00 | 4.00 |
| 4.025 | GT104.2037.025.22.40.L | 4.00 | 0.25 | 23 | 20 | 1.70 | 3.70 | 0.30 | 22.00 | 40.00 | 4.00 |
| 4.026 | GT104.2037.025.27.40.L | 4.00 | 0.25 | 23 | 20 | 1.70 | 3.70 | 0.30 | 27.00 | 45.00 | 4.00 |
| 4.027 | GT104.2037.025.32.40.L | 4.00 | 0.25 | 23 | 20 | 1.70 | 3.70 | 0.30 | 32.00 | 50.00 | 4.00 |



Cutting insert for boring out and profiling

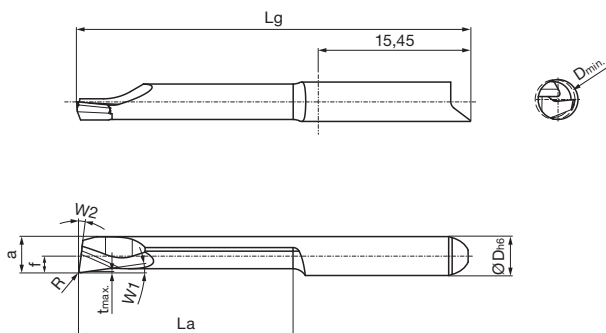


• radial free 8°

for tool holders type GH104/GB104 see from page 16

GUHRING NAVIGATOR

Cutting data page 184



Right hand version shown
Left hand version mirror image



Article no. **25082** **25084** **25088**

Cutting direction

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 4.001 | GT104.0827.005.07.30.R | 3.00 | 0.05 | 8 | 8 | 1.95 | 2.70 | 0.15 | 7.00 | 25.00 | 4.00 |
| 4.002 | GT104.0827.005.12.30.R | 3.00 | 0.05 | 8 | 8 | 1.95 | 2.70 | 0.15 | 12.00 | 30.00 | 4.00 |
| 4.013 | GT104.0837.005.12.40.R | 4.00 | 0.05 | 8 | 8 | 1.70 | 3.70 | 0.15 | 12.00 | 30.00 | 4.00 |
| 4.003 | GT104.0827.005.17.30.R | 3.00 | 0.05 | 8 | 8 | 1.95 | 2.70 | 0.15 | 17.00 | 35.00 | 4.00 |
| 4.014 | GT104.0837.005.17.40.R | 4.00 | 0.05 | 8 | 8 | 1.70 | 3.70 | 0.15 | 17.00 | 35.00 | 4.00 |
| 4.004 | GT104.0827.005.22.30.R | 3.00 | 0.05 | 8 | 8 | 1.95 | 2.70 | 0.15 | 22.00 | 40.00 | 4.00 |
| 4.015 | GT104.0837.005.22.40.R | 4.00 | 0.05 | 8 | 8 | 1.70 | 3.70 | 0.15 | 22.00 | 40.00 | 4.00 |
| 4.016 | GT104.0837.005.27.40.R | 4.00 | 0.05 | 8 | 8 | 1.70 | 3.70 | 0.15 | 27.00 | 45.00 | 4.00 |
| 4.017 | GT104.0837.005.32.40.R | 4.00 | 0.05 | 8 | 8 | 1.70 | 3.70 | 0.15 | 32.00 | 50.00 | 4.00 |
| 4.005 | GT104.0827.010.07.30.R | 3.00 | 0.10 | 8 | 8 | 1.95 | 2.70 | 0.15 | 7.00 | 25.00 | 4.00 |
| 4.006 | GT104.0827.010.12.30.R | 3.00 | 0.10 | 8 | 8 | 1.95 | 2.70 | 0.15 | 12.00 | 30.00 | 4.00 |
| 4.007 | GT104.0827.010.17.30.R | 3.00 | 0.10 | 8 | 8 | 1.95 | 2.70 | 0.15 | 17.00 | 35.00 | 4.00 |
| 4.008 | GT104.0827.010.22.30.R | 3.00 | 0.10 | 8 | 8 | 1.95 | 2.70 | 0.15 | 22.00 | 40.00 | 4.00 |
| 4.018 | GT104.0837.015.12.40.R | 4.00 | 0.15 | 8 | 8 | 1.70 | 3.70 | 0.15 | 12.00 | 30.00 | 4.00 |
| 4.019 | GT104.0837.015.17.40.R | 4.00 | 0.15 | 8 | 8 | 1.70 | 3.70 | 0.15 | 17.00 | 35.00 | 4.00 |
| 4.020 | GT104.0837.015.22.40.R | 4.00 | 0.15 | 8 | 8 | 1.70 | 3.70 | 0.15 | 22.00 | 40.00 | 4.00 |
| 4.021 | GT104.0837.015.27.40.R | 4.00 | 0.15 | 8 | 8 | 1.70 | 3.70 | 0.15 | 27.00 | 45.00 | 4.00 |
| 4.022 | GT104.0837.015.32.40.R | 4.00 | 0.15 | 8 | 8 | 1.70 | 3.70 | 0.15 | 32.00 | 50.00 | 4.00 |
| 4.009 | GT104.0827.020.07.30.R | 3.00 | 0.20 | 8 | 8 | 1.95 | 2.70 | 0.15 | 7.00 | 25.00 | 4.00 |
| 4.010 | GT104.0827.020.12.30.R | 3.00 | 0.20 | 8 | 8 | 1.95 | 2.70 | 0.15 | 12.00 | 30.00 | 4.00 |
| 4.011 | GT104.0827.020.17.30.R | 3.00 | 0.20 | 8 | 8 | 1.95 | 2.70 | 0.15 | 17.00 | 35.00 | 4.00 |
| 4.012 | GT104.0827.020.22.30.R | 3.00 | 0.20 | 8 | 8 | 1.95 | 2.70 | 0.15 | 22.00 | 40.00 | 4.00 |
| 4.023 | GT104.0837.025.12.40.R | 4.00 | 0.25 | 8 | 8 | 1.70 | 3.70 | 0.15 | 12.00 | 30.00 | 4.00 |
| 4.024 | GT104.0837.025.17.40.R | 4.00 | 0.25 | 8 | 8 | 1.70 | 3.70 | 0.15 | 17.00 | 35.00 | 4.00 |
| 4.025 | GT104.0837.025.22.40.R | 4.00 | 0.25 | 8 | 8 | 1.70 | 3.70 | 0.15 | 22.00 | 40.00 | 4.00 |
| 4.026 | GT104.0837.025.27.40.R | 4.00 | 0.25 | 8 | 8 | 1.70 | 3.70 | 0.15 | 27.00 | 45.00 | 4.00 |
| 4.027 | GT104.0837.025.32.40.R | 4.00 | 0.25 | 8 | 8 | 1.70 | 3.70 | 0.15 | 32.00 | 50.00 | 4.00 |

Article no. **25083** **25085** **25089**

Cutting direction

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 4.001 | GT104.0827.005.07.30.L | 3.00 | 0.05 | 8 | 8 | 1.95 | 2.70 | 0.15 | 7.00 | 25.00 | 4.00 |
| 4.002 | GT104.0827.005.12.30.L | 3.00 | 0.05 | 8 | 8 | 1.95 | 2.70 | 0.15 | 12.00 | 30.00 | 4.00 |
| 4.013 | GT104.0837.005.12.40.L | 4.00 | 0.05 | 8 | 8 | 1.70 | 3.70 | 0.15 | 12.00 | 30.00 | 4.00 |
| 4.003 | GT104.0827.005.17.30.L | 3.00 | 0.05 | 8 | 8 | 1.95 | 2.70 | 0.15 | 17.00 | 35.00 | 4.00 |
| 4.014 | GT104.0837.005.17.40.L | 4.00 | 0.05 | 8 | 8 | 1.70 | 3.70 | 0.15 | 17.00 | 35.00 | 4.00 |
| 4.004 | GT104.0827.005.22.30.L | 3.00 | 0.05 | 8 | 8 | 1.95 | 2.70 | 0.15 | 22.00 | 40.00 | 4.00 |



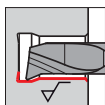
Article no. **25083** **25085** **25089**

Cutting direction

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 4.015 | GT104.0837.005.22.40.L | 4.00 | 0.05 | 8 | 8 | 1.70 | 3.70 | 0.15 | 22.00 | 40.00 | 4.00 |
| 4.016 | GT104.0837.005.27.40.L | 4.00 | 0.05 | 8 | 8 | 1.70 | 3.70 | 0.15 | 27.00 | 45.00 | 4.00 |
| 4.017 | GT104.0837.005.32.40.L | 4.00 | 0.05 | 8 | 8 | 1.70 | 3.70 | 0.15 | 32.00 | 50.00 | 4.00 |
| 4.005 | GT104.0827.010.07.30.L | 3.00 | 0.10 | 8 | 8 | 1.95 | 2.70 | 0.15 | 7.00 | 25.00 | 4.00 |
| 4.006 | GT104.0827.010.12.30.L | 3.00 | 0.10 | 8 | 8 | 1.95 | 2.70 | 0.15 | 12.00 | 30.00 | 4.00 |
| 4.007 | GT104.0827.010.17.30.L | 3.00 | 0.10 | 8 | 8 | 1.95 | 2.70 | 0.15 | 17.00 | 35.00 | 4.00 |
| 4.008 | GT104.0827.010.22.30.L | 3.00 | 0.10 | 8 | 8 | 1.95 | 2.70 | 0.15 | 22.00 | 40.00 | 4.00 |
| 4.018 | GT104.0837.015.12.40.L | 4.00 | 0.15 | 8 | 8 | 1.70 | 3.70 | 0.15 | 12.00 | 30.00 | 4.00 |
| 4.019 | GT104.0837.015.17.40.L | 4.00 | 0.15 | 8 | 8 | 1.70 | 3.70 | 0.15 | 17.00 | 35.00 | 4.00 |
| 4.020 | GT104.0837.015.22.40.L | 4.00 | 0.15 | 8 | 8 | 1.70 | 3.70 | 0.15 | 22.00 | 40.00 | 4.00 |
| 4.021 | GT104.0837.015.27.40.L | 4.00 | 0.15 | 8 | 8 | 1.70 | 3.70 | 0.15 | 27.00 | 45.00 | 4.00 |
| 4.022 | GT104.0837.015.32.40.L | 4.00 | 0.15 | 8 | 8 | 1.70 | 3.70 | 0.15 | 32.00 | 50.00 | 4.00 |
| 4.009 | GT104.0827.020.07.30.L | 3.00 | 0.20 | 8 | 8 | 1.95 | 2.70 | 0.15 | 7.00 | 25.00 | 4.00 |
| 4.010 | GT104.0827.020.12.30.L | 3.00 | 0.20 | 8 | 8 | 1.95 | 2.70 | 0.15 | 12.00 | 30.00 | 4.00 |
| 4.011 | GT104.0827.020.17.30.L | 3.00 | 0.20 | 8 | 8 | 1.95 | 2.70 | 0.15 | 17.00 | 35.00 | 4.00 |
| 4.012 | GT104.0827.020.22.30.L | 3.00 | 0.20 | 8 | 8 | 1.95 | 2.70 | 0.15 | 22.00 | 40.00 | 4.00 |
| 4.023 | GT104.0837.025.12.40.L | 4.00 | 0.25 | 8 | 8 | 1.70 | 3.70 | 0.15 | 12.00 | 30.00 | 4.00 |
| 4.024 | GT104.0837.025.17.40.L | 4.00 | 0.25 | 8 | 8 | 1.70 | 3.70 | 0.15 | 17.00 | 35.00 | 4.00 |
| 4.025 | GT104.0837.025.22.40.L | 4.00 | 0.25 | 8 | 8 | 1.70 | 3.70 | 0.15 | 22.00 | 40.00 | 4.00 |
| 4.026 | GT104.0837.025.27.40.L | 4.00 | 0.25 | 8 | 8 | 1.70 | 3.70 | 0.15 | 27.00 | 45.00 | 4.00 |
| 4.027 | GT104.0837.025.32.40.L | 4.00 | 0.25 | 8 | 8 | 1.70 | 3.70 | 0.15 | 32.00 | 50.00 | 4.00 |



Cutting insert for boring out and profiling



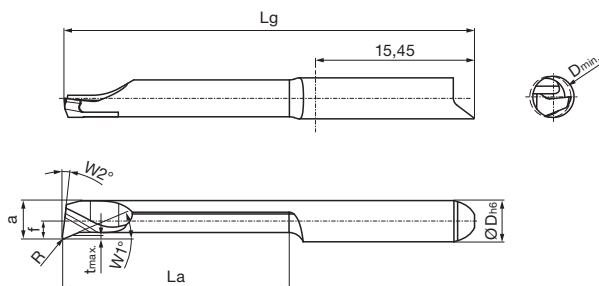
• WIPER-geometry

for tool holders type GH104/GB104 see from page 16

GUHRING NAVIGATOR

Cutting data page 184

| Tool material | Solid carbide | | |
|---------------|---------------|----------------------|----------|
| Type | GJ 104 | GJ 104 | GJ 104 |
| Surface | S TiN | a TiAlN-nanoA | ○ bright |



Right hand version shown
Left hand version mirror image



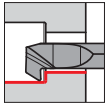
| Article no. | 25090 | 25092 | 25096 |
|-------------------|------------|------------|------------|
| Cutting direction | (R) | (R) | (R) |

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 4.001 | GJ104.2319.010.04.20.R | 2.00 | 0.10 | 23 | 8 | 1.95 | 1.90 | 0.15 | 4.00 | 25.00 | 4.00 |
| 4.002 | GJ104.2319.010.07.20.R | 2.00 | 0.10 | 23 | 8 | 1.95 | 1.90 | 0.15 | 7.00 | 25.00 | 4.00 |
| 4.003 | GJ104.2319.010.12.20.R | 2.00 | 0.10 | 23 | 8 | 1.95 | 1.90 | 0.15 | 12.00 | 30.00 | 4.00 |
| 4.004 | GJ104.2319.010.17.20.R | 2.00 | 0.10 | 23 | 8 | 1.95 | 1.90 | 0.15 | 17.00 | 35.00 | 4.00 |
| 4.005 | GJ104.2326.015.07.30.R | 3.00 | 0.15 | 23 | 8 | 1.95 | 2.60 | 0.20 | 7.00 | 25.00 | 4.00 |
| 4.006 | GJ104.2326.015.12.30.R | 3.00 | 0.15 | 23 | 8 | 1.95 | 2.60 | 0.20 | 12.00 | 30.00 | 4.00 |
| 4.007 | GJ104.2326.015.17.30.R | 3.00 | 0.15 | 23 | 8 | 1.95 | 2.60 | 0.20 | 17.00 | 35.00 | 4.00 |
| 4.008 | GJ104.2326.015.22.30.R | 3.00 | 0.15 | 23 | 8 | 1.95 | 2.60 | 0.20 | 22.00 | 40.00 | 4.00 |
| 4.009 | GJ104.2337.020.12.40.R | 4.00 | 0.20 | 23 | 8 | 1.70 | 3.70 | 0.30 | 12.00 | 30.00 | 4.00 |
| 4.010 | GJ104.2337.020.17.40.R | 4.00 | 0.20 | 23 | 8 | 1.70 | 3.70 | 0.30 | 17.00 | 35.00 | 4.00 |
| 4.011 | GJ104.2337.020.22.40.R | 4.00 | 0.20 | 23 | 8 | 1.70 | 3.70 | 0.30 | 22.00 | 40.00 | 4.00 |
| 4.012 | GJ104.2337.020.27.40.R | 4.00 | 0.20 | 23 | 8 | 1.70 | 3.70 | 0.30 | 27.00 | 45.00 | 4.00 |
| 4.013 | GJ104.2337.020.32.40.R | 4.00 | 0.20 | 23 | 8 | 1.70 | 3.70 | 0.30 | 32.00 | 50.00 | 4.00 |

| Article no. | 25091 | 25093 | 25097 |
|-------------------|------------|------------|------------|
| Cutting direction | (L) | (L) | (L) |

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 4.001 | GJ104.2319.010.04.20.L | 2.00 | 0.10 | 23 | 8 | 1.95 | 1.90 | 0.15 | 4.00 | 25.00 | 4.00 |
| 4.002 | GJ104.2319.010.07.20.L | 2.00 | 0.10 | 23 | 8 | 1.95 | 1.90 | 0.15 | 7.00 | 25.00 | 4.00 |
| 4.003 | GJ104.2319.010.12.20.L | 2.00 | 0.10 | 23 | 8 | 1.95 | 1.90 | 0.15 | 12.00 | 30.00 | 4.00 |
| 4.004 | GJ104.2319.010.17.20.L | 2.00 | 0.10 | 23 | 8 | 1.95 | 1.90 | 0.15 | 17.00 | 35.00 | 4.00 |
| 4.005 | GJ104.2326.015.07.30.L | 3.00 | 0.15 | 23 | 8 | 1.95 | 2.60 | 0.20 | 7.00 | 25.00 | 4.00 |
| 4.006 | GJ104.2326.015.12.30.L | 3.00 | 0.15 | 23 | 8 | 1.95 | 2.60 | 0.20 | 12.00 | 30.00 | 4.00 |
| 4.007 | GJ104.2326.015.17.30.L | 3.00 | 0.15 | 23 | 8 | 1.95 | 2.60 | 0.20 | 17.00 | 35.00 | 4.00 |
| 4.008 | GJ104.2326.015.22.30.L | 3.00 | 0.15 | 23 | 8 | 1.95 | 2.60 | 0.20 | 22.00 | 40.00 | 4.00 |
| 4.009 | GJ104.2337.020.12.40.L | 4.00 | 0.20 | 23 | 8 | 1.70 | 3.70 | 0.30 | 12.00 | 30.00 | 4.00 |
| 4.010 | GJ104.2337.020.17.40.L | 4.00 | 0.20 | 23 | 8 | 1.70 | 3.70 | 0.30 | 17.00 | 35.00 | 4.00 |
| 4.011 | GJ104.2337.020.22.40.L | 4.00 | 0.20 | 23 | 8 | 1.70 | 3.70 | 0.30 | 22.00 | 40.00 | 4.00 |
| 4.012 | GJ104.2337.020.27.40.L | 4.00 | 0.20 | 23 | 8 | 1.70 | 3.70 | 0.30 | 27.00 | 45.00 | 4.00 |
| 4.013 | GJ104.2337.020.32.40.L | 4.00 | 0.20 | 23 | 8 | 1.70 | 3.70 | 0.30 | 32.00 | 50.00 | 4.00 |

Cutting insert for back boring and profiling

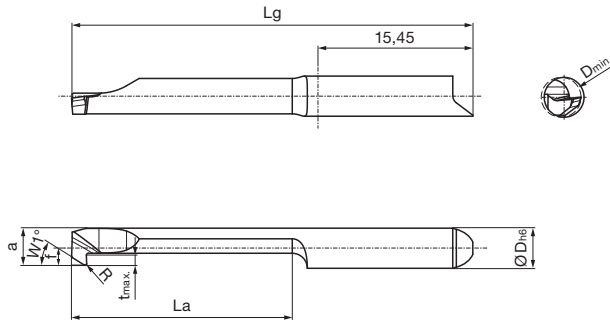


• radial free 32°

for tool holders type GH104/GB104 see from page 16

GUHRING NAVIGATOR

Cutting data page 184



Right hand version shown
Left hand version mirror image



Article no. **25106** **25108** **25112**

Cutting direction

| Code no. | Description | D min | R | W1 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | mm | mm | mm | mm | mm | mm |
| 4.001 | GT104.3217.010.04.20.R | 2.00 | 0.10 | 32 | 1.95 | 1.70 | 0.30 | 4.00 | 25.00 | 4.00 |
| 4.002 | GT104.3217.010.07.20.R | 2.00 | 0.10 | 32 | 1.95 | 1.70 | 0.30 | 7.00 | 25.00 | 4.00 |
| 4.003 | GT104.3217.010.12.20.R | 2.00 | 0.10 | 32 | 1.95 | 1.70 | 0.30 | 12.00 | 30.00 | 4.00 |
| 4.004 | GT104.3217.010.17.20.R | 2.00 | 0.10 | 32 | 1.95 | 1.70 | 0.70 | 17.00 | 35.00 | 4.00 |
| 4.005 | GT104.3226.005.07.30.R | 3.00 | 0.05 | 32 | 1.95 | 2.60 | 0.70 | 7.00 | 25.00 | 4.00 |
| 4.006 | GT104.3226.005.12.30.R | 3.00 | 0.05 | 32 | 1.95 | 2.60 | 0.70 | 12.00 | 30.00 | 4.00 |
| 4.007 | GT104.3226.005.17.30.R | 3.00 | 0.05 | 32 | 1.95 | 2.60 | 0.70 | 17.00 | 35.00 | 4.00 |
| 4.008 | GT104.3226.005.22.30.R | 3.00 | 0.05 | 32 | 1.95 | 2.60 | 0.70 | 22.00 | 40.00 | 4.00 |
| 4.009 | GT104.3226.010.07.30.R | 3.00 | 0.10 | 32 | 1.95 | 2.60 | 0.70 | 7.00 | 25.00 | 4.00 |
| 4.010 | GT104.3226.010.12.30.R | 3.00 | 0.10 | 32 | 1.95 | 2.60 | 0.70 | 12.00 | 30.00 | 4.00 |
| 4.011 | GT104.3226.010.17.30.R | 3.00 | 0.10 | 32 | 1.95 | 2.60 | 0.70 | 17.00 | 35.00 | 4.00 |
| 4.012 | GT104.3226.010.22.30.R | 3.00 | 0.10 | 32 | 1.95 | 2.60 | 0.70 | 22.00 | 40.00 | 4.00 |
| 4.013 | GT104.3237.010.12.40.R | 4.00 | 0.10 | 32 | 1.70 | 3.70 | 1.00 | 12.00 | 30.00 | 4.00 |
| 4.014 | GT104.3237.010.17.40.R | 4.00 | 0.10 | 32 | 1.70 | 3.70 | 1.00 | 17.00 | 35.00 | 4.00 |
| 4.015 | GT104.3237.010.22.40.R | 4.00 | 0.10 | 32 | 1.70 | 3.70 | 1.00 | 22.00 | 40.00 | 4.00 |
| 4.016 | GT104.3237.010.27.40.R | 4.00 | 0.10 | 32 | 1.70 | 3.70 | 1.00 | 27.00 | 45.00 | 4.00 |
| 4.017 | GT104.3237.010.32.40.R | 4.00 | 0.10 | 32 | 1.70 | 3.70 | 1.00 | 32.00 | 50.00 | 4.00 |
| 4.018 | GT104.3237.015.12.40.R | 4.00 | 0.15 | 32 | 1.70 | 3.70 | 1.00 | 12.00 | 30.00 | 4.00 |
| 4.019 | GT104.3237.015.17.40.R | 4.00 | 0.15 | 32 | 1.70 | 3.70 | 1.00 | 17.00 | 35.00 | 4.00 |
| 4.020 | GT104.3237.015.22.40.R | 4.00 | 0.15 | 32 | 1.70 | 3.70 | 1.00 | 22.00 | 40.00 | 4.00 |
| 4.021 | GT104.3237.015.27.40.R | 4.00 | 0.15 | 32 | 1.70 | 3.70 | 1.00 | 27.00 | 45.00 | 4.00 |
| 4.022 | GT104.3237.015.32.40.R | 4.00 | 0.15 | 32 | 1.70 | 3.70 | 1.00 | 32.00 | 50.00 | 4.00 |

Article no. **25107** **25109** **25113**

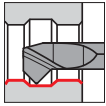
Cutting direction

| Code no. | Description | D min | R | W1 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | mm | mm | mm | mm | mm | mm |
| 4.001 | GT104.3217.010.04.20.L | 2.00 | 0.10 | 32 | 1.95 | 1.70 | 0.30 | 4.00 | 25.00 | 4.00 |
| 4.002 | GT104.3217.010.07.20.L | 2.00 | 0.10 | 32 | 1.95 | 1.70 | 0.30 | 7.00 | 25.00 | 4.00 |
| 4.003 | GT104.3217.010.12.20.L | 2.00 | 0.10 | 32 | 1.95 | 1.70 | 0.30 | 12.00 | 30.00 | 4.00 |
| 4.004 | GT104.3217.010.17.20.L | 2.00 | 0.10 | 32 | 1.95 | 1.70 | 0.70 | 17.00 | 35.00 | 4.00 |
| 4.005 | GT104.3226.005.07.30.L | 3.00 | 0.05 | 32 | 1.95 | 2.60 | 0.70 | 7.00 | 25.00 | 4.00 |
| 4.006 | GT104.3226.005.12.30.L | 3.00 | 0.05 | 32 | 1.95 | 2.60 | 0.70 | 12.00 | 30.00 | 4.00 |
| 4.007 | GT104.3226.005.17.30.L | 3.00 | 0.05 | 32 | 1.95 | 2.60 | 0.70 | 17.00 | 35.00 | 4.00 |
| 4.008 | GT104.3226.005.22.30.L | 3.00 | 0.05 | 32 | 1.95 | 2.60 | 0.70 | 22.00 | 40.00 | 4.00 |
| 4.009 | GT104.3226.010.07.30.L | 3.00 | 0.10 | 32 | 1.95 | 2.60 | 0.70 | 7.00 | 25.00 | 4.00 |
| 4.010 | GT104.3226.010.12.30.L | 3.00 | 0.10 | 32 | 1.95 | 2.60 | 0.70 | 12.00 | 30.00 | 4.00 |
| 4.011 | GT104.3226.010.17.30.L | 3.00 | 0.10 | 32 | 1.95 | 2.60 | 0.70 | 17.00 | 35.00 | 4.00 |
| 4.012 | GT104.3226.010.22.30.L | 3.00 | 0.10 | 32 | 1.95 | 2.60 | 0.70 | 22.00 | 40.00 | 4.00 |

Article no. **25107** **25109** **25113**Cutting direction   

| Code no. | Description | D min | R | W1 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | mm | mm | mm | mm | mm | mm |
| 4.013 | GT104.3237.010.12.40.L | 4.00 | 0.10 | 32 | 1.70 | 3.70 | 1.00 | 12.00 | 30.00 | 4.00 |
| 4.014 | GT104.3237.010.17.40.L | 4.00 | 0.10 | 32 | 1.70 | 3.70 | 1.00 | 17.00 | 35.00 | 4.00 |
| 4.015 | GT104.3237.010.22.40.L | 4.00 | 0.10 | 32 | 1.70 | 3.70 | 1.00 | 22.00 | 40.00 | 4.00 |
| 4.016 | GT104.3237.010.27.40.L | 4.00 | 0.10 | 32 | 1.70 | 3.70 | 1.00 | 27.00 | 45.00 | 4.00 |
| 4.017 | GT104.3237.010.32.40.L | 4.00 | 0.10 | 32 | 1.70 | 3.70 | 1.00 | 32.00 | 50.00 | 4.00 |
| 4.018 | GT104.3237.015.12.40.L | 4.00 | 0.15 | 32 | 1.70 | 3.70 | 1.00 | 12.00 | 30.00 | 4.00 |
| 4.019 | GT104.3237.015.17.40.L | 4.00 | 0.15 | 32 | 1.70 | 3.70 | 1.00 | 17.00 | 35.00 | 4.00 |
| 4.020 | GT104.3237.015.22.40.L | 4.00 | 0.15 | 32 | 1.70 | 3.70 | 1.00 | 22.00 | 40.00 | 4.00 |
| 4.021 | GT104.3237.015.27.40.L | 4.00 | 0.15 | 32 | 1.70 | 3.70 | 1.00 | 27.00 | 45.00 | 4.00 |
| 4.022 | GT104.3237.015.32.40.L | 4.00 | 0.15 | 32 | 1.70 | 3.70 | 1.00 | 32.00 | 50.00 | 4.00 |

Cutting insert for boring out and chamfering

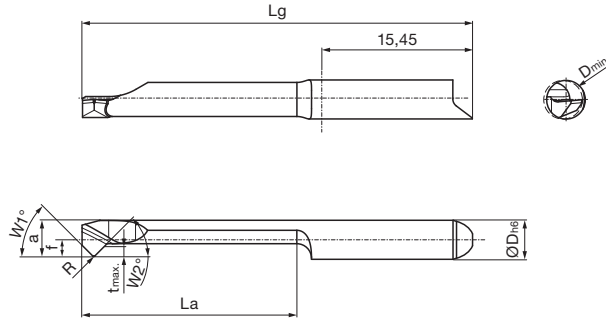


• 45° both sides

for tool holders type GH104/GB104 see from page 16

GUHRING NAVIGATOR

Cutting data page 184



Right hand version shown
Left hand version mirror image



| | | | |
|---------------|---------------|-------------|--------|
| Tool material | Solid carbide | | |
| Type | GT 104 | GT 104 | GT 104 |
| Surface | S | a | ○ |
| | TiN | TiAlN-nanoA | bright |

Article no. **25114** **25116** **25120**

Cutting direction

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 4.001 | GT104.4518.010.04.20.R | 2.00 | 0.10 | 45 | 45 | 1.95 | 1.80 | 0.50 | 4.00 | 25.00 | 4.00 |
| 4.002 | GT104.4518.010.07.20.R | 2.00 | 0.10 | 45 | 45 | 1.95 | 1.80 | 0.50 | 7.00 | 25.00 | 4.00 |
| 4.005 | GT104.4527.010.07.30.R | 3.00 | 0.10 | 45 | 45 | 1.95 | 2.70 | 0.70 | 7.00 | 25.00 | 4.00 |
| 4.003 | GT104.4518.010.12.20.R | 2.00 | 0.10 | 45 | 45 | 1.95 | 1.80 | 0.50 | 12.00 | 30.00 | 4.00 |
| 4.006 | GT104.4527.010.12.30.R | 3.00 | 0.10 | 45 | 45 | 1.95 | 2.70 | 0.70 | 12.00 | 30.00 | 4.00 |
| 4.004 | GT104.4518.010.17.20.R | 2.00 | 0.10 | 45 | 45 | 1.95 | 1.80 | 0.50 | 17.00 | 35.00 | 4.00 |
| 4.007 | GT104.4527.010.17.30.R | 3.00 | 0.10 | 45 | 45 | 1.95 | 2.70 | 0.70 | 17.00 | 35.00 | 4.00 |
| 4.008 | GT104.4527.010.22.30.R | 3.00 | 0.10 | 45 | 45 | 1.95 | 2.70 | 0.70 | 22.00 | 40.00 | 4.00 |
| 4.009 | GT104.4537.015.12.40.R | 4.00 | 0.15 | 45 | 45 | 1.70 | 3.70 | 1.00 | 12.00 | 30.00 | 4.00 |
| 4.010 | GT104.4537.015.17.40.R | 4.00 | 0.15 | 45 | 45 | 1.70 | 3.70 | 1.00 | 17.00 | 35.00 | 4.00 |
| 4.011 | GT104.4537.015.22.40.R | 4.00 | 0.15 | 45 | 45 | 1.70 | 3.70 | 1.00 | 22.00 | 40.00 | 4.00 |
| 4.012 | GT104.4537.015.27.40.R | 4.00 | 0.15 | 45 | 45 | 1.70 | 3.70 | 1.00 | 27.00 | 45.00 | 4.00 |
| 4.013 | GT104.4537.015.32.40.R | 4.00 | 0.15 | 45 | 45 | 1.70 | 3.70 | 1.00 | 32.00 | 50.00 | 4.00 |

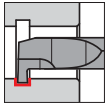
Article no. **25115** **25117** **25121**

Cutting direction

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 4.001 | GT104.4518.010.04.20.L | 2.00 | 0.10 | 45 | 45 | 1.95 | 1.80 | 0.50 | 4.00 | 25.00 | 4.00 |
| 4.002 | GT104.4518.010.07.20.L | 2.00 | 0.10 | 45 | 45 | 1.95 | 1.80 | 0.50 | 7.00 | 25.00 | 4.00 |
| 4.005 | GT104.4527.010.07.30.L | 3.00 | 0.10 | 45 | 45 | 1.95 | 2.70 | 0.70 | 7.00 | 25.00 | 4.00 |
| 4.003 | GT104.4518.010.12.20.L | 2.00 | 0.10 | 45 | 45 | 1.95 | 1.80 | 0.50 | 12.00 | 30.00 | 4.00 |
| 4.006 | GT104.4527.010.12.30.L | 3.00 | 0.10 | 45 | 45 | 1.95 | 2.70 | 0.70 | 12.00 | 30.00 | 4.00 |
| 4.004 | GT104.4518.010.17.20.L | 2.00 | 0.10 | 45 | 45 | 1.95 | 1.80 | 0.50 | 17.00 | 35.00 | 4.00 |
| 4.007 | GT104.4527.010.17.30.L | 3.00 | 0.10 | 45 | 45 | 1.95 | 2.70 | 0.70 | 17.00 | 35.00 | 4.00 |
| 4.008 | GT104.4527.010.22.30.L | 3.00 | 0.10 | 45 | 45 | 1.95 | 2.70 | 0.70 | 22.00 | 40.00 | 4.00 |
| 4.009 | GT104.4537.015.12.40.L | 4.00 | 0.15 | 45 | 45 | 1.70 | 3.70 | 1.00 | 12.00 | 30.00 | 4.00 |
| 4.010 | GT104.4537.015.17.40.L | 4.00 | 0.15 | 45 | 45 | 1.70 | 3.70 | 1.00 | 17.00 | 35.00 | 4.00 |
| 4.011 | GT104.4537.015.22.40.L | 4.00 | 0.15 | 45 | 45 | 1.70 | 3.70 | 1.00 | 22.00 | 40.00 | 4.00 |
| 4.012 | GT104.4537.015.27.40.L | 4.00 | 0.15 | 45 | 45 | 1.70 | 3.70 | 1.00 | 27.00 | 45.00 | 4.00 |
| 4.013 | GT104.4537.015.32.40.L | 4.00 | 0.15 | 45 | 45 | 1.70 | 3.70 | 1.00 | 32.00 | 50.00 | 4.00 |



Cutting insert for internal grooving, straight slots



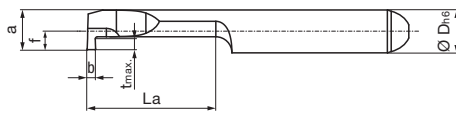
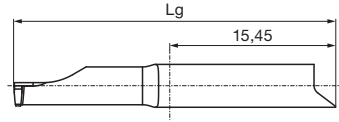
- grooving depth up to 1 mm

for tool holders type GH104/GB104 see from page 16

GUHRING NAVIGATOR

Cutting data page 184

| Tool material | Solid carbide | | |
|---------------|---------------|-------------|--------|
| | GE 104 | GE 104 | GE 104 |
| Type | | | |
| Surface | S | a | ○ |
| | TiN | TiAlN-nanoA | bright |



Right hand version shown
Left hand version mirror image



Article no. **25124** **25126** **25130**

Cutting direction **(R)** **(R)** **(R)**

| Code no. | Description | D min | b | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm |
| 4.001 | GE104.0030.000.04.10.R | 1.00 | 0.30 | 1.95 | 0.85 | 0.20 | 4.00 | 25.00 | 4.00 |
| 4.002 | GE104.0030.000.07.10.R | 1.00 | 0.30 | 1.95 | 0.85 | 0.20 | 7.00 | 25.00 | 4.00 |
| 4.003 | GE104.0040.000.04.15.R | 1.50 | 0.40 | 1.95 | 1.30 | 0.40 | 4.00 | 25.00 | 4.00 |
| 4.004 | GE104.0040.000.07.15.R | 1.50 | 0.40 | 1.95 | 1.30 | 0.40 | 7.00 | 25.00 | 4.00 |
| 4.005 | GE104.0040.000.12.15.R | 1.50 | 0.40 | 1.95 | 1.30 | 0.40 | 12.00 | 30.00 | 4.00 |
| 4.006 | GE104.0050.000.04.20.R | 2.00 | 0.50 | 1.95 | 1.80 | 0.50 | 4.00 | 25.00 | 4.00 |
| 4.007 | GE104.0050.000.07.20.R | 2.00 | 0.50 | 1.95 | 1.80 | 0.50 | 7.00 | 25.00 | 4.00 |
| 4.008 | GE104.0050.000.12.20.R | 2.00 | 0.50 | 1.95 | 1.80 | 0.50 | 12.00 | 30.00 | 4.00 |
| 4.009 | GE104.0050.000.17.20.R | 2.00 | 0.50 | 1.95 | 1.80 | 0.50 | 17.00 | 35.00 | 4.00 |
| 4.010 | GE104.0070.000.07.30.R | 3.00 | 0.70 | 1.95 | 2.70 | 0.70 | 7.00 | 25.00 | 4.00 |
| 4.011 | GE104.0070.000.12.30.R | 3.00 | 0.70 | 1.95 | 2.70 | 0.70 | 12.00 | 30.00 | 4.00 |
| 4.012 | GE104.0070.000.17.30.R | 3.00 | 0.70 | 1.95 | 2.70 | 0.70 | 17.00 | 35.00 | 4.00 |
| 4.013 | GE104.0070.000.22.30.R | 3.00 | 0.70 | 1.95 | 2.70 | 0.70 | 22.00 | 40.00 | 4.00 |
| 4.014 | GE104.0079.000.12.40.R | 4.00 | 0.79 | 1.70 | 3.70 | 1.00 | 12.00 | 30.00 | 4.00 |
| 4.015 | GE104.0079.000.17.40.R | 4.00 | 0.79 | 1.70 | 3.70 | 1.00 | 17.00 | 35.00 | 4.00 |
| 4.016 | GE104.0079.000.22.40.R | 4.00 | 0.79 | 1.70 | 3.70 | 1.00 | 22.00 | 40.00 | 4.00 |
| 4.017 | GE104.0079.000.27.40.R | 4.00 | 0.79 | 1.70 | 3.70 | 1.00 | 27.00 | 45.00 | 4.00 |
| 4.018 | GE104.0079.000.32.40.R | 4.00 | 0.79 | 1.70 | 3.70 | 1.00 | 32.00 | 50.00 | 4.00 |
| 4.019 | GE104.0100.000.12.40.R | 4.00 | 1.00 | 1.70 | 3.70 | 1.00 | 12.00 | 30.00 | 4.00 |
| 4.020 | GE104.0100.000.17.40.R | 4.00 | 1.00 | 1.70 | 3.70 | 1.00 | 17.00 | 35.00 | 4.00 |
| 4.021 | GE104.0100.000.22.40.R | 4.00 | 1.00 | 1.70 | 3.70 | 1.00 | 22.00 | 40.00 | 4.00 |
| 4.022 | GE104.0100.000.27.40.R | 4.00 | 1.00 | 1.70 | 3.70 | 1.00 | 27.00 | 45.00 | 4.00 |
| 4.023 | GE104.0100.000.32.40.R | 4.00 | 1.00 | 1.70 | 3.70 | 1.00 | 32.00 | 50.00 | 4.00 |
| 4.024 | GE104.0150.000.12.40.R | 4.00 | 1.50 | 1.70 | 3.70 | 1.00 | 12.00 | 30.00 | 4.00 |
| 4.025 | GE104.0150.000.17.40.R | 4.00 | 1.50 | 1.70 | 3.70 | 1.00 | 17.00 | 35.00 | 4.00 |
| 4.026 | GE104.0150.000.22.40.R | 4.00 | 1.50 | 1.70 | 3.70 | 1.00 | 22.00 | 40.00 | 4.00 |
| 4.027 | GE104.0150.000.27.40.R | 4.00 | 1.50 | 1.70 | 3.70 | 1.00 | 27.00 | 45.00 | 4.00 |
| 4.028 | GE104.0150.000.32.40.R | 4.00 | 1.50 | 1.70 | 3.70 | 1.00 | 32.00 | 50.00 | 4.00 |

Article no. **25125** **25127** **25131**

Cutting direction **(L)** **(L)** **(L)**

| Code no. | Description | D min | b | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm |
| 4.001 | GE104.0030.000.04.10.L | 1.00 | 0.30 | 1.95 | 0.85 | 0.20 | 4.00 | 25.00 | 4.00 |
| 4.002 | GE104.0030.000.07.10.L | 1.00 | 0.30 | 1.95 | 0.85 | 0.20 | 7.00 | 25.00 | 4.00 |
| 4.003 | GE104.0040.000.04.15.L | 1.50 | 0.40 | 1.95 | 1.30 | 0.40 | 4.00 | 25.00 | 4.00 |
| 4.004 | GE104.0040.000.07.15.L | 1.50 | 0.40 | 1.95 | 1.30 | 0.40 | 7.00 | 25.00 | 4.00 |
| 4.005 | GE104.0040.000.12.15.L | 1.50 | 0.40 | 1.95 | 1.30 | 0.40 | 12.00 | 30.00 | 4.00 |
| 4.006 | GE104.0050.000.04.20.L | 2.00 | 0.50 | 1.95 | 1.80 | 0.50 | 4.00 | 25.00 | 4.00 |



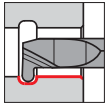
Article no. **25125** **25127** **25131**

Cutting direction   

| Code no. | Description | D min | b | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm |
| 4.007 | GE104.0050.000.07.20.L | 2.00 | 0.50 | 1.95 | 1.80 | 0.50 | 7.00 | 25.00 | 4.00 |
| 4.008 | GE104.0050.000.12.20.L | 2.00 | 0.50 | 1.95 | 1.80 | 0.50 | 12.00 | 30.00 | 4.00 |
| 4.009 | GE104.0050.000.17.20.L | 2.00 | 0.50 | 1.95 | 1.80 | 0.50 | 17.00 | 35.00 | 4.00 |
| 4.010 | GE104.0070.000.07.30.L | 3.00 | 0.70 | 1.95 | 2.70 | 0.70 | 7.00 | 25.00 | 4.00 |
| 4.011 | GE104.0070.000.12.30.L | 3.00 | 0.70 | 1.95 | 2.70 | 0.70 | 12.00 | 30.00 | 4.00 |
| 4.012 | GE104.0070.000.17.30.L | 3.00 | 0.70 | 1.95 | 2.70 | 0.70 | 17.00 | 35.00 | 4.00 |
| 4.013 | GE104.0070.000.22.30.L | 3.00 | 0.70 | 1.95 | 2.70 | 0.70 | 22.00 | 40.00 | 4.00 |
| 4.014 | GE104.0079.000.12.40.L | 4.00 | 0.79 | 1.70 | 3.70 | 1.00 | 12.00 | 30.00 | 4.00 |
| 4.015 | GE104.0079.000.17.40.L | 4.00 | 0.79 | 1.70 | 3.70 | 1.00 | 17.00 | 35.00 | 4.00 |
| 4.016 | GE104.0079.000.22.40.L | 4.00 | 0.79 | 1.70 | 3.70 | 1.00 | 22.00 | 40.00 | 4.00 |
| 4.017 | GE104.0079.000.27.40.L | 4.00 | 0.79 | 1.70 | 3.70 | 1.00 | 27.00 | 45.00 | 4.00 |
| 4.018 | GE104.0079.000.32.40.L | 4.00 | 0.79 | 1.70 | 3.70 | 1.00 | 32.00 | 50.00 | 4.00 |
| 4.019 | GE104.0100.000.12.40.L | 4.00 | 1.00 | 1.70 | 3.70 | 1.00 | 12.00 | 30.00 | 4.00 |
| 4.020 | GE104.0100.000.17.40.L | 4.00 | 1.00 | 1.70 | 3.70 | 1.00 | 17.00 | 35.00 | 4.00 |
| 4.021 | GE104.0100.000.22.40.L | 4.00 | 1.00 | 1.70 | 3.70 | 1.00 | 22.00 | 40.00 | 4.00 |
| 4.022 | GE104.0100.000.27.40.L | 4.00 | 1.00 | 1.70 | 3.70 | 1.00 | 27.00 | 45.00 | 4.00 |
| 4.023 | GE104.0100.000.32.40.L | 4.00 | 1.00 | 1.70 | 3.70 | 1.00 | 32.00 | 50.00 | 4.00 |
| 4.024 | GE104.0150.000.12.40.L | 4.00 | 1.50 | 1.70 | 3.70 | 1.00 | 12.00 | 30.00 | 4.00 |
| 4.025 | GE104.0150.000.17.40.L | 4.00 | 1.50 | 1.70 | 3.70 | 1.00 | 17.00 | 35.00 | 4.00 |
| 4.026 | GE104.0150.000.22.40.L | 4.00 | 1.50 | 1.70 | 3.70 | 1.00 | 22.00 | 40.00 | 4.00 |
| 4.027 | GE104.0150.000.27.40.L | 4.00 | 1.50 | 1.70 | 3.70 | 1.00 | 27.00 | 45.00 | 4.00 |
| 4.028 | GE104.0150.000.32.40.L | 4.00 | 1.50 | 1.70 | 3.70 | 1.00 | 32.00 | 50.00 | 4.00 |



Cutting insert for internal grooving, full radius slots

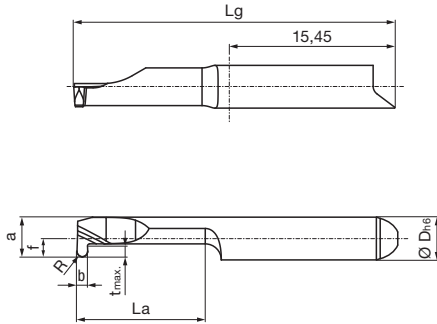


- full radius R0.4-R0.58

for tool holders type GH104/GB104 see from page 16

GUHRING NAVIGATOR

Cutting data page 184



Right hand version shown
Left hand version mirror image

Article no. **25132** **25134** **25138**

Cutting direction

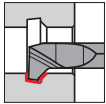
| Code no. | Description | D min | b | R | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm | mm |
| 4.001 | GE104.0080.040.07.30.R | 3.00 | 0.80 | 0.40 | 1.95 | 2.70 | 0.70 | 7.00 | 25.00 | 4.00 |
| 4.002 | GE104.0080.040.12.30.R | 3.00 | 0.80 | 0.40 | 1.95 | 2.70 | 0.70 | 12.00 | 30.00 | 4.00 |
| 4.003 | GE104.0080.040.17.30.R | 3.00 | 0.80 | 0.40 | 1.95 | 2.70 | 0.70 | 17.00 | 35.00 | 4.00 |
| 4.004 | GE104.0080.040.22.30.R | 3.00 | 0.80 | 0.40 | 1.95 | 2.70 | 0.70 | 22.00 | 40.00 | 4.00 |
| 4.005 | GE104.0100.050.12.40.R | 4.00 | 1.00 | 0.50 | 1.70 | 3.70 | 1.00 | 12.00 | 30.00 | 4.00 |
| 4.006 | GE104.0100.050.17.40.R | 4.00 | 1.00 | 0.50 | 1.70 | 3.70 | 1.00 | 17.00 | 35.00 | 4.00 |
| 4.007 | GE104.0100.050.22.40.R | 4.00 | 1.00 | 0.50 | 1.70 | 3.70 | 1.00 | 22.00 | 40.00 | 4.00 |
| 4.008 | GE104.0100.050.27.40.R | 4.00 | 1.00 | 0.50 | 1.70 | 3.70 | 1.00 | 27.00 | 45.00 | 4.00 |
| 4.009 | GE104.0100.050.32.40.R | 4.00 | 1.00 | 0.50 | 1.70 | 3.70 | 1.00 | 32.00 | 50.00 | 4.00 |
| 4.010 | GE104.0117.058.12.40.R | 4.00 | 1.17 | 0.58 | 1.70 | 3.70 | 1.00 | 12.00 | 30.00 | 4.00 |
| 4.011 | GE104.0117.058.17.40.R | 4.00 | 1.17 | 0.58 | 1.70 | 3.70 | 1.00 | 17.00 | 35.00 | 4.00 |
| 4.012 | GE104.0117.058.22.40.R | 4.00 | 1.17 | 0.58 | 1.70 | 3.70 | 1.00 | 22.00 | 40.00 | 4.00 |
| 4.013 | GE104.0117.058.27.40.R | 4.00 | 1.17 | 0.58 | 1.70 | 3.70 | 1.00 | 27.00 | 45.00 | 4.00 |
| 4.014 | GE104.0117.058.32.40.R | 4.00 | 1.17 | 0.58 | 1.70 | 3.70 | 1.00 | 32.00 | 50.00 | 4.00 |

Article no. **25133** **25135** **25139**

Cutting direction

| Code no. | Description | D min | b | R | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm | mm |
| 4.001 | GE104.0080.040.07.30.L | 3.00 | 0.80 | 0.40 | 1.95 | 2.70 | 0.70 | 7.00 | 25.00 | 4.00 |
| 4.002 | GE104.0080.040.12.30.L | 3.00 | 0.80 | 0.40 | 1.95 | 2.70 | 0.70 | 12.00 | 30.00 | 4.00 |
| 4.003 | GE104.0080.040.17.30.L | 3.00 | 0.80 | 0.40 | 1.95 | 2.70 | 0.70 | 17.00 | 35.00 | 4.00 |
| 4.004 | GE104.0080.040.22.30.L | 3.00 | 0.80 | 0.40 | 1.95 | 2.70 | 0.70 | 22.00 | 40.00 | 4.00 |
| 4.005 | GE104.0100.050.12.40.L | 4.00 | 1.00 | 0.50 | 1.70 | 3.70 | 1.00 | 12.00 | 30.00 | 4.00 |
| 4.006 | GE104.0100.050.17.40.L | 4.00 | 1.00 | 0.50 | 1.70 | 3.70 | 1.00 | 17.00 | 35.00 | 4.00 |
| 4.007 | GE104.0100.050.22.40.L | 4.00 | 1.00 | 0.50 | 1.70 | 3.70 | 1.00 | 22.00 | 40.00 | 4.00 |
| 4.008 | GE104.0100.050.27.40.L | 4.00 | 1.00 | 0.50 | 1.70 | 3.70 | 1.00 | 27.00 | 45.00 | 4.00 |
| 4.009 | GE104.0100.050.32.40.L | 4.00 | 1.00 | 0.50 | 1.70 | 3.70 | 1.00 | 32.00 | 50.00 | 4.00 |
| 4.010 | GE104.0117.058.12.40.L | 4.00 | 1.17 | 0.58 | 1.70 | 3.70 | 1.00 | 12.00 | 30.00 | 4.00 |
| 4.011 | GE104.0117.058.17.40.L | 4.00 | 1.17 | 0.58 | 1.70 | 3.70 | 1.00 | 17.00 | 35.00 | 4.00 |
| 4.012 | GE104.0117.058.22.40.L | 4.00 | 1.17 | 0.58 | 1.70 | 3.70 | 1.00 | 22.00 | 40.00 | 4.00 |
| 4.013 | GE104.0117.058.27.40.L | 4.00 | 1.17 | 0.58 | 1.70 | 3.70 | 1.00 | 27.00 | 45.00 | 4.00 |
| 4.014 | GE104.0117.058.32.40.L | 4.00 | 1.17 | 0.58 | 1.70 | 3.70 | 1.00 | 32.00 | 50.00 | 4.00 |

Cutting insert for internal pre-grooving and chamfering



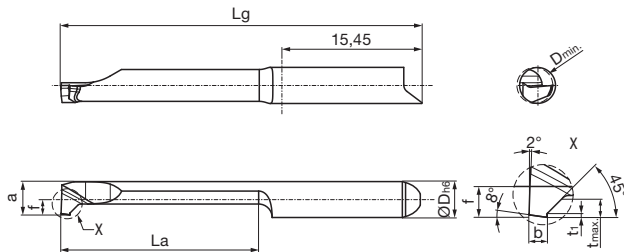
• 45° chamfer

for tool holders type GH104/GB104 see from page 16

GUHRING NAVIGATOR

Cutting data page 184

| Tool material | Solid carbide | | |
|---------------|---------------|----------------------|----------|
| Type | GV 104 | GV 104 | GV 104 |
| Surface | S TiN | a TiAlN-nanoA | ○ bright |



Right hand version shown
Left hand version mirror image

Article no. **25140** **25142** **25146**

Cutting direction

| Code no. | Description | D min | b | f | t1 | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm | mm |
| 4.001 | GV104.0807.045.04.20.R | 2.00 | 0.70 | 1.95 | 0.20 | 1.80 | 0.50 | 4.00 | 25.00 | 4.00 |
| 4.002 | GV104.0807.045.07.20.R | 2.00 | 0.70 | 1.95 | 0.20 | 1.80 | 0.50 | 7.00 | 25.00 | 4.00 |
| 4.003 | GV104.0807.045.12.20.R | 2.00 | 0.70 | 1.95 | 0.20 | 1.80 | 0.50 | 12.00 | 30.00 | 4.00 |
| 4.004 | GV104.0807.045.17.20.R | 2.00 | 0.70 | 1.95 | 0.20 | 1.80 | 0.50 | 17.00 | 35.00 | 4.00 |
| 4.005 | GV104.0807.045.07.30.R | 3.00 | 0.70 | 1.95 | 0.20 | 2.70 | 0.70 | 7.00 | 25.00 | 4.00 |
| 4.006 | GV104.0807.045.12.30.R | 3.00 | 0.70 | 1.95 | 0.20 | 2.70 | 0.70 | 12.00 | 30.00 | 4.00 |
| 4.007 | GV104.0807.045.17.30.R | 3.00 | 0.70 | 1.95 | 0.20 | 2.70 | 0.70 | 17.00 | 35.00 | 4.00 |
| 4.008 | GV104.0807.045.22.30.R | 3.00 | 0.70 | 1.95 | 0.20 | 2.70 | 0.70 | 22.00 | 40.00 | 4.00 |
| 4.009 | GV104.0810.045.12.40.R | 4.00 | 1.00 | 1.70 | 0.20 | 3.70 | 1.00 | 12.00 | 30.00 | 4.00 |
| 4.010 | GV104.0810.045.17.40.R | 4.00 | 1.00 | 1.70 | 0.20 | 3.70 | 1.00 | 17.00 | 35.00 | 4.00 |
| 4.011 | GV104.0810.045.22.40.R | 4.00 | 1.00 | 1.70 | 0.20 | 3.70 | 1.00 | 22.00 | 40.00 | 4.00 |
| 4.012 | GV104.0810.045.27.40.R | 4.00 | 1.00 | 1.70 | 0.20 | 3.70 | 1.00 | 27.00 | 45.00 | 4.00 |
| 4.013 | GV104.0810.045.32.40.R | 4.00 | 1.00 | 1.70 | 0.20 | 3.70 | 1.00 | 32.00 | 50.00 | 4.00 |

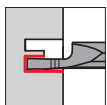
Article no. **25141** **25143** **25147**

Cutting direction

| Code no. | Description | D min | b | f | t1 | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm | mm |
| 4.001 | GV104.0807.045.04.20.L | 2.00 | 0.70 | 1.95 | 0.20 | 1.80 | 0.50 | 4.00 | 25.00 | 4.00 |
| 4.002 | GV104.0807.045.07.20.L | 2.00 | 0.70 | 1.95 | 0.20 | 1.80 | 0.50 | 7.00 | 25.00 | 4.00 |
| 4.003 | GV104.0807.045.12.20.L | 2.00 | 0.70 | 1.95 | 0.20 | 1.80 | 0.50 | 12.00 | 30.00 | 4.00 |
| 4.004 | GV104.0807.045.17.20.L | 2.00 | 0.70 | 1.95 | 0.20 | 1.80 | 0.50 | 17.00 | 35.00 | 4.00 |
| 4.005 | GV104.0807.045.07.30.L | 3.00 | 0.70 | 1.95 | 0.20 | 2.70 | 0.70 | 7.00 | 25.00 | 4.00 |
| 4.006 | GV104.0807.045.12.30.L | 3.00 | 0.70 | 1.95 | 0.20 | 2.70 | 0.70 | 12.00 | 30.00 | 4.00 |
| 4.007 | GV104.0807.045.17.30.L | 3.00 | 0.70 | 1.95 | 0.20 | 2.70 | 0.70 | 17.00 | 35.00 | 4.00 |
| 4.008 | GV104.0807.045.22.30.L | 3.00 | 0.70 | 1.95 | 0.20 | 2.70 | 0.70 | 22.00 | 40.00 | 4.00 |
| 4.009 | GV104.0810.045.12.40.L | 4.00 | 1.00 | 1.70 | 0.20 | 3.70 | 1.00 | 12.00 | 30.00 | 4.00 |
| 4.010 | GV104.0810.045.17.40.L | 4.00 | 1.00 | 1.70 | 0.20 | 3.70 | 1.00 | 17.00 | 35.00 | 4.00 |
| 4.011 | GV104.0810.045.22.40.L | 4.00 | 1.00 | 1.70 | 0.20 | 3.70 | 1.00 | 22.00 | 40.00 | 4.00 |
| 4.012 | GV104.0810.045.27.40.L | 4.00 | 1.00 | 1.70 | 0.20 | 3.70 | 1.00 | 27.00 | 45.00 | 4.00 |
| 4.013 | GV104.0810.045.32.40.L | 4.00 | 1.00 | 1.70 | 0.20 | 3.70 | 1.00 | 32.00 | 50.00 | 4.00 |



Cutting insert for axial grooving bores, straight slots



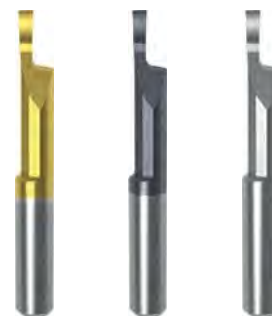
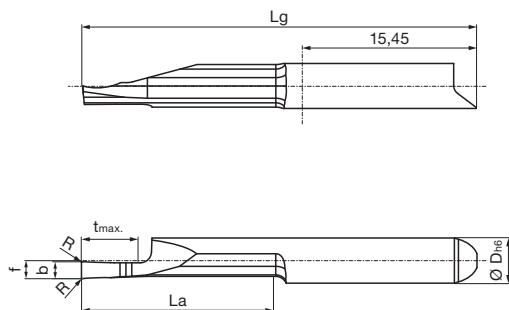
- grooving depth up to 5 mm

for tool holders type GH104/GB104 see from page 16

GUHRING NAVIGATOR

Cutting data page 184

| Tool material | Solid carbide | | |
|---------------|---------------|-------------|--------|
| Type | GA 104 | GA 104 | GA 104 |
| Surface | S | a | ○ |
| | TiN | TiAlN-nanoA | bright |



Right hand version shown
Left hand version mirror image

Article no. **25188** **25190** **25194**

Cutting direction **(R)** **(R)** **(R)**

| Code no. | Description | D min | b | R | f | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm |
| 4.001 | GA104.0100.005.12.40.R | 4.00 | 1.00 | 0.05 | 1.60 | 2.00 | 12.00 | 30.00 | 4.00 |
| 4.002 | GA104.0100.005.17.40.R | 4.00 | 1.00 | 0.05 | 1.60 | 2.00 | 17.00 | 35.00 | 4.00 |
| 4.003 | GA104.0150.005.12.40.R | 4.00 | 1.50 | 0.05 | 1.60 | 3.00 | 12.00 | 30.00 | 4.00 |
| 4.004 | GA104.0150.005.17.40.R | 4.00 | 1.50 | 0.05 | 1.60 | 3.00 | 17.00 | 35.00 | 4.00 |
| 4.005 | GA104.0200.005.12.50.R | 5.00 | 2.00 | 0.05 | 1.60 | 5.00 | 12.00 | 30.00 | 4.00 |
| 4.006 | GA104.0200.005.17.50.R | 5.00 | 2.00 | 0.05 | 1.60 | 5.00 | 17.00 | 35.00 | 4.00 |

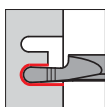
Article no. **25189** **25191** **25195**

Cutting direction **(L)** **(L)** **(L)**

| Code no. | Description | D min | b | R | f | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm |
| 4.001 | GA104.0100.005.12.40.L | 4.00 | 1.00 | 0.05 | 1.60 | 2.00 | 12.00 | 30.00 | 4.00 |
| 4.002 | GA104.0100.005.17.40.L | 4.00 | 1.00 | 0.05 | 1.60 | 2.00 | 17.00 | 35.00 | 4.00 |
| 4.003 | GA104.0150.005.12.40.L | 4.00 | 1.50 | 0.05 | 1.60 | 3.00 | 12.00 | 30.00 | 4.00 |
| 4.004 | GA104.0150.005.17.40.L | 4.00 | 1.50 | 0.05 | 1.60 | 3.00 | 17.00 | 35.00 | 4.00 |
| 4.005 | GA104.0200.005.12.50.L | 5.00 | 2.00 | 0.05 | 1.60 | 5.00 | 12.00 | 30.00 | 4.00 |
| 4.006 | GA104.0200.005.17.50.L | 5.00 | 2.00 | 0.05 | 1.60 | 5.00 | 17.00 | 35.00 | 4.00 |



Cutting insert for axial grooving bores, full radius slots

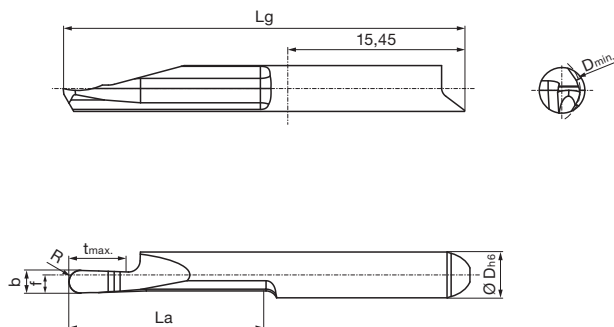


- grooving depth up to 5 mm

for tool holders type GH104/GB104 see from page 16

GUHRING NAVIGATOR

Cutting data page 184



Right hand version shown
Left hand version mirror image



| | | | |
|-------------------|--------------|--------------|--------------|
| Article no. | 25196 | 25198 | 25202 |
| Cutting direction | | | |

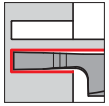
| Code no. | Description | D min | b | R | f | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm |
| 4.001 | GA104.0100.050.12.60.R | 6.00 | 1.00 | 0.50 | 1.60 | 2.00 | 12.00 | 30.00 | 4.00 |
| 4.002 | GA104.0100.050.17.60.R | 6.00 | 1.00 | 0.50 | 1.60 | 2.00 | 17.00 | 35.00 | 4.00 |
| 4.003 | GA104.0150.075.12.60.R | 6.00 | 1.50 | 0.75 | 1.60 | 3.00 | 12.00 | 30.00 | 4.00 |
| 4.004 | GA104.0150.075.17.60.R | 6.00 | 1.50 | 0.75 | 1.60 | 3.00 | 17.00 | 35.00 | 4.00 |
| 4.005 | GA104.0200.100.12.60.R | 6.00 | 2.00 | 1.00 | 1.60 | 5.00 | 12.00 | 30.00 | 4.00 |
| 4.006 | GA104.0200.100.17.60.R | 6.00 | 2.00 | 1.00 | 1.60 | 5.00 | 17.00 | 35.00 | 4.00 |

| | | | |
|-------------------|--------------|--------------|--------------|
| Article no. | 25197 | 25199 | 25203 |
| Cutting direction | | | |

| Code no. | Description | D min | b | R | f | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm |
| 4.001 | GA104.0100.050.12.60.L | 6.00 | 1.00 | 0.50 | 1.60 | 2.00 | 12.00 | 30.00 | 4.00 |
| 4.002 | GA104.0100.050.17.60.L | 6.00 | 1.00 | 0.50 | 1.60 | 2.00 | 17.00 | 35.00 | 4.00 |
| 4.003 | GA104.0150.075.12.60.L | 6.00 | 1.50 | 0.75 | 1.60 | 3.00 | 12.00 | 30.00 | 4.00 |
| 4.004 | GA104.0150.075.17.60.L | 6.00 | 1.50 | 0.75 | 1.60 | 3.00 | 17.00 | 35.00 | 4.00 |
| 4.005 | GA104.0200.100.12.60.L | 6.00 | 2.00 | 1.00 | 1.60 | 5.00 | 12.00 | 30.00 | 4.00 |
| 4.006 | GA104.0200.100.17.60.L | 6.00 | 2.00 | 1.00 | 1.60 | 5.00 | 17.00 | 35.00 | 4.00 |



Cutting insert for axial grooving studs, straight slots

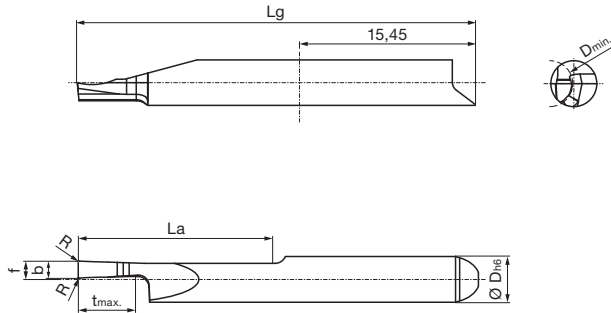


- grooving depth up to 5 mm

for tool holders type GH104/GB104 see from page 16

GUHRING NAVIGATOR

Cutting data page 184



Right hand version shown
Left hand version mirror image



System 104

| Tool material | Solid carbide | | |
|---------------|---------------|-------------|--------|
| Type | GA 104 | GA 104 | GA 104 |
| Surface | S | a | ○ |
| | TiN | TiAlN-nanoA | bright |

Article no. **25204** **25206** **25210**

Cutting direction **(R)** **(R)** **(R)**

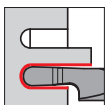
| Code no. | Description | D min | b | R | f | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm |
| 4.001 | GA104.Z100.005.12.40.R | 4.00 | 1.00 | 0.05 | 1.60 | 2.00 | 12.00 | 30.00 | 4.00 |
| 4.002 | GA104.Z100.005.17.40.R | 4.00 | 1.00 | 0.05 | 1.60 | 2.00 | 17.00 | 35.00 | 4.00 |
| 4.003 | GA104.Z150.005.12.40.R | 4.00 | 1.50 | 0.05 | 1.60 | 3.00 | 12.00 | 30.00 | 4.00 |
| 4.004 | GA104.Z150.005.17.40.R | 4.00 | 1.50 | 0.05 | 1.60 | 3.00 | 17.00 | 35.00 | 4.00 |
| 4.005 | GA104.Z200.005.12.50.R | 5.00 | 2.00 | 0.05 | 1.60 | 5.00 | 12.00 | 30.00 | 4.00 |
| 4.006 | GA104.Z200.005.17.50.R | 5.00 | 2.00 | 0.05 | 1.60 | 5.00 | 17.00 | 35.00 | 4.00 |

Article no. **25205** **25207** **25211**

Cutting direction **(L)** **(L)** **(L)**

| Code no. | Description | D min | b | R | f | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm |
| 4.001 | GA104.Z100.005.12.40.L | 4.00 | 1.00 | 0.05 | 1.60 | 2.00 | 12.00 | 30.00 | 4.00 |
| 4.002 | GA104.Z100.005.17.40.L | 4.00 | 1.00 | 0.05 | 1.60 | 2.00 | 17.00 | 35.00 | 4.00 |
| 4.003 | GA104.Z150.005.12.40.L | 4.00 | 1.50 | 0.05 | 1.60 | 3.00 | 12.00 | 30.00 | 4.00 |
| 4.004 | GA104.Z150.005.17.40.L | 4.00 | 1.50 | 0.05 | 1.60 | 3.00 | 17.00 | 35.00 | 4.00 |
| 4.005 | GA104.Z200.005.12.50.L | 5.00 | 2.00 | 0.05 | 1.60 | 5.00 | 12.00 | 30.00 | 4.00 |
| 4.006 | GA104.Z200.005.17.50.L | 5.00 | 2.00 | 0.05 | 1.60 | 5.00 | 17.00 | 35.00 | 4.00 |

Cutting insert for axial grooving studs, full radius slots

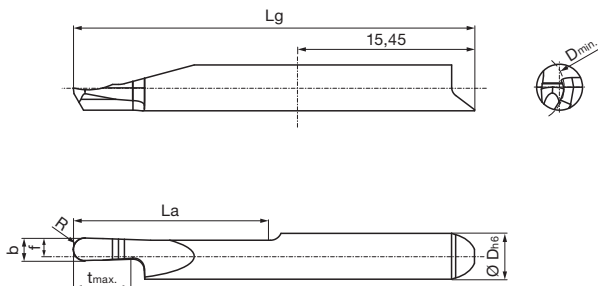


- grooving depth up to 5 mm

for tool holders type GH104/GB104 see from page 16

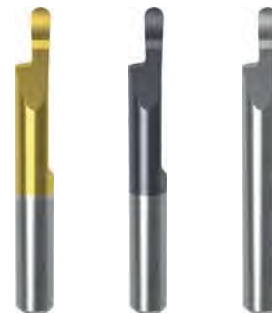
GUHRING NAVIGATOR

Cutting data page 184



Right hand version shown
Left hand version mirror image

| Tool material | Solid carbide | | |
|---------------|---------------|-------------|--------|
| Type | GA 104 | GA 104 | GA 104 |
| Surface | S | a | ○ |
| | TiN | TiAlN-nanoA | bright |



Article no. **25212** **25214** **25218**

Cutting direction

| Code no. | Description | D min | b | R | f | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm |
| 4.001 | GA104.Z100.050.12.60.R | 6.00 | 1.00 | 0.50 | 1.60 | 2.00 | 12.00 | 30.00 | 4.00 |
| 4.002 | GA104.Z100.050.17.60.R | 6.00 | 1.00 | 0.50 | 1.60 | 2.00 | 17.00 | 35.00 | 4.00 |
| 4.003 | GA104.Z150.075.12.60.R | 6.00 | 1.50 | 0.75 | 1.60 | 3.00 | 12.00 | 30.00 | 4.00 |
| 4.004 | GA104.Z150.075.17.60.R | 6.00 | 1.50 | 0.75 | 1.60 | 3.00 | 17.00 | 35.00 | 4.00 |
| 4.005 | GA104.Z200.100.12.60.R | 6.00 | 2.00 | 1.00 | 1.60 | 5.00 | 12.00 | 30.00 | 4.00 |
| 4.006 | GA104.Z200.100.17.60.R | 6.00 | 2.00 | 1.00 | 1.60 | 5.00 | 17.00 | 35.00 | 4.00 |

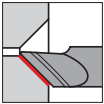
Article no. **25213** **25215** **25219**

Cutting direction

| Code no. | Description | D min | b | R | f | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm |
| 4.001 | GA104.Z100.050.12.60.L | 6.00 | 1.00 | 0.50 | 1.60 | 2.00 | 12.00 | 30.00 | 4.00 |
| 4.002 | GA104.Z100.050.17.60.L | 6.00 | 1.00 | 0.50 | 1.60 | 2.00 | 17.00 | 35.00 | 4.00 |
| 4.003 | GA104.Z150.075.12.60.L | 6.00 | 1.50 | 0.75 | 1.60 | 3.00 | 12.00 | 30.00 | 4.00 |
| 4.004 | GA104.Z150.075.17.60.L | 6.00 | 1.50 | 0.75 | 1.60 | 3.00 | 17.00 | 35.00 | 4.00 |
| 4.005 | GA104.Z200.100.12.60.L | 6.00 | 2.00 | 1.00 | 1.60 | 5.00 | 12.00 | 30.00 | 4.00 |
| 4.006 | GA104.Z200.100.17.60.L | 6.00 | 2.00 | 1.00 | 1.60 | 5.00 | 17.00 | 35.00 | 4.00 |



Cutting insert for axial chamfering bores



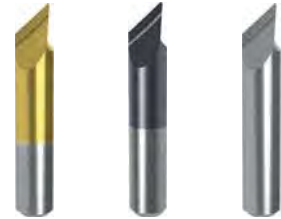
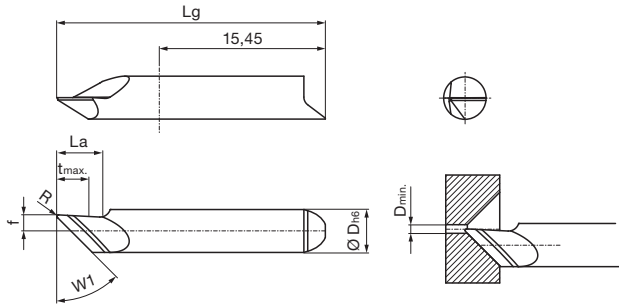
- 45°/60°/75° chamfer angle

for tool holders type GH104/GB104 see from page 16

GUHRING NAVIGATOR

Cutting data page 184

| | | | |
|---------------|---------------|-------------|--------|
| Tool material | Solid carbide | | |
| Type | GA 104 | GA 104 | GA 104 |
| Surface | S | a | ○ |
| | TiN | TiAlN-nanoA | bright |



Right hand version shown
Left hand version mirror image

Article no. **25220** **25222** **25226**

Cutting direction

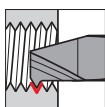
| Code no. | Description | D min | R | W1 | f | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|-------|------|-------|------|-------|------|
| | | mm | mm | ° | mm | mm | mm | mm | mm |
| 4.001 | GA104.F045.015.04.08.R | 0.80 | 0.15 | 45.00 | 1.50 | 3.00 | 4.00 | 25.00 | 4.00 |
| 4.002 | GA104.F060.015.04.08.R | 0.80 | 0.15 | 60.00 | 0.50 | 3.50 | 4.00 | 25.00 | 4.00 |
| 4.003 | GA104.F075.015.04.08.R | 0.80 | 0.15 | 75.00 | 0.50 | 2.00 | 4.00 | 25.00 | 4.00 |

Article no. **25221** **25223** **25227**

Cutting direction

| Code no. | Description | D min | R | W1 | f | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|-------|------|-------|------|-------|------|
| | | mm | mm | ° | mm | mm | mm | mm | mm |
| 4.001 | GA104.F045.015.04.08.L | 0.80 | 0.15 | 45.00 | 1.50 | 3.00 | 4.00 | 25.00 | 4.00 |
| 4.002 | GA104.F060.015.04.08.L | 0.80 | 0.15 | 60.00 | 0.50 | 3.50 | 4.00 | 25.00 | 4.00 |
| 4.003 | GA104.F075.015.04.08.L | 0.80 | 0.15 | 75.00 | 0.50 | 2.00 | 4.00 | 25.00 | 4.00 |

Cutting insert for internal threading, part profile - metric standard threads

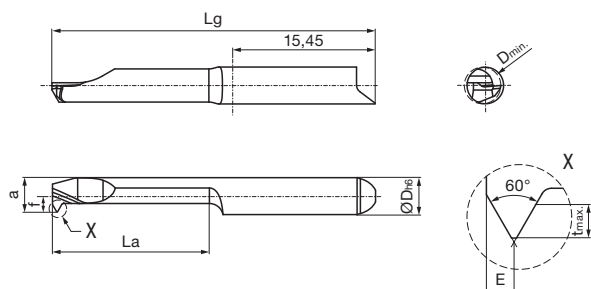


• pitch P = 0.4-1.0

for tool holders type GH104/GB104 see from page 16

GUHRING NAVIGATOR

Cutting data page 184



Right hand version shown
Left hand version mirror image



| Tool material | Solid carbide | | | |
|---------------|---------------|-------------|--------|--------|
| | Type | GG 104 | GG 104 | GG 104 |
| Surface | S | a | ○ | |
| | TiN | TiAlN-nanoA | bright | |

Article no. **25148** **25150** **25154**

Cutting direction

| Code no. | Description | G | P | D min | f | t max | a | E | La | Lg | D h6 |
|----------|------------------------|---------|-----------|-------|------|-------|------|------|-------|-------|------|
| | | | | mm | mm | mm | mm | mm | mm | mm | mm |
| 4.001 | GG104.TM02.040.04.15.R | M2/M2,5 | 0.40-0.45 | 1.50 | 1.95 | 0.25 | 1.40 | 0.25 | 4.00 | 25.00 | 4.00 |
| 4.002 | GG104.TM02.040.07.15.R | M2/M2,5 | 0.40-0.45 | 1.50 | 1.95 | 0.25 | 1.40 | 0.25 | 7.00 | 25.00 | 4.00 |
| 4.003 | GG104.TM02.040.12.15.R | M2/M2,5 | 0.40-0.45 | 1.50 | 1.95 | 0.25 | 1.40 | 0.25 | 12.00 | 30.00 | 4.00 |
| 4.004 | GG104.TM03.050.04.25.R | M3 | 0.50 | 2.50 | 1.95 | 0.30 | 2.20 | 0.30 | 4.00 | 25.00 | 4.00 |
| 4.005 | GG104.TM03.050.07.25.R | M3 | 0.50 | 2.50 | 1.95 | 0.30 | 2.20 | 0.30 | 7.00 | 25.00 | 4.00 |
| 4.006 | GG104.TM03.050.12.25.R | M3 | 0.50 | 2.50 | 1.95 | 0.30 | 2.20 | 0.30 | 12.00 | 30.00 | 4.00 |
| 4.007 | GG104.TM04.070.07.33.R | M4 | 0.70 | 3.30 | 1.95 | 0.40 | 3.00 | 0.40 | 7.00 | 25.00 | 4.00 |
| 4.008 | GG104.TM04.070.12.33.R | M4 | 0.70 | 3.30 | 1.95 | 0.40 | 3.00 | 0.40 | 12.00 | 30.00 | 4.00 |
| 4.009 | GG104.TM04.070.17.33.R | M4 | 0.70 | 3.30 | 1.95 | 0.40 | 3.00 | 0.40 | 17.00 | 35.00 | 4.00 |
| 4.010 | GG104.TM05.080.12.40.R | M5/M6 | 0.80-1.00 | 4.00 | 1.70 | 0.60 | 3.70 | 0.50 | 12.00 | 30.00 | 4.00 |
| 4.011 | GG104.TM05.080.17.40.R | M5/M6 | 0.80-1.00 | 4.00 | 1.70 | 0.60 | 3.70 | 0.50 | 17.00 | 35.00 | 4.00 |
| 4.012 | GG104.TM05.080.22.40.R | M5/M6 | 0.80-1.00 | 4.00 | 1.70 | 0.60 | 3.70 | 0.50 | 22.00 | 40.00 | 4.00 |

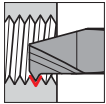
Article no. **25149** **25151** **25155**

Cutting direction

| Code no. | Description | G | P | D min | f | t max | a | E | La | Lg | D h6 |
|----------|------------------------|---------|-----------|-------|------|-------|------|------|-------|-------|------|
| | | | | mm | mm | mm | mm | mm | mm | mm | mm |
| 4.001 | GG104.TM02.040.04.15.L | M2/M2,5 | 0.40-0.45 | 1.50 | 1.95 | 0.25 | 1.40 | 0.25 | 4.00 | 25.00 | 4.00 |
| 4.002 | GG104.TM02.040.07.15.L | M2/M2,5 | 0.40-0.45 | 1.50 | 1.95 | 0.25 | 1.40 | 0.25 | 7.00 | 25.00 | 4.00 |
| 4.003 | GG104.TM02.040.12.15.L | M2/M2,5 | 0.40-0.45 | 1.50 | 1.95 | 0.25 | 1.40 | 0.25 | 12.00 | 30.00 | 4.00 |
| 4.004 | GG104.TM03.050.04.25.L | M3 | 0.50 | 2.50 | 1.95 | 0.30 | 2.20 | 0.30 | 4.00 | 25.00 | 4.00 |
| 4.005 | GG104.TM03.050.07.25.L | M3 | 0.50 | 2.50 | 1.95 | 0.30 | 2.20 | 0.30 | 7.00 | 25.00 | 4.00 |
| 4.006 | GG104.TM03.050.12.25.L | M3 | 0.50 | 2.50 | 1.95 | 0.30 | 2.20 | 0.30 | 12.00 | 30.00 | 4.00 |
| 4.007 | GG104.TM04.070.07.33.L | M4 | 0.70 | 3.30 | 1.95 | 0.40 | 3.00 | 0.40 | 7.00 | 25.00 | 4.00 |
| 4.008 | GG104.TM04.070.12.33.L | M4 | 0.70 | 3.30 | 1.95 | 0.40 | 3.00 | 0.40 | 12.00 | 30.00 | 4.00 |
| 4.009 | GG104.TM04.070.17.33.L | M4 | 0.70 | 3.30 | 1.95 | 0.40 | 3.00 | 0.40 | 17.00 | 35.00 | 4.00 |
| 4.010 | GG104.TM05.080.12.40.L | M5/M6 | 0.80-1.00 | 4.00 | 1.70 | 0.60 | 3.70 | 0.50 | 12.00 | 30.00 | 4.00 |
| 4.011 | GG104.TM05.080.17.40.L | M5/M6 | 0.80-1.00 | 4.00 | 1.70 | 0.60 | 3.70 | 0.50 | 17.00 | 35.00 | 4.00 |
| 4.012 | GG104.TM05.080.22.40.L | M5/M6 | 0.80-1.00 | 4.00 | 1.70 | 0.60 | 3.70 | 0.50 | 22.00 | 40.00 | 4.00 |



Cutting insert for internal threading, part profile - metric fine threads



• pitch P = 0.2-0.5

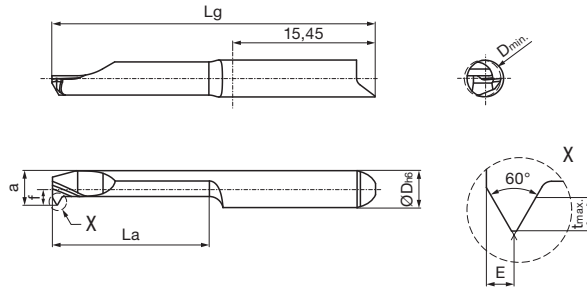
for tool holders type GH104/GB104 see from page 16

GUHRING NAVIGATOR

Cutting data page 184

| Tool material | Solid carbide | | |
|---------------|---------------|-------------|--------|
| Type | GG 104 | GG 104 | GG 104 |
| Surface | S | a | ○ |
| | TiN | TiAlN-nanoA | bright |

System 104



Right hand version shown
Left hand version mirror image

Article no. **25156** **25158** **25162**

Cutting direction

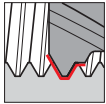
| Code no. | Description | G | P | D min | f | t max | a | E | La | Lg | D h6 |
|----------|------------------------|-------|-----------|-------|------|-------|------|------|-------|-------|------|
| | | | | mm | mm | mm | mm | mm | mm | mm | mm |
| 4.001 | GG104.TM02.020.04.17.R | M2/M3 | 0.20-0.30 | 1.70 | 1.95 | 0.20 | 1.55 | 0.20 | 4.00 | 25.00 | 4.00 |
| 4.002 | GG104.TM02.020.07.17.R | M2/M3 | 0.20-0.30 | 1.70 | 1.95 | 0.20 | 1.55 | 0.20 | 7.00 | 25.00 | 4.00 |
| 4.003 | GG104.TM02.020.12.17.R | M2/M3 | 0.20-0.30 | 1.70 | 1.95 | 0.20 | 1.55 | 0.20 | 12.00 | 30.00 | 4.00 |
| 4.004 | GG104.TM04.035.07.35.R | M4/M5 | 0.35-0.50 | 3.50 | 1.95 | 0.30 | 3.20 | 0.35 | 7.00 | 25.00 | 4.00 |
| 4.005 | GG104.TM04.035.12.35.R | M4/M5 | 0.35-0.50 | 3.50 | 1.95 | 0.30 | 3.20 | 0.35 | 12.00 | 30.00 | 4.00 |
| 4.006 | GG104.TM04.035.17.35.R | M4/M5 | 0.35-0.50 | 3.50 | 1.95 | 0.30 | 3.20 | 0.35 | 17.00 | 35.00 | 4.00 |

Article no. **25157** **25159** **25163**

Cutting direction

| Code no. | Description | G | P | D min | f | t max | a | E | La | Lg | D h6 |
|----------|------------------------|-------|-----------|-------|------|-------|------|------|-------|-------|------|
| | | | | mm | mm | mm | mm | mm | mm | mm | mm |
| 4.001 | GG104.TM02.020.04.17.L | M2/M3 | 0.20-0.30 | 1.70 | 1.95 | 0.20 | 1.55 | 0.20 | 4.00 | 25.00 | 4.00 |
| 4.002 | GG104.TM02.020.07.17.L | M2/M3 | 0.20-0.30 | 1.70 | 1.95 | 0.20 | 1.55 | 0.20 | 7.00 | 25.00 | 4.00 |
| 4.003 | GG104.TM02.020.12.17.L | M2/M3 | 0.20-0.30 | 1.70 | 1.95 | 0.20 | 1.55 | 0.20 | 12.00 | 30.00 | 4.00 |
| 4.004 | GG104.TM04.035.07.35.L | M4/M5 | 0.35-0.50 | 3.50 | 1.95 | 0.30 | 3.20 | 0.35 | 7.00 | 25.00 | 4.00 |
| 4.005 | GG104.TM04.035.12.35.L | M4/M5 | 0.35-0.50 | 3.50 | 1.95 | 0.30 | 3.20 | 0.35 | 12.00 | 30.00 | 4.00 |
| 4.006 | GG104.TM04.035.17.35.L | M4/M5 | 0.35-0.50 | 3.50 | 1.95 | 0.30 | 3.20 | 0.35 | 17.00 | 35.00 | 4.00 |

Cutting insert for internal threading, full profile - metric standard threads

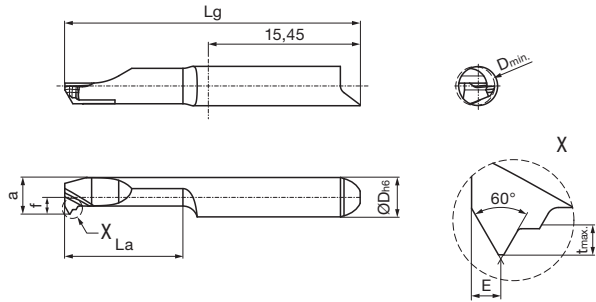


• pitch P = 0.4-0.8

for tool holders type GH104/GB104 see from page 16

GUHRING NAVIGATOR

Cutting data page 184



Right hand version shown
Left hand version mirror image



Article no. **25164** **25166** **25170**

Cutting direction

| Code no. | Description | G | P | D min | f | E | a | t max | La | Lg | D h6 |
|----------|------------------------|----|------|-------|------|------|------|-------|-------|-------|------|
| | | | mm | mm | mm | mm | mm | mm | mm | mm | mm |
| 4.001 | GG104.VM02.040.04.15.R | M2 | 0.40 | 1.50 | 1.95 | 0.20 | 1.35 | 0.25 | 4.00 | 25.00 | 4.00 |
| 4.002 | GG104.VM02.040.07.15.R | M2 | 0.40 | 1.50 | 1.95 | 0.20 | 1.35 | 0.25 | 7.00 | 25.00 | 4.00 |
| 4.003 | GG104.VM02.040.12.15.R | M2 | 0.40 | 1.50 | 1.95 | 0.20 | 1.35 | 0.25 | 12.00 | 30.00 | 4.00 |
| 4.004 | GG104.VM03.050.04.24.R | M3 | 0.50 | 2.40 | 1.95 | 0.30 | 1.95 | 0.35 | 4.00 | 25.00 | 4.00 |
| 4.005 | GG104.VM03.050.07.24.R | M3 | 0.50 | 2.40 | 1.95 | 0.30 | 1.95 | 0.35 | 7.00 | 25.00 | 4.00 |
| 4.006 | GG104.VM03.050.12.24.R | M3 | 0.50 | 2.40 | 1.95 | 0.30 | 1.95 | 0.35 | 12.00 | 30.00 | 4.00 |
| 4.007 | GG104.VM04.070.07.31.R | M4 | 0.70 | 3.10 | 1.95 | 0.40 | 2.80 | 0.45 | 7.00 | 25.00 | 4.00 |
| 4.008 | GG104.VM04.070.12.31.R | M4 | 0.70 | 3.10 | 1.95 | 0.40 | 2.80 | 0.45 | 12.00 | 30.00 | 4.00 |
| 4.009 | GG104.VM04.070.17.31.R | M4 | 0.70 | 3.10 | 1.95 | 0.40 | 2.80 | 0.45 | 17.00 | 35.00 | 4.00 |
| 4.010 | GG104.VM04.070.22.31.R | M4 | 0.70 | 3.10 | 1.95 | 0.40 | 2.80 | 0.45 | 22.00 | 40.00 | 4.00 |
| 4.011 | GG104.VM05.080.12.40.R | M5 | 0.80 | 4.00 | 1.70 | 0.50 | 3.70 | 0.50 | 12.00 | 30.00 | 4.00 |
| 4.012 | GG104.VM05.080.17.40.R | M5 | 0.80 | 4.00 | 1.70 | 0.50 | 3.70 | 0.50 | 17.00 | 35.00 | 4.00 |
| 4.013 | GG104.VM05.080.22.40.R | M5 | 0.80 | 4.00 | 1.70 | 0.50 | 3.70 | 0.50 | 22.00 | 40.00 | 4.00 |
| 4.014 | GG104.VM05.080.27.40.R | M5 | 0.80 | 4.00 | 1.70 | 0.50 | 3.70 | 0.50 | 27.00 | 45.00 | 4.00 |

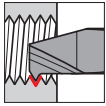
Article no. **25165** **25167** **25171**

Cutting direction

| Code no. | Description | G | P | D min | f | E | a | t max | La | Lg | D h6 |
|----------|------------------------|----|------|-------|------|------|------|-------|-------|-------|------|
| | | | mm | mm | mm | mm | mm | mm | mm | mm | mm |
| 4.001 | GG104.VM02.040.04.15.L | M2 | 0.40 | 1.50 | 1.95 | 0.20 | 1.35 | 0.25 | 4.00 | 25.00 | 4.00 |
| 4.002 | GG104.VM02.040.07.15.L | M2 | 0.40 | 1.50 | 1.95 | 0.20 | 1.35 | 0.25 | 7.00 | 25.00 | 4.00 |
| 4.003 | GG104.VM02.040.12.15.L | M2 | 0.40 | 1.50 | 1.95 | 0.20 | 1.35 | 0.25 | 12.00 | 30.00 | 4.00 |
| 4.004 | GG104.VM03.050.04.24.L | M3 | 0.50 | 2.40 | 1.95 | 0.30 | 1.95 | 0.35 | 4.00 | 25.00 | 4.00 |
| 4.005 | GG104.VM03.050.07.24.L | M3 | 0.50 | 2.40 | 1.95 | 0.30 | 1.95 | 0.35 | 7.00 | 25.00 | 4.00 |
| 4.006 | GG104.VM03.050.12.24.L | M3 | 0.50 | 2.40 | 1.95 | 0.30 | 1.95 | 0.35 | 12.00 | 30.00 | 4.00 |
| 4.007 | GG104.VM04.070.07.31.L | M4 | 0.70 | 3.10 | 1.95 | 0.40 | 2.80 | 0.45 | 7.00 | 25.00 | 4.00 |
| 4.008 | GG104.VM04.070.12.31.L | M4 | 0.70 | 3.10 | 1.95 | 0.40 | 2.80 | 0.45 | 12.00 | 30.00 | 4.00 |
| 4.009 | GG104.VM04.070.17.31.L | M4 | 0.70 | 3.10 | 1.95 | 0.40 | 2.80 | 0.45 | 17.00 | 35.00 | 4.00 |
| 4.010 | GG104.VM04.070.22.31.L | M4 | 0.70 | 3.10 | 1.95 | 0.40 | 2.80 | 0.45 | 22.00 | 40.00 | 4.00 |
| 4.011 | GG104.VM05.080.12.40.L | M5 | 0.80 | 4.00 | 1.70 | 0.50 | 3.70 | 0.50 | 12.00 | 30.00 | 4.00 |
| 4.012 | GG104.VM05.080.17.40.L | M5 | 0.80 | 4.00 | 1.70 | 0.50 | 3.70 | 0.50 | 17.00 | 35.00 | 4.00 |
| 4.013 | GG104.VM05.080.22.40.L | M5 | 0.80 | 4.00 | 1.70 | 0.50 | 3.70 | 0.50 | 22.00 | 40.00 | 4.00 |
| 4.014 | GG104.VM05.080.27.40.L | M5 | 0.80 | 4.00 | 1.70 | 0.50 | 3.70 | 0.50 | 27.00 | 45.00 | 4.00 |



Cutting insert for internal threading, part profile - UN-threads



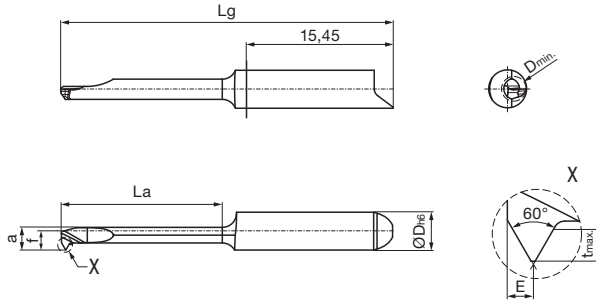
• pitch 32-40 thread/inch

for tool holders type GH104/GB104 see from page 16

GUHRING NAVIGATOR

Cutting data page 184

| Tool material | Solid carbide | | |
|---------------|---------------|-------------|--------|
| Type | GG 104 | GG 104 | GG 104 |
| Surface | S | a | ○ |
| | TiN | TiAlN-nanoA | bright |



Right hand version shown
Left hand version mirror image

Article no. **25172** **25174** **25178**

Cutting direction

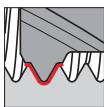
| Code no. | Description | P | D min | f | t max | a | E | La | Lg | D h6 |
|----------|------------------------|--------|-------|------|-------|------|------|-------|-------|------|
| | | G/inch | mm | mm | mm | mm | mm | mm | mm | mm |
| 4.001 | GG104.TU32.040.17.26.R | 32-40 | 2.60 | 1.95 | 0.55 | 2.35 | 0.45 | 17.00 | 35.00 | 4.00 |

Article no. **25173** **25175** **25179**

Cutting direction

| Code no. | Description | P | D min | f | t max | a | E | La | Lg | D h6 |
|----------|------------------------|--------|-------|------|-------|------|------|-------|-------|------|
| | | G/inch | mm | mm | mm | mm | mm | mm | mm | mm |
| 4.001 | GG104.TU32.040.17.26.L | 32-40 | 2.60 | 1.95 | 0.55 | 2.35 | 0.45 | 17.00 | 35.00 | 4.00 |

Cutting insert for internal threading, full profile - Whitworth pipe threads

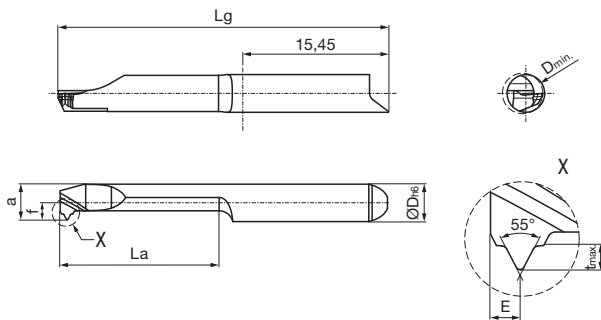


• pitch 24-28 thread/inch

for tool holders type GH104/GB104 see from page 16

GUHRING NAVIGATOR

Cutting data page 184



Right hand version shown
Left hand version mirror image

Article no. **25180** **25182** **25186**

Cutting direction

| Code no. | Description | P | D min | f | t max | a | E | La | Lg | D h6 |
|----------|------------------------|--------|-------|------|-------|------|------|-------|-------|------|
| | | G/inch | mm | mm | mm | mm | mm | mm | mm | mm |
| 4.001 | GG104.VW28.091.17.43.R | 28.00 | 4.30 | 1.80 | 0.65 | 3.80 | 0.75 | 17.00 | 35.00 | 4.00 |
| 4.002 | GG104.VW26.098.17.49.R | 26.00 | 4.90 | 1.95 | 0.70 | 3.95 | 0.80 | 17.00 | 35.00 | 4.00 |
| 4.003 | GG104.VW24.106.17.33.R | 24.00 | 3.30 | 1.95 | 0.75 | 3.00 | 0.80 | 17.00 | 35.00 | 4.00 |

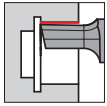
Article no. **25181** **25183** **25187**

Cutting direction

| Code no. | Description | P | D min | f | t max | a | E | La | Lg | D h6 |
|----------|------------------------|--------|-------|------|-------|------|------|-------|-------|------|
| | | G/inch | mm | mm | mm | mm | mm | mm | mm | mm |
| 4.001 | GG104.VW28.091.17.43.L | 28.00 | 4.30 | 1.80 | 0.65 | 3.80 | 0.75 | 17.00 | 35.00 | 4.00 |
| 4.002 | GG104.VW26.098.17.49.L | 26.00 | 4.90 | 1.95 | 0.70 | 3.95 | 0.80 | 17.00 | 35.00 | 4.00 |
| 4.003 | GG104.VW24.106.17.33.L | 24.00 | 3.30 | 1.95 | 0.75 | 3.00 | 0.80 | 17.00 | 35.00 | 4.00 |



Cutting insert for internal hexagon



• SW 1.5-4.0

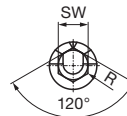
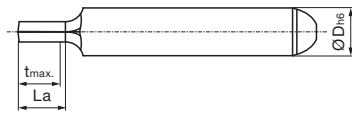
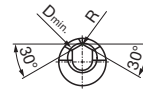
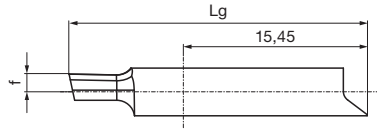
for tool holders type GB104 Art. No. 25006 see page 28

GUHRING NAVIGATOR

Cutting data page 184

| Tool material | Solid carbide | | |
|---------------|---------------|-------------|--------|
| Type | GN 104 | GN 104 | GN 104 |
| Surface | S | a | ○ |
| | TiN | TiAlN-nanoA | bright |

System 104

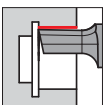


Article no. **25228** **25229** **25231**

| Code no. | Description | SW | D min | R | f | t max | La | Lg | D h6 |
|----------|------------------------|-----------|-------|------|------|-------|------|-------|------|
| | | | mm | mm | mm | mm | mm | mm | mm |
| 4.001 | GN104.SW15.005.04.15.N | 1,50-2,00 | 1.50 | 0.05 | 1.50 | 3.50 | 4.00 | 25.00 | 4.00 |
| 4.002 | GN104.SW20.005.04.20.N | 2,00-2,50 | 2.00 | 0.05 | 1.50 | 3.50 | 4.00 | 25.00 | 4.00 |
| 4.003 | GN104.SW25.005.04.25.N | 2,50-2,90 | 2.50 | 0.05 | 1.50 | 3.50 | 4.00 | 25.00 | 4.00 |
| 4.004 | GN104.SW29.005.05.29.N | 2,90-3,50 | 2.90 | 0.05 | 1.50 | 4.50 | 5.00 | 25.00 | 4.00 |
| 4.005 | GN104.SW35.005.06.35.N | 3,50-4,00 | 3.50 | 0.05 | 1.50 | 5.50 | 6.00 | 25.00 | 4.00 |



Cutting insert for internal square

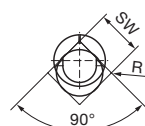
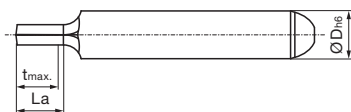
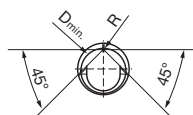
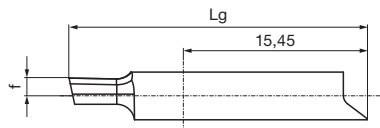


• SW 1.5-4.0

for tool holders type GB104 Art. No. 25006 see page 28

GUHRING NAVIGATOR

Cutting data page 184

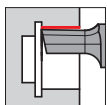


Article no. **25232** **25233** **25235**

| Code no. | Description | SW | D min | R | f | t max | La | Lg | D h6 |
|----------|------------------------|-----------|-------|------|------|-------|------|-------|------|
| | | | mm | mm | mm | mm | mm | mm | mm |
| 4.001 | GN104.4545.005.04.15.N | 1,50-2,00 | 1.50 | 0.05 | 1.50 | 3.50 | 4.00 | 25.00 | 4.00 |
| 4.002 | GN104.4545.005.04.20.N | 2,00-2,50 | 2.00 | 0.05 | 1.50 | 3.50 | 4.00 | 25.00 | 4.00 |
| 4.003 | GN104.4545.005.04.25.N | 2,50-2,90 | 2.50 | 0.05 | 1.50 | 3.50 | 4.00 | 25.00 | 4.00 |
| 4.004 | GN104.4545.005.05.29.N | 2,90-3,50 | 2.90 | 0.05 | 1.50 | 4.50 | 5.00 | 25.00 | 4.00 |
| 4.005 | GN104.4545.005.06.35.N | 3,50-4,00 | 3.50 | 0.05 | 1.50 | 5.50 | 6.00 | 25.00 | 4.00 |



Cutting insert for Torx



• Torx 8-30

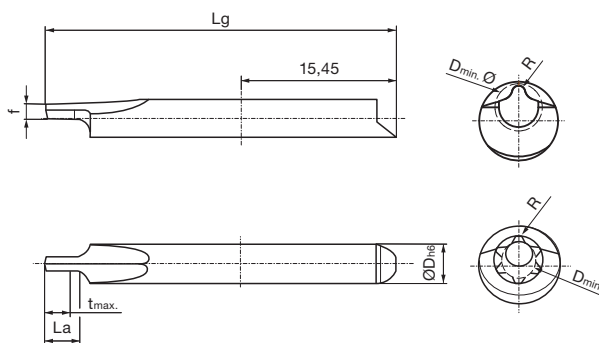
for tool holders type GB104 Art. No. 25006 see page 28

GUHRING NAVIGATOR

Cutting data page 184

| Tool material | Solid carbide | | |
|---------------|---------------|-------------|--------|
| Type | GN 104 | GN 104 | GN 104 |
| Surface | S | a | ○ |
| | TiN | TiAlN-nanoA | bright |

System 104



Article no. **25236** **25237** **25239**

| Code no. | Description | Torx | D min | R | f | t max | La | Lg | D h6 |
|----------|------------------------|------|-------|------|------|-------|------|-------|------|
| | | | mm | mm | mm | mm | mm | mm | mm |
| 4.001 | GN104.TX08.024.03.17.N | T8 | 1.70 | 0.24 | 1.80 | 2.50 | 3.00 | 35.00 | 4.00 |
| 4.002 | GN104.TX10.028.03.20.N | T10 | 2.00 | 0.28 | 1.80 | 2.50 | 3.00 | 35.00 | 4.00 |
| 4.003 | GN104.TX15.033.04.24.N | T15 | 2.40 | 0.33 | 1.80 | 3.50 | 4.00 | 40.00 | 4.00 |
| 4.004 | GN104.TX20.039.04.28.N | T20 | 2.80 | 0.39 | 1.80 | 3.50 | 4.00 | 40.00 | 4.00 |
| 4.005 | GN104.TX25.045.05.32.N | T25 | 3.20 | 0.45 | 1.80 | 4.50 | 5.00 | 40.00 | 4.00 |
| 4.006 | GN104.TX30.056.05.40.N | T30 | 4.00 | 0.56 | 1.80 | 4.50 | 5.00 | 40.00 | 4.00 |

106





SYSTEM 106

MICRO-PRECISION TOOLS



Round shank holder

from page 62



Square shank holder

from page 69



Modular holder

from page 71

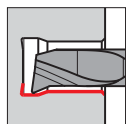


Round shank holder

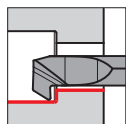
Broaching
page 74

Tool holder

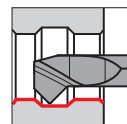
System 106



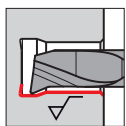
Boring out
and profiling, type GT
from page 75



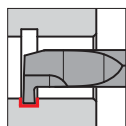
Back boring
and profiling, type GT
from page 96



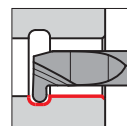
Boring out
and chamfering, type GT
from page 98



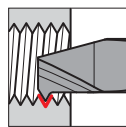
Boring out
with Wiper, type GJ
from page 92



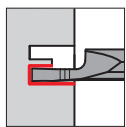
Internal grooving,
straight slots, type GE
from page 102



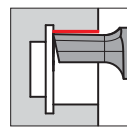
Internal grooving,
full radius slots, type GE
from page 106



Internal threading,
type GG
from page 114



Axial grooving bores,
type GA
from page 110



Broaching,
type GN
from page 119

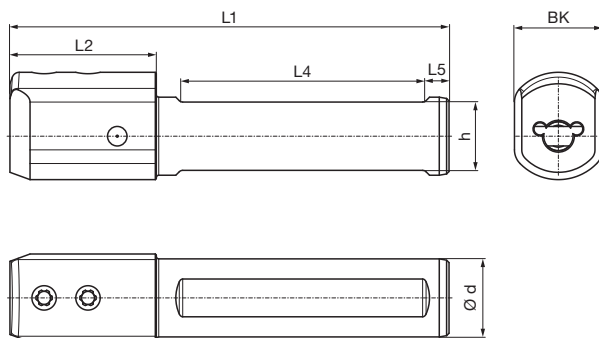
Cutting inserts from hole-Ø 5 mm

Round shank holder, clamping screw top

- for inserts type 106
- with internal coolant supply

Type GB 106

System 106



Article no. 25300

| Code no. | Description | d | h | L1 | L2 | L4 | L5 | BK |
|----------|---------------------------|-------|-------|--------|-------|-------|------|------|
| | | mm | mm | mm | mm | mm | mm | mm |
| 6.001 | GB106.0010.090.00.22.N.IK | 10.00 | 9.00 | 90.00 | 30.00 | 50.00 | 5.00 | 13.0 |
| 6.002 | GB106.0012.090.00.22.N.IK | 12.00 | 11.00 | 90.00 | 30.00 | 50.00 | 5.00 | 14.0 |
| 6.015 | GB106.0500.354.00.22.N.IK | 12.70 | 11.00 | 89.92 | 26.67 | 54.86 | 5.08 | 13.9 |
| 6.016 | GB106.0625.354.00.22.N.IK | 15.87 | 14.00 | 89.92 | 26.67 | 54.86 | 5.08 | 17.7 |
| 6.003 | GB106.0016.090.00.22.N.IK | 16.00 | 14.00 | 90.00 | 30.00 | 50.00 | 5.00 | 18.0 |
| 6.017 | GB106.0750.415.00.22.N.IK | 19.05 | 17.04 | 105.41 | 26.67 | 69.85 | 5.08 | |
| 6.004 | GB106.0020.095.00.22.N.IK | 20.00 | 18.00 | 95.00 | 30.00 | 55.00 | 5.00 | |
| 6.005 | GB106.0022.095.00.22.N.IK | 22.00 | 20.00 | 95.00 | | 55.00 | 5.00 | |
| 6.006 | GB106.0025.100.00.22.N.IK | 25.00 | 23.00 | 100.00 | | 55.00 | 5.00 | |
| 6.018 | GB106.1000.415.00.22.N.IK | 25.40 | 23.39 | 105.41 | | 69.85 | 5.08 | |

Spare parts

| Article no. | Clamping screw | Tightening torque |
|-------------|----------------|-------------------|
| 25900 | | Nm |
| Code 6.000 | M6x7.5x15IP | 4-4.5 |

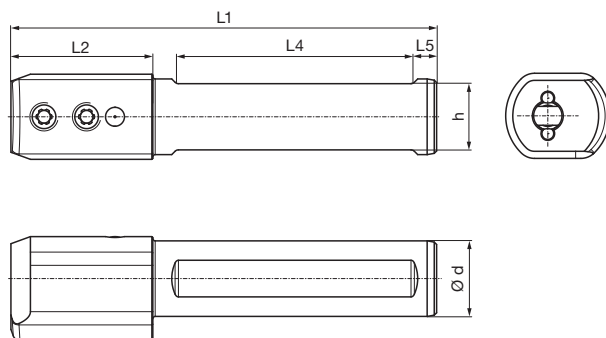
| Article no. | Torx-Plus Wrench |
|-------------|------------------|
| 25904 | |
| Code 15.000 | T15IP T-handle |



Round shank holder, clamping screw lateral

- for inserts type 106
- with internal coolant supply

Type GB 106



System 106

Article no. 25301

| Code no. | Description | d | h | L1 | L2 | L4 | L5 |
|----------|------------------------------|-------|-------|--------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm |
| 6.001 | GB106.0010.090.00.22.N.IK.90 | 10.00 | 9.00 | 90.00 | 30.00 | 50.00 | 5.00 |
| 6.002 | GB106.0012.090.00.22.N.IK.90 | 12.00 | 11.00 | 90.00 | 30.00 | 50.00 | 5.00 |
| 6.015 | GB106.0500.354.00.22.N.IK.90 | 12.70 | 11.00 | 89.92 | 26.67 | 54.86 | 5.08 |
| 6.016 | GB106.0625.354.00.22.N.IK.90 | 15.87 | 14.00 | 89.92 | 26.67 | 54.86 | 5.08 |
| 6.003 | GB106.0016.090.00.22.N.IK.90 | 16.00 | 14.00 | 90.00 | 30.00 | 50.00 | 5.00 |
| 6.017 | GB106.0750.415.00.22.N.IK.90 | 19.05 | 17.04 | 105.41 | 26.67 | 69.85 | 5.08 |
| 6.004 | GB106.0020.095.00.22.N.IK.90 | 20.00 | 18.00 | 95.00 | 30.00 | 55.00 | 5.00 |
| 6.005 | GB106.0022.095.00.22.N.IK.90 | 22.00 | 20.00 | 95.00 | | 55.00 | 5.00 |
| 6.006 | GB106.0025.100.00.22.N.IK.90 | 25.00 | 23.00 | 100.00 | | 55.00 | 5.00 |
| 6.018 | GB106.1000.415.00.22.N.IK.90 | 25.40 | 23.39 | 105.41 | | 69.85 | 5.08 |

Spare parts

| Article no. | Clamping screw | Tightening torque |
|-------------|----------------|-------------------|
| 25900 | | Nm |
| Code 6.000 | M6x7.5x15IP | 4-4.5 |

| Article no. | Torx-Plus Wrench |
|-------------|------------------|
| 25904 | |
| Code 15.000 | T15IP T-handle |

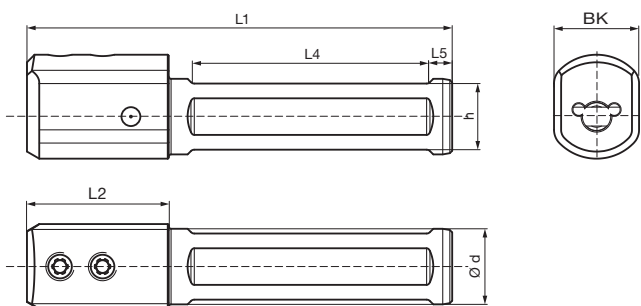


Round shank holder, clamping screw above, four clamping surfaces

- for inserts type 106
- with internal coolant supply

Type GB 106

System 106



Article no. **25320**

version left and right

| Code no. | Description | d | h | L1 | L2 | L4 | L5 | BK |
|----------|-------------------------------|-------|-------|--------|-------|-------|------|------|
| | | mm | mm | mm | mm | mm | mm | mm |
| 6.010 | GB106.0016.090.00.22.N.IK.VSP | 16.00 | 14.00 | 90.00 | 30.00 | 50.00 | 5.00 | 18.0 |
| 6.020 | GB106.0020.095.00.22.N.IK.VSP | 20.00 | 18.00 | 95.00 | 30.00 | 55.00 | 5.00 | |
| 6.030 | GB106.0022.095.00.22.N.IK.VSP | 22.00 | 20.00 | 95.00 | | 55.00 | 5.00 | |
| 6.040 | GB106.0025.100.00.22.N.IK.VSP | 25.00 | 23.00 | 100.00 | | 55.00 | 5.00 | |

Spare parts

| Article no. | Clamping screw | Tightening torque |
|-------------|----------------|-------------------|
| 25900 | | Nm |
| Code 6.000 | M6x7.5x15IP | 4-4.5 |

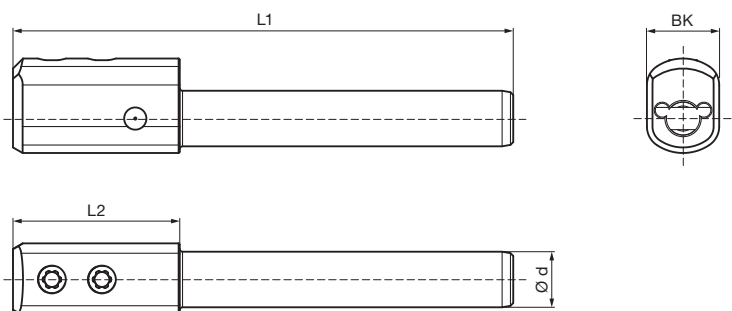
| Article no. | Torx-Plus Wrench |
|-------------|------------------|
| 25904 | |
| Code 15.000 | T15IP T-handle |



Round shank holder, clamping screw above, without clamping surfaces

- for inserts type 106
- with internal coolant supply

| | |
|------|--------|
| Type | GB 106 |
|------|--------|



System 106

Article no. **25319**
version left and right

| Code no. | Description | d | L1 | L2 | BK |
|----------|-------------------------------|-------|-------|-------|------|
| | | mm | mm | mm | mm |
| 6.010 | GB106.0010.090.00.22.N.IK.RND | 10.00 | 90.00 | 30.00 | 13.0 |
| 6.020 | GB106.0012.090.00.22.N.IK.RND | 12.00 | 90.00 | 30.00 | 14.0 |
| 6.030 | GB106.0016.090.00.22.N.IK.RND | 16.00 | 90.00 | 30.00 | 18.0 |

Spare parts

| Article no. | Clamping screw | Tightening torque |
|-------------|----------------|-------------------|
| 25900 | | Nm |
| Code 6.000 | M6x7.5x15IP | 4-4.5 |

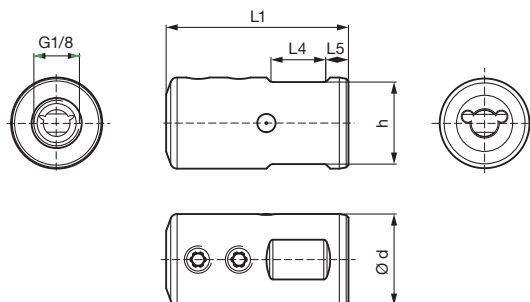
| Article no. | Torx-Plus Wrench |
|-------------|------------------|
| 25904 | |
| Code 15.000 | T15IP T-handle |

Round shank holder, clamping screw above, for Citizen machine

- for inserts type 106
- with internal coolant supply

Type GB 106

System 106



Article no. **25316**

version left and right

| Code no. | Description | d | h | L1 | L4 | L5 |
|----------|-------------------------------|-------|-------|--------|-------|------|
| | | mm | mm | mm | mm | mm |
| 6.110 | GB106.0750.040.00.22.N.IK.CIT | 19.05 | 17.05 | 40.00 | 12.70 | 5.08 |
| 6.120 | GB106.0750.050.00.22.N.IK.CIT | 19.05 | 17.05 | 50.00 | 22.86 | 5.08 |
| 6.130 | GB106.0750.070.00.22.N.IK.CIT | 19.05 | 17.05 | 70.00 | 44.45 | 5.08 |
| 6.140 | GB106.0750.100.00.22.N.IK.CIT | 19.05 | 17.05 | 100.00 | 73.66 | 5.08 |
| 6.010 | GB106.0020.040.00.22.N.IK.CIT | 20.00 | 18.00 | 40.00 | 12.00 | 5.00 |
| 6.020 | GB106.0020.050.00.22.N.IK.CIT | 20.00 | 18.00 | 50.00 | 22.00 | 5.00 |
| 6.150 | GB106.1000.060.00.22.N.IK.CIT | 25.40 | 23.40 | 60.00 | 31.75 | 5.08 |
| 6.160 | GB106.1000.100.00.22.N.IK.CIT | 25.40 | 23.40 | 100.00 | 73.66 | 5.08 |

Spare parts

| Article no. | Clamping screw | Tightening torque |
|-------------|----------------|-------------------|
| 25900 | | Nm |
| Code 6.000 | M6x7.5x15IP | 4-4.5 |

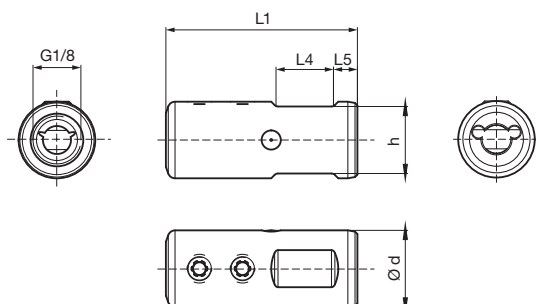
| Article no. | Torx-Plus Wrench |
|-------------|------------------|
| 25904 | |
| Code 15.000 | T15IP T-handle |



Round shank holder, clamping screw above, for Star machine

- for inserts type 106
- with internal coolant supply

Type GB 106



System 106

Article no. **25317**

version left and right

| Code no. | Description | d | h | L1 | L4 | L5 |
|----------|-------------------------------|-------|-------|--------|-------|------|
| | | mm | mm | mm | mm | mm |
| 6.010 | GB106.0016.040.00.22.N.IK.STA | 16.00 | 14.00 | 40.00 | 12.00 | 5.00 |
| 6.020 | GB106.0016.050.00.22.N.IK.STA | 16.00 | 14.00 | 50.00 | 22.00 | 5.00 |
| 6.030 | GB106.0016.070.00.22.N.IK.STA | 16.00 | 14.00 | 70.00 | 42.00 | 5.00 |
| 6.040 | GB106.0022.038.00.22.N.IK.STA | 22.00 | 20.00 | 38.00 | 10.00 | 5.00 |
| 6.050 | GB106.0022.050.00.22.N.IK.STA | 22.00 | 20.00 | 50.00 | 20.00 | 5.00 |
| 6.060 | GB106.0022.070.00.22.N.IK.STA | 22.00 | 20.00 | 70.00 | 40.00 | 5.00 |
| 6.070 | GB106.0022.100.00.22.N.IK.STA | 22.00 | 20.00 | 100.00 | 70.00 | 5.00 |
| 6.080 | GB106.0022.120.00.22.N.IK.STA | 22.00 | 20.00 | 120.00 | 90.00 | 5.00 |

Spare parts

| Article no. | Clamping screw | Tightening torque |
|-------------|----------------|-------------------|
| 25900 | | Nm |
| Code 6.000 | M6x7.5x15IP | 4-4.5 |

| Article no. | Torx-Plus Wrench |
|-------------|------------------|
| 25904 | |
| Code 15.000 | T15IP T-handle |

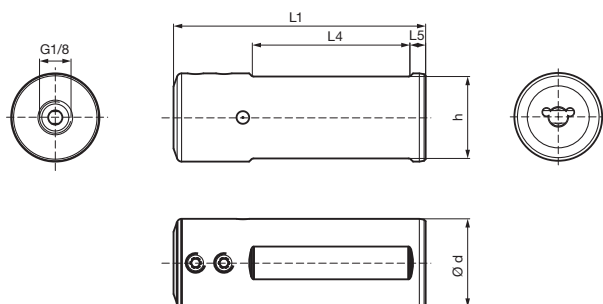


Round shank holder, clamping screw above, for Tornos machine

- for inserts type 106
- with internal coolant supply

Type GB 106

System 106



Article no. **25318**

version left and right

| Code no. | Description | d | h | L1 | L4 | L5 |
|----------|-------------------------------|-------|-------|--------|--------|------|
| | | mm | mm | mm | mm | mm |
| 6.010 | GB106.0018.310.00.22.N.IK.TOR | 18.00 | 16.00 | 310.00 | 280.00 | 5.00 |
| 6.020 | GB106.0020.170.00.22.N.IK.TOR | 20.00 | 18.00 | 170.00 | 140.00 | 5.00 |
| 6.030 | GB106.0020.185.00.22.N.IK.TOR | 20.00 | 18.00 | 185.00 | 155.00 | 5.00 |
| 6.040 | GB106.0025.100.00.22.N.IK.TOR | 25.00 | 23.00 | 100.00 | 70.00 | 5.00 |
| 6.050 | GB106.0025.150.00.22.N.IK.TOR | 25.00 | 23.00 | 150.00 | 120.00 | 5.00 |
| 6.060 | GB106.0028.080.00.22.N.IK.TOR | 28.00 | 26.00 | 80.00 | 50.00 | 5.00 |

Spare parts

| Article no. | Clamping screw | Tightening torque |
|-------------|----------------|-------------------|
| 25900 | | Nm |
| Code 6.000 | M6x7.5x15IP | 4-4.5 |

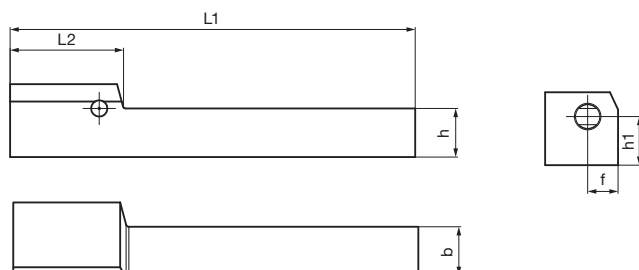
| Article no. | Torx-Plus Wrench |
|-------------|------------------|
| 25904 | |
| Code 15.000 | T15IP T-handle |



Square shank holder, straight 0°

- for inserts type 106
- without internal coolant supply

Type GH 106



Right hand version shown
Left hand version mirror image

Article no. **25314**
version right-hand

| Code no. | Description | b | h | h1 | f | L1 | L2 |
|----------|------------------------|-------|-------|-------|------|--------|-------|
| | | mm | mm | mm | mm | mm | mm |
| 6.110 | GH106.0375.350.00.22.R | 9.52 | 9.52 | 9.52 | 7.62 | 88.90 | 27.94 |
| 6.010 | GH106.1010.100.00.22.R | 10.00 | 10.00 | 10.00 | 7.50 | 100.00 | 28.00 |
| 6.020 | GH106.1212.100.00.22.R | 12.00 | 12.00 | 12.00 | 7.50 | 100.00 | 28.00 |
| 6.120 | GH106.0500.350.00.22.R | 12.70 | 12.70 | 12.70 | 7.62 | 88.90 | 27.94 |
| 6.130 | GH106.0625.400.00.22.R | 15.87 | 15.87 | 15.87 | 7.62 | 101.60 | 27.94 |
| 6.030 | GH106.1616.120.00.22.R | 16.00 | 16.00 | 16.00 | 7.50 | 120.00 | 28.00 |

Article no. **25315**
version left-hand

| Code no. | Description | b | h | h1 | f | L1 | L2 |
|----------|------------------------|-------|-------|-------|------|--------|-------|
| | | mm | mm | mm | mm | mm | mm |
| 6.110 | GH106.0375.350.00.22.L | 9.52 | 9.52 | 9.52 | 7.62 | 88.90 | 27.94 |
| 6.010 | GH106.1010.100.00.22.L | 10.00 | 10.00 | 10.00 | 7.50 | 100.00 | 28.00 |
| 6.020 | GH106.1212.100.00.22.L | 12.00 | 12.00 | 12.00 | 7.50 | 100.00 | 28.00 |
| 6.120 | GH106.0500.350.00.22.L | 12.70 | 12.70 | 12.70 | 7.62 | 88.90 | 27.94 |
| 6.130 | GH106.0625.400.00.22.L | 15.87 | 15.87 | 15.87 | 7.62 | 101.60 | 27.94 |
| 6.030 | GH106.1616.120.00.22.L | 16.00 | 16.00 | 16.00 | 7.50 | 120.00 | 28.00 |

Spare parts

| Article no. | Clamping screw | Tightening torque |
|-------------|----------------|-------------------|
| 25900 | | Nm |
| Code 6.000 | M6x7.5x15IP | 4-4.5 |

| Article no. | Torx-Plus Wrench |
|-------------|------------------|
| 25904 | |
| Code 15.000 | T15IP T-handle |

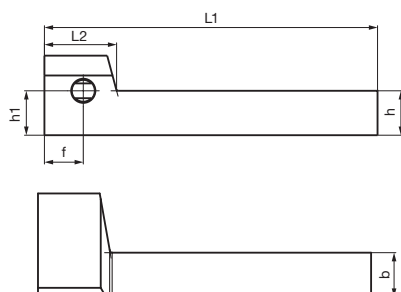
System 106



Square shank holder, 90° offset

- for inserts type 106
- without internal coolant supply

Type GH 106



Right hand version shown
Left hand version mirror image

Article no. **25304**

version right-hand

| Code no. | Description | b | h | h1 | f | L1 | L2 |
|----------|------------------------|-------|-------|-------|-------|--------|-------|
| | | mm | mm | mm | mm | mm | mm |
| 6.010 | GH106.0375.350.90.22.R | 9.52 | 9.52 | 9.52 | 22.00 | 88.90 | 19.50 |
| 6.001 | GH106.1010.090.90.22.R | 10.00 | 10.00 | 10.00 | 22.00 | 90.00 | 19.50 |
| 6.002 | GH106.1212.090.90.22.R | 12.00 | 12.00 | 12.00 | 22.00 | 90.00 | 19.50 |
| 6.011 | GH106.0500.350.90.22.R | 12.70 | 12.70 | 12.70 | 22.00 | 88.90 | 19.50 |
| 6.012 | GH106.0625.400.90.22.R | 15.87 | 15.87 | 15.87 | 22.00 | 101.60 | 19.50 |
| 6.003 | GH106.1616.120.90.22.R | 16.00 | 16.00 | 16.00 | 22.00 | 120.00 | 19.50 |

Article no. **25305**

version left-hand

| Code no. | Description | b | h | h1 | f | L1 | L2 |
|----------|------------------------|-------|-------|-------|-------|--------|-------|
| | | mm | mm | mm | mm | mm | mm |
| 6.010 | GH106.0375.350.90.22.L | 9.52 | 9.52 | 9.52 | 22.00 | 88.90 | 19.50 |
| 6.001 | GH106.1010.090.90.22.L | 10.00 | 10.00 | 10.00 | 22.00 | 90.00 | 19.50 |
| 6.002 | GH106.1212.090.90.22.L | 12.00 | 12.00 | 12.00 | 22.00 | 90.00 | 19.50 |
| 6.011 | GH106.0500.350.90.22.L | 12.70 | 12.70 | 12.70 | 22.00 | 88.90 | 19.50 |
| 6.012 | GH106.0625.400.90.22.L | 15.87 | 15.87 | 15.87 | 22.00 | 101.60 | 19.50 |
| 6.003 | GH106.1616.120.90.22.L | 16.00 | 16.00 | 16.00 | 22.00 | 120.00 | 19.50 |

Spare parts

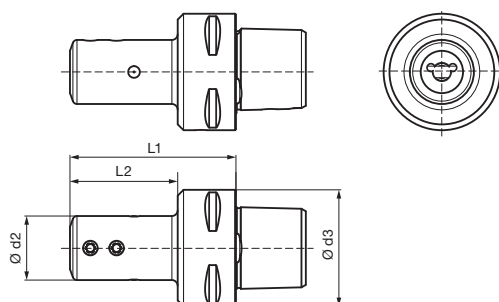
| Article no. | Clamping screw | Tightening torque |
|-------------|----------------|-------------------|
| 25900 | | Nm |
| Code 6.000 | M6x7.5x15IP | 4-4.5 |

| Article no. | Torx-Plus Wrench |
|-------------|------------------|
| 25904 | |
| Code 15.000 | T15IP T-handle |


Polygon shank holder, to ISO 26623, straight 0°

- for inserts type 106
- with internal coolant supply

| | |
|------|--------|
| Type | GH 106 |
|------|--------|



System 106

| | |
|-------------|--------------|
| Article no. | 25307 |
|-------------|--------------|

| | |
|---------|----------------|
| version | left and right |
|---------|----------------|

| Code no. | Description | d2 | d3 | L1 | L2 |
|----------|---------------------------|-------|--------|-------|-------|
| | | mm | | mm | mm |
| 6.001 | GH106.PO32.052.00.22.N.IK | 22.00 | PSC 32 | 52.00 | 37.00 |
| 6.002 | GH106.PO40.057.00.22.N.IK | 22.00 | PSC 40 | 57.00 | 37.00 |
| 6.003 | GH106.PO50.057.00.22.N.IK | 22.00 | PSC 50 | 57.00 | 37.00 |
| 6.004 | GH106.PO63.060.00.22.N.IK | 22.00 | PSC 63 | 60.00 | 38.00 |

Spare parts

| Article no. | Clamping screw | Tightening torque |
|-------------|----------------|-------------------|
| 25900 | | Nm |
| Code 6.000 | M6x7.5x15IP | 4-4.5 |

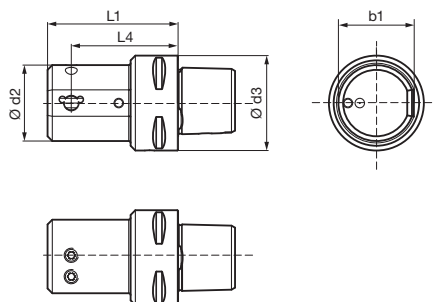
| Article no. | Torx-Plus Wrench |
|-------------|------------------|
| 25904 | |
| Code 15.000 | T15IP T-handle |



Polygon shank holder, to ISO 26623, off-set 90°

- for inserts type 106
- with internal coolant supply

Type GH 106



Right hand version shown
Left hand version mirror image

Article no. **25308**

version right-hand

| Code no. | Description | d2 | d3 | L1 | L4 | b1 |
|----------|---------------------------|-------|--------|-------|-------|-------|
| | | mm | | mm | mm | mm |
| 6.001 | GH106.PO32.045.90.22.R.IK | 32.00 | PSC 32 | 55.00 | 45.00 | 31.00 |
| 6.002 | GH106.PO40.045.90.22.R.IK | 32.00 | PSC 40 | 55.00 | 45.00 | 31.00 |
| 6.003 | GH106.PO50.050.90.22.R.IK | 32.00 | PSC 50 | 60.00 | 50.00 | 31.00 |
| 6.004 | GH106.PO63.050.90.22.R.IK | 32.00 | PSC 63 | 60.00 | 50.00 | 31.00 |

Article no. **25309**

version left-hand

| Code no. | Description | d2 | d3 | L1 | L4 | b1 |
|----------|---------------------------|-------|--------|-------|-------|-------|
| | | mm | | mm | mm | mm |
| 6.001 | GH106.PO32.045.90.22.L.IK | 32.00 | PSC 32 | 55.00 | 45.00 | 31.00 |
| 6.002 | GH106.PO40.045.90.22.L.IK | 32.00 | PSC 40 | 55.00 | 45.00 | 31.00 |
| 6.003 | GH106.PO50.050.90.22.L.IK | 32.00 | PSC 50 | 60.00 | 50.00 | 31.00 |
| 6.004 | GH106.PO63.050.90.22.L.IK | 32.00 | PSC 63 | 60.00 | 50.00 | 31.00 |

Spare parts

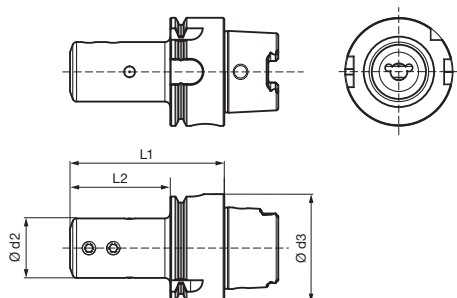
| Article no. | Clamping screw | Tightening torque |
|-------------|----------------|-------------------|
| 25900 | | Nm |
| Code 6.000 | M6x7.5x15IP | 4-4.5 |

| Article no. | Torx-Plus Wrench |
|-------------|------------------|
| 25904 | |
| Code 15.000 | T15IP T-handle |


HSK-T holder, to ISO 12164-3, straight 0°

- for inserts type 106
- with internal coolant supply

| | |
|------|--------|
| Type | GH 106 |
|------|--------|



System 106

| | |
|-------------|--------------|
| Article no. | 25311 |
|-------------|--------------|

| | |
|---------|----------------|
| version | left and right |
|---------|----------------|

| Code no. | Description | d2 | d3 | L1 | L2 |
|----------|---------------------------|-------|----------|-------|-------|
| | | mm | | mm | mm |
| 6.001 | GH106.HS40.057.00.22.N.IK | 22.00 | HSK-T 40 | 57.00 | 37.00 |
| 6.002 | GH106.HS63.063.00.22.N.IK | 22.00 | HSK-T 63 | 63.00 | 37.00 |

Spare parts

| Article no. | Clamping screw | Tightening torque |
|-------------|----------------|-------------------|
| 25900 | | Nm |
| Code 6.000 | M6x7.5x15IP | 4-4.5 |

| Article no. | Torx-Plus Wrench |
|-------------|------------------|
| 25904 | |
| Code 15.000 | T15IP T-handle |

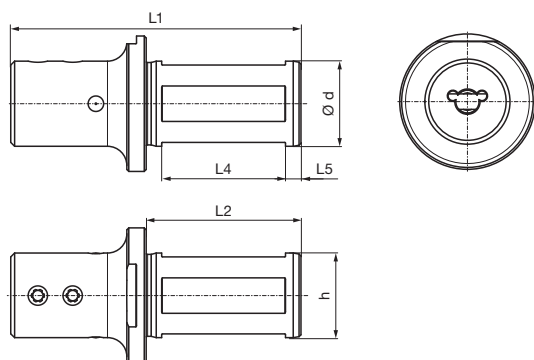


Round shank holder, 4 clamping surfaces

- for inserts type 106
- with internal coolant supply

Type GB 106

System 106



Article no. **25302**

| Code no. | Description | d | h | L1 | L2 | L4 | L5 |
|----------|---------------------------|-------|-------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm |
| 6.010 | GB106.0750.300.00.22.S.IK | 19.05 | 17.05 | 76.20 | 40.00 | 32.00 | 4.00 |
| 6.001 | GB106.0020.075.00.22.S.IK | 20.00 | 18.00 | 75.00 | 40.00 | 32.00 | 4.00 |
| 6.002 | GB106.0022.075.00.22.S.IK | 22.00 | 20.00 | 75.00 | 40.00 | 32.00 | 4.00 |
| 6.003 | GB106.0025.075.00.22.S.IK | 25.00 | 23.00 | 75.00 | 40.00 | 32.00 | 4.00 |
| 6.011 | GB106.1000.300.00.22.S.IK | 25.40 | 23.40 | 76.20 | 40.00 | 32.00 | 4.00 |

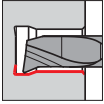
Spare parts

| Article no. | Clamping screw | Tightening torque |
|-------------|----------------|-------------------|
| 25900 | | Nm |
| Code 6.000 | M6x7.5x15IP | 4-4.5 |

| Article no. | Torx-Plus Wrench |
|-------------|------------------|
| 25904 | |
| Code 15.000 | T15IP T-handle |



Cutting insert for boring out and profiling

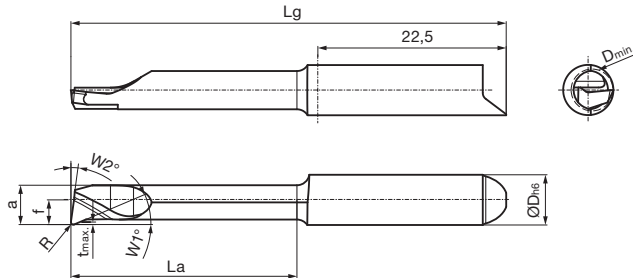


• radial free 23°

for tool holders type GH106/GB106 see from page 62

GUHRING NAVIGATOR

Cutting data page 184



Right hand version shown
Left hand version mirror image

| Tool material | Solid carbide | | |
|---------------|---------------|----------------------|----------|
| | GT 106 | GT 106 | GT 106 |
| Type | GT 106 | GT 106 | GT 106 |
| Surface | S TiN | a TiAlN-nanoA | ○ bright |



System 106

Article no. **25832** **25834** **25838**

Cutting direction **(R)** **(R)** **(R)**

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 6.010 | GT106.2347.005.12.50.R | 5.00 | 0.05 | 23 | 8 | 2.95 | 4.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.020 | GT106.2347.005.17.50.R | 5.00 | 0.05 | 23 | 8 | 2.95 | 4.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.030 | GT106.2347.005.22.50.R | 5.00 | 0.05 | 23 | 8 | 2.95 | 4.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.040 | GT106.2347.005.27.50.R | 5.00 | 0.05 | 23 | 8 | 2.95 | 4.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.050 | GT106.2347.005.32.50.R | 5.00 | 0.05 | 23 | 8 | 2.95 | 4.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.060 | GT106.2347.005.37.50.R | 5.00 | 0.05 | 23 | 8 | 2.95 | 4.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.070 | GT106.2347.005.42.50.R | 5.00 | 0.05 | 23 | 8 | 2.95 | 4.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.110 | GT106.2347.010.12.50.R | 5.00 | 0.10 | 23 | 8 | 2.95 | 4.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.120 | GT106.2347.010.17.50.R | 5.00 | 0.10 | 23 | 8 | 2.95 | 4.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.130 | GT106.2347.010.22.50.R | 5.00 | 0.10 | 23 | 8 | 2.95 | 4.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.140 | GT106.2347.010.27.50.R | 5.00 | 0.10 | 23 | 8 | 2.95 | 4.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.150 | GT106.2347.010.32.50.R | 5.00 | 0.10 | 23 | 8 | 2.95 | 4.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.160 | GT106.2347.010.37.50.R | 5.00 | 0.10 | 23 | 8 | 2.95 | 4.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.170 | GT106.2347.010.42.50.R | 5.00 | 0.10 | 23 | 8 | 2.95 | 4.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.210 | GT106.2347.015.12.50.R | 5.00 | 0.15 | 23 | 8 | 2.95 | 4.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.220 | GT106.2347.015.17.50.R | 5.00 | 0.15 | 23 | 8 | 2.95 | 4.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.230 | GT106.2347.015.22.50.R | 5.00 | 0.15 | 23 | 8 | 2.95 | 4.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.240 | GT106.2347.015.27.50.R | 5.00 | 0.15 | 23 | 8 | 2.95 | 4.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.250 | GT106.2347.015.32.50.R | 5.00 | 0.15 | 23 | 8 | 2.95 | 4.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.260 | GT106.2347.015.37.50.R | 5.00 | 0.15 | 23 | 8 | 2.95 | 4.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.270 | GT106.2347.015.42.50.R | 5.00 | 0.15 | 23 | 8 | 2.95 | 4.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.310 | GT106.2347.020.12.50.R | 5.00 | 0.20 | 23 | 8 | 2.95 | 4.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.320 | GT106.2347.020.17.50.R | 5.00 | 0.20 | 23 | 8 | 2.95 | 4.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.330 | GT106.2347.020.22.50.R | 5.00 | 0.20 | 23 | 8 | 2.95 | 4.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.340 | GT106.2347.020.27.50.R | 5.00 | 0.20 | 23 | 8 | 2.95 | 4.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.350 | GT106.2347.020.32.50.R | 5.00 | 0.20 | 23 | 8 | 2.95 | 4.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.360 | GT106.2347.020.37.50.R | 5.00 | 0.20 | 23 | 8 | 2.95 | 4.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.370 | GT106.2347.020.42.50.R | 5.00 | 0.20 | 23 | 8 | 2.95 | 4.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.410 | GT106.2347.030.12.50.R | 5.00 | 0.30 | 23 | 8 | 2.95 | 4.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.420 | GT106.2347.030.17.50.R | 5.00 | 0.30 | 23 | 8 | 2.95 | 4.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.430 | GT106.2347.030.22.50.R | 5.00 | 0.30 | 23 | 8 | 2.95 | 4.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.440 | GT106.2347.030.27.50.R | 5.00 | 0.30 | 23 | 8 | 2.95 | 4.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.450 | GT106.2347.030.32.50.R | 5.00 | 0.30 | 23 | 8 | 2.95 | 4.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.460 | GT106.2347.030.37.50.R | 5.00 | 0.30 | 23 | 8 | 2.95 | 4.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.470 | GT106.2347.030.42.50.R | 5.00 | 0.30 | 23 | 8 | 2.95 | 4.70 | 0.30 | 42.00 | 67.00 | 6.00 |



Article no. **25833** **25835** **25839**

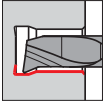
Cutting direction

System 106

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 6.010 | GT106.2347.005.12.50.L | 5.00 | 0.05 | 23 | 8 | 2.95 | 4.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.020 | GT106.2347.005.17.50.L | 5.00 | 0.05 | 23 | 8 | 2.95 | 4.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.030 | GT106.2347.005.22.50.L | 5.00 | 0.05 | 23 | 8 | 2.95 | 4.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.040 | GT106.2347.005.27.50.L | 5.00 | 0.05 | 23 | 8 | 2.95 | 4.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.050 | GT106.2347.005.32.50.L | 5.00 | 0.05 | 23 | 8 | 2.95 | 4.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.060 | GT106.2347.005.37.50.L | 5.00 | 0.05 | 23 | 8 | 2.95 | 4.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.070 | GT106.2347.005.42.50.L | 5.00 | 0.05 | 23 | 8 | 2.95 | 4.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.110 | GT106.2347.010.12.50.L | 5.00 | 0.10 | 23 | 8 | 2.95 | 4.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.120 | GT106.2347.010.17.50.L | 5.00 | 0.10 | 23 | 8 | 2.95 | 4.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.130 | GT106.2347.010.22.50.L | 5.00 | 0.10 | 23 | 8 | 2.95 | 4.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.140 | GT106.2347.010.27.50.L | 5.00 | 0.10 | 23 | 8 | 2.95 | 4.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.150 | GT106.2347.010.32.50.L | 5.00 | 0.10 | 23 | 8 | 2.95 | 4.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.160 | GT106.2347.010.37.50.L | 5.00 | 0.10 | 23 | 8 | 2.95 | 4.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.170 | GT106.2347.010.42.50.L | 5.00 | 0.10 | 23 | 8 | 2.95 | 4.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.210 | GT106.2347.015.12.50.L | 5.00 | 0.15 | 23 | 8 | 2.95 | 4.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.220 | GT106.2347.015.17.50.L | 5.00 | 0.15 | 23 | 8 | 2.95 | 4.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.230 | GT106.2347.015.22.50.L | 5.00 | 0.15 | 23 | 8 | 2.95 | 4.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.240 | GT106.2347.015.27.50.L | 5.00 | 0.15 | 23 | 8 | 2.95 | 4.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.250 | GT106.2347.015.32.50.L | 5.00 | 0.15 | 23 | 8 | 2.95 | 4.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.260 | GT106.2347.015.37.50.L | 5.00 | 0.15 | 23 | 8 | 2.95 | 4.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.270 | GT106.2347.015.42.50.L | 5.00 | 0.15 | 23 | 8 | 2.95 | 4.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.310 | GT106.2347.020.12.50.L | 5.00 | 0.20 | 23 | 8 | 2.95 | 4.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.320 | GT106.2347.020.17.50.L | 5.00 | 0.20 | 23 | 8 | 2.95 | 4.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.330 | GT106.2347.020.22.50.L | 5.00 | 0.20 | 23 | 8 | 2.95 | 4.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.340 | GT106.2347.020.27.50.L | 5.00 | 0.20 | 23 | 8 | 2.95 | 4.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.350 | GT106.2347.020.32.50.L | 5.00 | 0.20 | 23 | 8 | 2.95 | 4.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.360 | GT106.2347.020.37.50.L | 5.00 | 0.20 | 23 | 8 | 2.95 | 4.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.370 | GT106.2347.020.42.50.L | 5.00 | 0.20 | 23 | 8 | 2.95 | 4.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.410 | GT106.2347.030.12.50.L | 5.00 | 0.30 | 23 | 8 | 2.95 | 4.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.420 | GT106.2347.030.17.50.L | 5.00 | 0.30 | 23 | 8 | 2.95 | 4.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.430 | GT106.2347.030.22.50.L | 5.00 | 0.30 | 23 | 8 | 2.95 | 4.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.440 | GT106.2347.030.27.50.L | 5.00 | 0.30 | 23 | 8 | 2.95 | 4.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.450 | GT106.2347.030.32.50.L | 5.00 | 0.30 | 23 | 8 | 2.95 | 4.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.460 | GT106.2347.030.37.50.L | 5.00 | 0.30 | 23 | 8 | 2.95 | 4.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.470 | GT106.2347.030.42.50.L | 5.00 | 0.30 | 23 | 8 | 2.95 | 4.70 | 0.30 | 42.00 | 67.00 | 6.00 |



Cutting insert for boring out and profiling

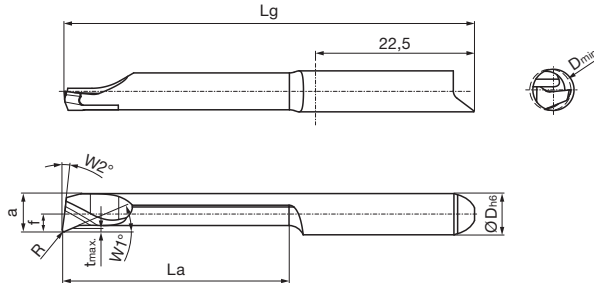


• radial free 23°

for tool holders type GH106/GB106 see from page 62

GUHRING NAVIGATOR

Cutting data page 184



Right hand version shown
Left hand version mirror image

| | | | |
|-------------------|--------------|--------------|--------------|
| Article no. | 25700 | 25702 | 25706 |
| Cutting direction | | | |

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 6.019 | GT106.2357.005.12.60.R | 6.00 | 0.05 | 23 | 8 | 2.70 | 5.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.020 | GT106.2357.005.17.60.R | 6.00 | 0.05 | 23 | 8 | 2.70 | 5.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.021 | GT106.2357.005.22.60.R | 6.00 | 0.05 | 23 | 8 | 2.70 | 5.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.022 | GT106.2357.005.27.60.R | 6.00 | 0.05 | 23 | 8 | 2.70 | 5.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.023 | GT106.2357.005.32.60.R | 6.00 | 0.05 | 23 | 8 | 2.70 | 5.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.024 | GT106.2357.005.37.60.R | 6.00 | 0.05 | 23 | 8 | 2.70 | 5.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.025 | GT106.2357.005.42.60.R | 6.00 | 0.05 | 23 | 8 | 2.70 | 5.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.026 | GT106.2357.005.47.60.R | 6.00 | 0.05 | 23 | 8 | 2.70 | 5.70 | 0.30 | 47.00 | 72.00 | 6.00 |
| 6.027 | GT106.2357.005.52.60.R | 6.00 | 0.05 | 23 | 8 | 2.70 | 5.70 | 0.30 | 52.00 | 77.00 | 6.00 |
| 6.028 | GT106.2357.010.12.60.R | 6.00 | 0.10 | 23 | 8 | 2.70 | 5.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.029 | GT106.2357.010.17.60.R | 6.00 | 0.10 | 23 | 8 | 2.70 | 5.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.030 | GT106.2357.010.22.60.R | 6.00 | 0.10 | 23 | 8 | 2.70 | 5.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.031 | GT106.2357.010.27.60.R | 6.00 | 0.10 | 23 | 8 | 2.70 | 5.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.032 | GT106.2357.010.32.60.R | 6.00 | 0.10 | 23 | 8 | 2.70 | 5.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.033 | GT106.2357.010.37.60.R | 6.00 | 0.10 | 23 | 8 | 2.70 | 5.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.034 | GT106.2357.010.42.60.R | 6.00 | 0.10 | 23 | 8 | 2.70 | 5.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.035 | GT106.2357.010.47.60.R | 6.00 | 0.10 | 23 | 8 | 2.70 | 5.70 | 0.30 | 47.00 | 72.00 | 6.00 |
| 6.036 | GT106.2357.010.52.60.R | 6.00 | 0.10 | 23 | 8 | 2.70 | 5.70 | 0.30 | 52.00 | 77.00 | 6.00 |
| 6.013 | GT106.2357.015.12.60.R | 6.00 | 0.15 | 23 | 8 | 2.70 | 5.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.014 | GT106.2357.015.17.60.R | 6.00 | 0.15 | 23 | 8 | 2.70 | 5.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.015 | GT106.2357.015.22.60.R | 6.00 | 0.15 | 23 | 8 | 2.70 | 5.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.001 | GT106.2357.015.27.60.R | 6.00 | 0.15 | 23 | 8 | 2.70 | 5.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.002 | GT106.2357.015.32.60.R | 6.00 | 0.15 | 23 | 8 | 2.70 | 5.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.003 | GT106.2357.015.37.60.R | 6.00 | 0.15 | 23 | 8 | 2.70 | 5.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.004 | GT106.2357.015.42.60.R | 6.00 | 0.15 | 23 | 8 | 2.70 | 5.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.005 | GT106.2357.015.47.60.R | 6.00 | 0.15 | 23 | 8 | 2.70 | 5.70 | 0.30 | 47.00 | 72.00 | 6.00 |
| 6.006 | GT106.2357.015.52.60.R | 6.00 | 0.15 | 23 | 8 | 2.70 | 5.70 | 0.30 | 52.00 | 77.00 | 6.00 |
| 6.037 | GT106.2357.020.12.60.R | 6.00 | 0.20 | 23 | 8 | 2.70 | 5.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.038 | GT106.2357.020.17.60.R | 6.00 | 0.20 | 23 | 8 | 2.70 | 5.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.039 | GT106.2357.020.22.60.R | 6.00 | 0.20 | 23 | 8 | 2.70 | 5.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.040 | GT106.2357.020.27.60.R | 6.00 | 0.20 | 23 | 8 | 2.70 | 5.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.041 | GT106.2357.020.32.60.R | 6.00 | 0.20 | 23 | 8 | 2.70 | 5.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.042 | GT106.2357.020.37.60.R | 6.00 | 0.20 | 23 | 8 | 2.70 | 5.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.043 | GT106.2357.020.42.60.R | 6.00 | 0.20 | 23 | 8 | 2.70 | 5.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.044 | GT106.2357.020.47.60.R | 6.00 | 0.20 | 23 | 8 | 2.70 | 5.70 | 0.30 | 47.00 | 72.00 | 6.00 |
| 6.045 | GT106.2357.020.52.60.R | 6.00 | 0.20 | 23 | 8 | 2.70 | 5.70 | 0.30 | 52.00 | 77.00 | 6.00 |
| 6.046 | GT106.2357.025.12.60.R | 6.00 | 0.25 | 23 | 8 | 2.70 | 5.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.047 | GT106.2357.025.17.60.R | 6.00 | 0.25 | 23 | 8 | 2.70 | 5.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.048 | GT106.2357.025.22.60.R | 6.00 | 0.25 | 23 | 8 | 2.70 | 5.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.049 | GT106.2357.025.27.60.R | 6.00 | 0.25 | 23 | 8 | 2.70 | 5.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.050 | GT106.2357.025.32.60.R | 6.00 | 0.25 | 23 | 8 | 2.70 | 5.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.051 | GT106.2357.025.37.60.R | 6.00 | 0.25 | 23 | 8 | 2.70 | 5.70 | 0.30 | 37.00 | 62.00 | 6.00 |

System 106



System 106

Article no. **25700** **25702** **25706**

Cutting direction

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 6.052 | GT106.2357.025.42.60.R | 6.00 | 0.25 | 23 | 8 | 2.70 | 5.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.053 | GT106.2357.025.47.60.R | 6.00 | 0.25 | 23 | 8 | 2.70 | 5.70 | 0.30 | 47.00 | 72.00 | 6.00 |
| 6.054 | GT106.2357.025.52.60.R | 6.00 | 0.25 | 23 | 8 | 2.70 | 5.70 | 0.30 | 52.00 | 77.00 | 6.00 |
| 6.016 | GT106.2357.030.12.60.R | 6.00 | 0.30 | 23 | 8 | 2.70 | 5.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.017 | GT106.2357.030.17.60.R | 6.00 | 0.30 | 23 | 8 | 2.70 | 5.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.018 | GT106.2357.030.22.60.R | 6.00 | 0.30 | 23 | 8 | 2.70 | 5.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.007 | GT106.2357.030.27.60.R | 6.00 | 0.30 | 23 | 8 | 2.70 | 5.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.008 | GT106.2357.030.32.60.R | 6.00 | 0.30 | 23 | 8 | 2.70 | 5.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.009 | GT106.2357.030.37.60.R | 6.00 | 0.30 | 23 | 8 | 2.70 | 5.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.010 | GT106.2357.030.42.60.R | 6.00 | 0.30 | 23 | 8 | 2.70 | 5.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.011 | GT106.2357.030.47.60.R | 6.00 | 0.30 | 23 | 8 | 2.70 | 5.70 | 0.30 | 47.00 | 72.00 | 6.00 |
| 6.012 | GT106.2357.030.52.60.R | 6.00 | 0.30 | 23 | 8 | 2.70 | 5.70 | 0.30 | 52.00 | 77.00 | 6.00 |

Article no. **25701** **25703** **25707**

Cutting direction

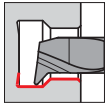
| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 6.019 | GT106.2357.005.12.60.L | 6.00 | 0.05 | 23 | 8 | 2.70 | 5.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.020 | GT106.2357.005.17.60.L | 6.00 | 0.05 | 23 | 8 | 2.70 | 5.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.021 | GT106.2357.005.22.60.L | 6.00 | 0.05 | 23 | 8 | 2.70 | 5.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.022 | GT106.2357.005.27.60.L | 6.00 | 0.05 | 23 | 8 | 2.70 | 5.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.023 | GT106.2357.005.32.60.L | 6.00 | 0.05 | 23 | 8 | 2.70 | 5.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.024 | GT106.2357.005.37.60.L | 6.00 | 0.05 | 23 | 8 | 2.70 | 5.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.025 | GT106.2357.005.42.60.L | 6.00 | 0.05 | 23 | 8 | 2.70 | 5.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.026 | GT106.2357.005.47.60.L | 6.00 | 0.05 | 23 | 8 | 2.70 | 5.70 | 0.30 | 47.00 | 72.00 | 6.00 |
| 6.027 | GT106.2357.005.52.60.L | 6.00 | 0.05 | 23 | 8 | 2.70 | 5.70 | 0.30 | 52.00 | 77.00 | 6.00 |
| 6.028 | GT106.2357.010.12.60.L | 6.00 | 0.10 | 23 | 8 | 2.70 | 5.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.029 | GT106.2357.010.17.60.L | 6.00 | 0.10 | 23 | 8 | 2.70 | 5.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.030 | GT106.2357.010.22.60.L | 6.00 | 0.10 | 23 | 8 | 2.70 | 5.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.031 | GT106.2357.010.27.60.L | 6.00 | 0.10 | 23 | 8 | 2.70 | 5.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.032 | GT106.2357.010.32.60.L | 6.00 | 0.10 | 23 | 8 | 2.70 | 5.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.033 | GT106.2357.010.37.60.L | 6.00 | 0.10 | 23 | 8 | 2.70 | 5.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.034 | GT106.2357.010.42.60.L | 6.00 | 0.10 | 23 | 8 | 2.70 | 5.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.035 | GT106.2357.010.47.60.L | 6.00 | 0.10 | 23 | 8 | 2.70 | 5.70 | 0.30 | 47.00 | 72.00 | 6.00 |
| 6.036 | GT106.2357.010.52.60.L | 6.00 | 0.10 | 23 | 8 | 2.70 | 5.70 | 0.30 | 52.00 | 77.00 | 6.00 |
| 6.013 | GT106.2357.015.12.60.L | 6.00 | 0.15 | 23 | 8 | 2.70 | 5.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.014 | GT106.2357.015.17.60.L | 6.00 | 0.15 | 23 | 8 | 2.70 | 5.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.015 | GT106.2357.015.22.60.L | 6.00 | 0.15 | 23 | 8 | 2.70 | 5.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.001 | GT106.2357.015.27.60.L | 6.00 | 0.15 | 23 | 8 | 2.70 | 5.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.002 | GT106.2357.015.32.60.L | 6.00 | 0.15 | 23 | 8 | 2.70 | 5.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.003 | GT106.2357.015.37.60.L | 6.00 | 0.15 | 23 | 8 | 2.70 | 5.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.004 | GT106.2357.015.42.60.L | 6.00 | 0.15 | 23 | 8 | 2.70 | 5.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.005 | GT106.2357.015.47.60.L | 6.00 | 0.15 | 23 | 8 | 2.70 | 5.70 | 0.30 | 47.00 | 72.00 | 6.00 |
| 6.006 | GT106.2357.015.52.60.L | 6.00 | 0.15 | 23 | 8 | 2.70 | 5.70 | 0.30 | 52.00 | 77.00 | 6.00 |
| 6.037 | GT106.2357.020.12.60.L | 6.00 | 0.20 | 23 | 8 | 2.70 | 5.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.038 | GT106.2357.020.17.60.L | 6.00 | 0.20 | 23 | 8 | 2.70 | 5.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.039 | GT106.2357.020.22.60.L | 6.00 | 0.20 | 23 | 8 | 2.70 | 5.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.040 | GT106.2357.020.27.60.L | 6.00 | 0.20 | 23 | 8 | 2.70 | 5.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.041 | GT106.2357.020.32.60.L | 6.00 | 0.20 | 23 | 8 | 2.70 | 5.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.042 | GT106.2357.020.37.60.L | 6.00 | 0.20 | 23 | 8 | 2.70 | 5.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.043 | GT106.2357.020.42.60.L | 6.00 | 0.20 | 23 | 8 | 2.70 | 5.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.044 | GT106.2357.020.47.60.L | 6.00 | 0.20 | 23 | 8 | 2.70 | 5.70 | 0.30 | 47.00 | 72.00 | 6.00 |
| 6.045 | GT106.2357.020.52.60.L | 6.00 | 0.20 | 23 | 8 | 2.70 | 5.70 | 0.30 | 52.00 | 77.00 | 6.00 |
| 6.046 | GT106.2357.025.12.60.L | 6.00 | 0.25 | 23 | 8 | 2.70 | 5.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.047 | GT106.2357.025.17.60.L | 6.00 | 0.25 | 23 | 8 | 2.70 | 5.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.048 | GT106.2357.025.22.60.L | 6.00 | 0.25 | 23 | 8 | 2.70 | 5.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.049 | GT106.2357.025.27.60.L | 6.00 | 0.25 | 23 | 8 | 2.70 | 5.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.050 | GT106.2357.025.32.60.L | 6.00 | 0.25 | 23 | 8 | 2.70 | 5.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.051 | GT106.2357.025.37.60.L | 6.00 | 0.25 | 23 | 8 | 2.70 | 5.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.052 | GT106.2357.025.42.60.L | 6.00 | 0.25 | 23 | 8 | 2.70 | 5.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.053 | GT106.2357.025.47.60.L | 6.00 | 0.25 | 23 | 8 | 2.70 | 5.70 | 0.30 | 47.00 | 72.00 | 6.00 |
| 6.054 | GT106.2357.025.52.60.L | 6.00 | 0.25 | 23 | 8 | 2.70 | 5.70 | 0.30 | 52.00 | 77.00 | 6.00 |
| 6.016 | GT106.2357.030.12.60.L | 6.00 | 0.30 | 23 | 8 | 2.70 | 5.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.017 | GT106.2357.030.17.60.L | 6.00 | 0.30 | 23 | 8 | 2.70 | 5.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.018 | GT106.2357.030.22.60.L | 6.00 | 0.30 | 23 | 8 | 2.70 | 5.70 | 0.30 | 22.00 | 47.00 | 6.00 |

Article no. **25701** **25703** **25707**Cutting direction   

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 6.007 | GT106.2357.030.27.60.L | 6.00 | 0.30 | 23 | 8 | 2.70 | 5.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.008 | GT106.2357.030.32.60.L | 6.00 | 0.30 | 23 | 8 | 2.70 | 5.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.009 | GT106.2357.030.37.60.L | 6.00 | 0.30 | 23 | 8 | 2.70 | 5.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.010 | GT106.2357.030.42.60.L | 6.00 | 0.30 | 23 | 8 | 2.70 | 5.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.011 | GT106.2357.030.47.60.L | 6.00 | 0.30 | 23 | 8 | 2.70 | 5.70 | 0.30 | 47.00 | 72.00 | 6.00 |
| 6.012 | GT106.2357.030.52.60.L | 6.00 | 0.30 | 23 | 8 | 2.70 | 5.70 | 0.30 | 52.00 | 77.00 | 6.00 |

System 106

Cutting insert for boring out and profiling



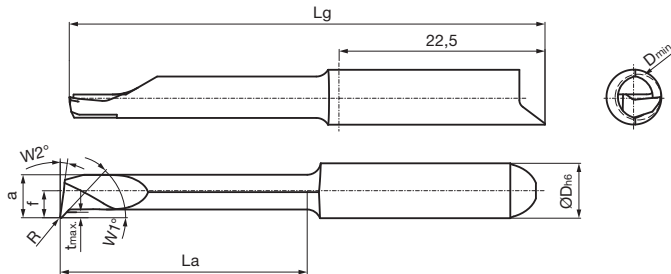
• radial free 47°, tmax 0.6

for tool holders type GH106/GB106 see from page 62

GUHRING NAVIGATOR

Cutting data page 184

System 106



Right hand version shown
Left hand version mirror image



| Tool material | Solid carbide | | |
|---------------|---------------|-------------|--------|
| | GT 106 | GT 106 | GT 106 |
| Type | | | |
| Surface | S | a | ○ |
| | TiN | TiAlN-nanoA | bright |

Article no. **25840** **25842** **25846**

Cutting direction **(R)** **(R)** **(R)**

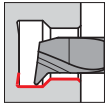
| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 6.010 | GT106.4747.005.12.50.R | 5.00 | 0.05 | 47 | 8 | 2.95 | 4.70 | 0.60 | 12.00 | 37.00 | 6.00 |
| 6.020 | GT106.4747.005.17.50.R | 5.00 | 0.05 | 47 | 8 | 2.95 | 4.70 | 0.60 | 17.00 | 42.00 | 6.00 |
| 6.030 | GT106.4747.005.22.50.R | 5.00 | 0.05 | 47 | 8 | 2.95 | 4.70 | 0.60 | 22.00 | 47.00 | 6.00 |
| 6.040 | GT106.4747.005.27.50.R | 5.00 | 0.05 | 47 | 8 | 2.95 | 4.70 | 0.60 | 27.00 | 52.00 | 6.00 |
| 6.050 | GT106.4747.005.32.50.R | 5.00 | 0.05 | 47 | 8 | 2.95 | 4.70 | 0.60 | 32.00 | 57.00 | 6.00 |
| 6.060 | GT106.4747.005.37.50.R | 5.00 | 0.05 | 47 | 8 | 2.95 | 4.70 | 0.60 | 37.00 | 62.00 | 6.00 |
| 6.070 | GT106.4747.010.12.50.R | 5.00 | 0.05 | 47 | 8 | 2.95 | 4.70 | 0.60 | 42.00 | 67.00 | 6.00 |
| 6.110 | GT106.4747.010.12.50.R | 5.00 | 0.10 | 47 | 8 | 2.95 | 4.70 | 0.60 | 12.00 | 37.00 | 6.00 |
| 6.120 | GT106.4747.010.17.50.R | 5.00 | 0.10 | 47 | 8 | 2.95 | 4.70 | 0.60 | 17.00 | 42.00 | 6.00 |
| 6.130 | GT106.4747.010.22.50.R | 5.00 | 0.10 | 47 | 8 | 2.95 | 4.70 | 0.60 | 22.00 | 47.00 | 6.00 |
| 6.140 | GT106.4747.010.27.50.R | 5.00 | 0.10 | 47 | 8 | 2.95 | 4.70 | 0.60 | 27.00 | 52.00 | 6.00 |
| 6.150 | GT106.4747.010.32.50.R | 5.00 | 0.10 | 47 | 8 | 2.95 | 4.70 | 0.60 | 32.00 | 57.00 | 6.00 |
| 6.160 | GT106.4747.010.37.50.R | 5.00 | 0.10 | 47 | 8 | 2.95 | 4.70 | 0.60 | 37.00 | 62.00 | 6.00 |
| 6.170 | GT106.4747.010.42.50.R | 5.00 | 0.10 | 47 | 8 | 2.95 | 4.70 | 0.60 | 42.00 | 67.00 | 6.00 |
| 6.210 | GT106.4747.015.12.50.R | 5.00 | 0.15 | 47 | 8 | 2.95 | 4.70 | 0.60 | 12.00 | 37.00 | 6.00 |
| 6.220 | GT106.4747.015.17.50.R | 5.00 | 0.15 | 47 | 8 | 2.95 | 4.70 | 0.60 | 17.00 | 42.00 | 6.00 |
| 6.230 | GT106.4747.015.22.50.R | 5.00 | 0.15 | 47 | 8 | 2.95 | 4.70 | 0.60 | 22.00 | 47.00 | 6.00 |
| 6.240 | GT106.4747.015.27.50.R | 5.00 | 0.15 | 47 | 8 | 2.95 | 4.70 | 0.60 | 27.00 | 52.00 | 6.00 |
| 6.250 | GT106.4747.015.32.50.R | 5.00 | 0.15 | 47 | 8 | 2.95 | 4.70 | 0.60 | 32.00 | 57.00 | 6.00 |
| 6.260 | GT106.4747.015.37.50.R | 5.00 | 0.15 | 47 | 8 | 2.95 | 4.70 | 0.60 | 37.00 | 62.00 | 6.00 |
| 6.270 | GT106.4747.015.42.50.R | 5.00 | 0.15 | 47 | 8 | 2.95 | 4.70 | 0.60 | 42.00 | 67.00 | 6.00 |
| 6.310 | GT106.4747.020.12.50.R | 5.00 | 0.20 | 47 | 8 | 2.95 | 4.70 | 0.60 | 12.00 | 37.00 | 6.00 |
| 6.320 | GT106.4747.020.17.50.R | 5.00 | 0.20 | 47 | 8 | 2.95 | 4.70 | 0.60 | 17.00 | 42.00 | 6.00 |
| 6.330 | GT106.4747.020.22.50.R | 5.00 | 0.20 | 47 | 8 | 2.95 | 4.70 | 0.60 | 22.00 | 47.00 | 6.00 |
| 6.340 | GT106.4747.020.27.50.R | 5.00 | 0.20 | 47 | 8 | 2.95 | 4.70 | 0.60 | 27.00 | 52.00 | 6.00 |
| 6.350 | GT106.4747.020.32.50.R | 5.00 | 0.20 | 47 | 8 | 2.95 | 4.70 | 0.60 | 32.00 | 57.00 | 6.00 |
| 6.360 | GT106.4747.020.37.50.R | 5.00 | 0.20 | 47 | 8 | 2.95 | 4.70 | 0.60 | 37.00 | 62.00 | 6.00 |
| 6.370 | GT106.4747.020.42.50.R | 5.00 | 0.20 | 47 | 8 | 2.95 | 4.70 | 0.60 | 42.00 | 67.00 | 6.00 |
| 6.410 | GT106.4747.030.12.50.R | 5.00 | 0.30 | 47 | 8 | 2.95 | 4.70 | 0.60 | 12.00 | 37.00 | 6.00 |
| 6.420 | GT106.4747.030.17.50.R | 5.00 | 0.30 | 47 | 8 | 2.95 | 4.70 | 0.60 | 17.00 | 42.00 | 6.00 |
| 6.430 | GT106.4747.030.22.50.R | 5.00 | 0.30 | 47 | 8 | 2.95 | 4.70 | 0.60 | 22.00 | 47.00 | 6.00 |
| 6.440 | GT106.4747.030.27.50.R | 5.00 | 0.30 | 47 | 8 | 2.95 | 4.70 | 0.60 | 27.00 | 52.00 | 6.00 |
| 6.450 | GT106.4747.030.32.50.R | 5.00 | 0.30 | 47 | 8 | 2.95 | 4.70 | 0.60 | 32.00 | 57.00 | 6.00 |
| 6.460 | GT106.4747.030.37.50.R | 5.00 | 0.30 | 47 | 8 | 2.95 | 4.70 | 0.60 | 37.00 | 62.00 | 6.00 |
| 6.470 | GT106.4747.030.42.50.R | 5.00 | 0.30 | 47 | 8 | 2.95 | 4.70 | 0.60 | 42.00 | 67.00 | 6.00 |

Article no. **25841** **25843** **25847**Cutting direction   

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 6.010 | GT106.4747.005.12.50.L | 5.00 | 0.05 | 47 | 8 | 2.95 | 4.70 | 0.60 | 12.00 | 37.00 | 6.00 |
| 6.020 | GT106.4747.005.17.50.L | 5.00 | 0.05 | 47 | 8 | 2.95 | 4.70 | 0.60 | 17.00 | 42.00 | 6.00 |
| 6.030 | GT106.4747.005.22.50.L | 5.00 | 0.05 | 47 | 8 | 2.95 | 4.70 | 0.60 | 22.00 | 47.00 | 6.00 |
| 6.040 | GT106.4747.005.27.50.L | 5.00 | 0.05 | 47 | 8 | 2.95 | 4.70 | 0.60 | 27.00 | 52.00 | 6.00 |
| 6.050 | GT106.4747.005.32.50.L | 5.00 | 0.05 | 47 | 8 | 2.95 | 4.70 | 0.60 | 32.00 | 57.00 | 6.00 |
| 6.060 | GT106.4747.005.37.50.L | 5.00 | 0.05 | 47 | 8 | 2.95 | 4.70 | 0.60 | 37.00 | 62.00 | 6.00 |
| 6.070 | GT106.4747.005.42.50.L | 5.00 | 0.05 | 47 | 8 | 2.95 | 4.70 | 0.60 | 42.00 | 67.00 | 6.00 |
| 6.110 | GT106.4747.010.12.50.L | 5.00 | 0.10 | 47 | 8 | 2.95 | 4.70 | 0.60 | 12.00 | 37.00 | 6.00 |
| 6.120 | GT106.4747.010.17.50.L | 5.00 | 0.10 | 47 | 8 | 2.95 | 4.70 | 0.60 | 17.00 | 42.00 | 6.00 |
| 6.130 | GT106.4747.010.22.50.L | 5.00 | 0.10 | 47 | 8 | 2.95 | 4.70 | 0.60 | 22.00 | 47.00 | 6.00 |
| 6.140 | GT106.4747.010.27.50.L | 5.00 | 0.10 | 47 | 8 | 2.95 | 4.70 | 0.60 | 27.00 | 52.00 | 6.00 |
| 6.150 | GT106.4747.010.32.50.L | 5.00 | 0.10 | 47 | 8 | 2.95 | 4.70 | 0.60 | 32.00 | 57.00 | 6.00 |
| 6.160 | GT106.4747.010.37.50.L | 5.00 | 0.10 | 47 | 8 | 2.95 | 4.70 | 0.60 | 37.00 | 62.00 | 6.00 |
| 6.170 | GT106.4747.010.42.50.L | 5.00 | 0.10 | 47 | 8 | 2.95 | 4.70 | 0.60 | 42.00 | 67.00 | 6.00 |
| 6.210 | GT106.4747.015.12.50.L | 5.00 | 0.15 | 47 | 8 | 2.95 | 4.70 | 0.60 | 12.00 | 37.00 | 6.00 |
| 6.220 | GT106.4747.015.17.50.L | 5.00 | 0.15 | 47 | 8 | 2.95 | 4.70 | 0.60 | 17.00 | 42.00 | 6.00 |
| 6.230 | GT106.4747.015.22.50.L | 5.00 | 0.15 | 47 | 8 | 2.95 | 4.70 | 0.60 | 22.00 | 47.00 | 6.00 |
| 6.240 | GT106.4747.015.27.50.L | 5.00 | 0.15 | 47 | 8 | 2.95 | 4.70 | 0.60 | 27.00 | 52.00 | 6.00 |
| 6.250 | GT106.4747.015.32.50.L | 5.00 | 0.15 | 47 | 8 | 2.95 | 4.70 | 0.60 | 32.00 | 57.00 | 6.00 |
| 6.260 | GT106.4747.015.37.50.L | 5.00 | 0.15 | 47 | 8 | 2.95 | 4.70 | 0.60 | 37.00 | 62.00 | 6.00 |
| 6.270 | GT106.4747.015.42.50.L | 5.00 | 0.15 | 47 | 8 | 2.95 | 4.70 | 0.60 | 42.00 | 67.00 | 6.00 |
| 6.310 | GT106.4747.020.12.50.L | 5.00 | 0.20 | 47 | 8 | 2.95 | 4.70 | 0.60 | 12.00 | 37.00 | 6.00 |
| 6.320 | GT106.4747.020.17.50.L | 5.00 | 0.20 | 47 | 8 | 2.95 | 4.70 | 0.60 | 17.00 | 42.00 | 6.00 |
| 6.330 | GT106.4747.020.22.50.L | 5.00 | 0.20 | 47 | 8 | 2.95 | 4.70 | 0.60 | 22.00 | 47.00 | 6.00 |
| 6.340 | GT106.4747.020.27.50.L | 5.00 | 0.20 | 47 | 8 | 2.95 | 4.70 | 0.60 | 27.00 | 52.00 | 6.00 |
| 6.350 | GT106.4747.020.32.50.L | 5.00 | 0.20 | 47 | 8 | 2.95 | 4.70 | 0.60 | 32.00 | 57.00 | 6.00 |
| 6.360 | GT106.4747.020.37.50.L | 5.00 | 0.20 | 47 | 8 | 2.95 | 4.70 | 0.60 | 37.00 | 62.00 | 6.00 |
| 6.370 | GT106.4747.020.42.50.L | 5.00 | 0.20 | 47 | 8 | 2.95 | 4.70 | 0.60 | 42.00 | 67.00 | 6.00 |
| 6.410 | GT106.4747.030.12.50.L | 5.00 | 0.30 | 47 | 8 | 2.95 | 4.70 | 0.60 | 12.00 | 37.00 | 6.00 |
| 6.420 | GT106.4747.030.17.50.L | 5.00 | 0.30 | 47 | 8 | 2.95 | 4.70 | 0.60 | 17.00 | 42.00 | 6.00 |
| 6.430 | GT106.4747.030.22.50.L | 5.00 | 0.30 | 47 | 8 | 2.95 | 4.70 | 0.60 | 22.00 | 47.00 | 6.00 |
| 6.440 | GT106.4747.030.27.50.L | 5.00 | 0.30 | 47 | 8 | 2.95 | 4.70 | 0.60 | 27.00 | 52.00 | 6.00 |
| 6.450 | GT106.4747.030.32.50.L | 5.00 | 0.30 | 47 | 8 | 2.95 | 4.70 | 0.60 | 32.00 | 57.00 | 6.00 |
| 6.460 | GT106.4747.030.37.50.L | 5.00 | 0.30 | 47 | 8 | 2.95 | 4.70 | 0.60 | 37.00 | 62.00 | 6.00 |
| 6.470 | GT106.4747.030.42.50.L | 5.00 | 0.30 | 47 | 8 | 2.95 | 4.70 | 0.60 | 42.00 | 67.00 | 6.00 |

System 106

Cutting insert for boring out and profiling



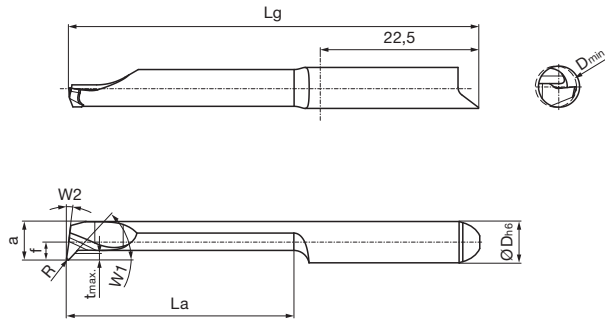
• radial free 47°, tmax 0.8

for tool holders type GH106/GB106 see from page 62

GUHRING NAVIGATOR

Cutting data page 184

System 106



Right hand version shown
Left hand version mirror image

| Tool material | Solid carbide | | |
|---------------|---------------|-------------|--------|
| | GT 106 | GT 106 | GT 106 |
| Type | | | |
| Surface | S | a | ○ |
| | TiN | TiAlN-nanoA | bright |



| Article no. | 25708 | 25710 | 25714 |
|-------------------|------------|------------|------------|
| Cutting direction | (R) | (R) | (R) |

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 6.019 | GT106.4757.005.12.60.R | 6.00 | 0.05 | 47 | 8 | 2.70 | 5.70 | 0.60 | 12.00 | 37.00 | 6.00 |
| 6.020 | GT106.4757.005.17.60.R | 6.00 | 0.05 | 47 | 8 | 2.70 | 5.70 | 0.60 | 17.00 | 42.00 | 6.00 |
| 6.021 | GT106.4757.005.22.60.R | 6.00 | 0.05 | 47 | 8 | 2.70 | 5.70 | 0.60 | 22.00 | 47.00 | 6.00 |
| 6.022 | GT106.4757.005.27.60.R | 6.00 | 0.05 | 47 | 8 | 2.70 | 5.70 | 0.60 | 27.00 | 52.00 | 6.00 |
| 6.023 | GT106.4757.005.32.60.R | 6.00 | 0.05 | 47 | 8 | 2.70 | 5.70 | 0.60 | 32.00 | 57.00 | 6.00 |
| 6.024 | GT106.4757.005.37.60.R | 6.00 | 0.05 | 47 | 8 | 2.70 | 5.70 | 0.60 | 37.00 | 62.00 | 6.00 |
| 6.025 | GT106.4757.005.42.60.R | 6.00 | 0.05 | 47 | 8 | 2.70 | 5.70 | 0.60 | 42.00 | 67.00 | 6.00 |
| 6.026 | GT106.4757.005.47.60.R | 6.00 | 0.05 | 47 | 8 | 2.70 | 5.70 | 0.60 | 47.00 | 72.00 | 6.00 |
| 6.027 | GT106.4757.005.52.60.R | 6.00 | 0.05 | 47 | 8 | 2.70 | 5.70 | 0.60 | 52.00 | 77.00 | 6.00 |
| 6.028 | GT106.4757.010.12.60.R | 6.00 | 0.10 | 47 | 8 | 2.70 | 5.70 | 0.60 | 12.00 | 37.00 | 6.00 |
| 6.029 | GT106.4757.010.17.60.R | 6.00 | 0.10 | 47 | 8 | 2.70 | 5.70 | 0.60 | 17.00 | 42.00 | 6.00 |
| 6.030 | GT106.4757.010.22.60.R | 6.00 | 0.10 | 47 | 8 | 2.70 | 5.70 | 0.60 | 22.00 | 47.00 | 6.00 |
| 6.031 | GT106.4757.010.27.60.R | 6.00 | 0.10 | 47 | 8 | 2.70 | 5.70 | 0.60 | 27.00 | 52.00 | 6.00 |
| 6.032 | GT106.4757.010.32.60.R | 6.00 | 0.10 | 47 | 8 | 2.70 | 5.70 | 0.60 | 32.00 | 57.00 | 6.00 |
| 6.033 | GT106.4757.010.37.60.R | 6.00 | 0.10 | 47 | 8 | 2.70 | 5.70 | 0.60 | 37.00 | 62.00 | 6.00 |
| 6.034 | GT106.4757.010.42.60.R | 6.00 | 0.10 | 47 | 8 | 2.70 | 5.70 | 0.60 | 42.00 | 67.00 | 6.00 |
| 6.035 | GT106.4757.010.47.60.R | 6.00 | 0.10 | 47 | 8 | 2.70 | 5.70 | 0.60 | 47.00 | 72.00 | 6.00 |
| 6.036 | GT106.4757.010.52.60.R | 6.00 | 0.10 | 47 | 8 | 2.70 | 5.70 | 0.60 | 52.00 | 77.00 | 6.00 |
| 6.013 | GT106.4757.015.12.60.R | 6.00 | 0.15 | 47 | 8 | 2.70 | 5.70 | 0.60 | 12.00 | 37.00 | 6.00 |
| 6.014 | GT106.4757.015.17.60.R | 6.00 | 0.15 | 47 | 8 | 2.70 | 5.70 | 0.60 | 17.00 | 42.00 | 6.00 |
| 6.015 | GT106.4757.015.22.60.R | 6.00 | 0.15 | 47 | 8 | 2.70 | 5.70 | 0.60 | 22.00 | 47.00 | 6.00 |
| 6.001 | GT106.4757.015.27.60.R | 6.00 | 0.15 | 47 | 8 | 2.70 | 5.70 | 0.60 | 27.00 | 52.00 | 6.00 |
| 6.002 | GT106.4757.015.32.60.R | 6.00 | 0.15 | 47 | 8 | 2.70 | 5.70 | 0.60 | 32.00 | 57.00 | 6.00 |
| 6.003 | GT106.4757.015.37.60.R | 6.00 | 0.15 | 47 | 8 | 2.70 | 5.70 | 0.60 | 37.00 | 62.00 | 6.00 |
| 6.004 | GT106.4757.015.42.60.R | 6.00 | 0.15 | 47 | 8 | 2.70 | 5.70 | 0.60 | 42.00 | 67.00 | 6.00 |
| 6.005 | GT106.4757.015.47.60.R | 6.00 | 0.15 | 47 | 8 | 2.70 | 5.70 | 0.60 | 47.00 | 72.00 | 6.00 |
| 6.006 | GT106.4757.015.52.60.R | 6.00 | 0.15 | 47 | 8 | 2.70 | 5.70 | 0.60 | 52.00 | 77.00 | 6.00 |
| 6.037 | GT106.4757.020.12.60.R | 6.00 | 0.20 | 47 | 8 | 2.70 | 5.70 | 0.60 | 12.00 | 37.00 | 6.00 |
| 6.038 | GT106.4757.020.17.60.R | 6.00 | 0.20 | 47 | 8 | 2.70 | 5.70 | 0.60 | 17.00 | 42.00 | 6.00 |
| 6.039 | GT106.4757.020.22.60.R | 6.00 | 0.20 | 47 | 8 | 2.70 | 5.70 | 0.60 | 22.00 | 47.00 | 6.00 |
| 6.040 | GT106.4757.020.27.60.R | 6.00 | 0.20 | 47 | 8 | 2.70 | 5.70 | 0.60 | 27.00 | 52.00 | 6.00 |
| 6.041 | GT106.4757.020.32.60.R | 6.00 | 0.20 | 47 | 8 | 2.70 | 5.70 | 0.60 | 32.00 | 57.00 | 6.00 |
| 6.042 | GT106.4757.020.37.60.R | 6.00 | 0.20 | 47 | 8 | 2.70 | 5.70 | 0.60 | 37.00 | 62.00 | 6.00 |
| 6.043 | GT106.4757.020.42.60.R | 6.00 | 0.20 | 47 | 8 | 2.70 | 5.70 | 0.60 | 42.00 | 67.00 | 6.00 |
| 6.044 | GT106.4757.020.47.60.R | 6.00 | 0.20 | 47 | 8 | 2.70 | 5.70 | 0.60 | 47.00 | 72.00 | 6.00 |
| 6.045 | GT106.4757.020.52.60.R | 6.00 | 0.20 | 47 | 8 | 2.70 | 5.70 | 0.60 | 52.00 | 77.00 | 6.00 |
| 6.016 | GT106.4757.030.12.60.R | 6.00 | 0.30 | 47 | 8 | 2.70 | 5.70 | 0.60 | 12.00 | 37.00 | 6.00 |
| 6.017 | GT106.4757.030.17.60.R | 6.00 | 0.30 | 47 | 8 | 2.70 | 5.70 | 0.60 | 17.00 | 42.00 | 6.00 |
| 6.018 | GT106.4757.030.22.60.R | 6.00 | 0.30 | 47 | 8 | 2.70 | 5.70 | 0.60 | 22.00 | 47.00 | 6.00 |
| 6.007 | GT106.4757.030.27.60.R | 6.00 | 0.30 | 47 | 8 | 2.70 | 5.70 | 0.60 | 27.00 | 52.00 | 6.00 |
| 6.008 | GT106.4757.030.32.60.R | 6.00 | 0.30 | 47 | 8 | 2.70 | 5.70 | 0.60 | 32.00 | 57.00 | 6.00 |
| 6.009 | GT106.4757.030.37.60.R | 6.00 | 0.30 | 47 | 8 | 2.70 | 5.70 | 0.60 | 37.00 | 62.00 | 6.00 |

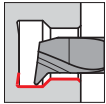
Article no. **25708** **25710** **25714**Cutting direction   

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 6.010 | GT106.4757.030.42.60.R | 6.00 | 0.30 | 47 | 8 | 2.70 | 5.70 | 0.60 | 42.00 | 67.00 | 6.00 |
| 6.011 | GT106.4757.030.47.60.R | 6.00 | 0.30 | 47 | 8 | 2.70 | 5.70 | 0.60 | 47.00 | 72.00 | 6.00 |
| 6.012 | GT106.4757.030.52.60.R | 6.00 | 0.30 | 47 | 8 | 2.70 | 5.70 | 0.60 | 52.00 | 77.00 | 6.00 |

Article no. **25709** **25711** **25715**Cutting direction   

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 6.019 | GT106.4757.005.12.60.L | 6.00 | 0.05 | 47 | 8 | 2.70 | 5.70 | 0.60 | 12.00 | 37.00 | 6.00 |
| 6.020 | GT106.4757.005.17.60.L | 6.00 | 0.05 | 47 | 8 | 2.70 | 5.70 | 0.60 | 17.00 | 42.00 | 6.00 |
| 6.021 | GT106.4757.005.22.60.L | 6.00 | 0.05 | 47 | 8 | 2.70 | 5.70 | 0.60 | 22.00 | 47.00 | 6.00 |
| 6.022 | GT106.4757.005.27.60.L | 6.00 | 0.05 | 47 | 8 | 2.70 | 5.70 | 0.60 | 27.00 | 52.00 | 6.00 |
| 6.023 | GT106.4757.005.32.60.L | 6.00 | 0.05 | 47 | 8 | 2.70 | 5.70 | 0.60 | 32.00 | 57.00 | 6.00 |
| 6.024 | GT106.4757.005.37.60.L | 6.00 | 0.05 | 47 | 8 | 2.70 | 5.70 | 0.60 | 37.00 | 62.00 | 6.00 |
| 6.025 | GT106.4757.005.42.60.L | 6.00 | 0.05 | 47 | 8 | 2.70 | 5.70 | 0.60 | 42.00 | 67.00 | 6.00 |
| 6.026 | GT106.4757.005.47.60.L | 6.00 | 0.05 | 47 | 8 | 2.70 | 5.70 | 0.60 | 47.00 | 72.00 | 6.00 |
| 6.027 | GT106.4757.005.52.60.L | 6.00 | 0.05 | 47 | 8 | 2.70 | 5.70 | 0.60 | 52.00 | 77.00 | 6.00 |
| 6.028 | GT106.4757.010.12.60.L | 6.00 | 0.10 | 47 | 8 | 2.70 | 5.70 | 0.60 | 12.00 | 37.00 | 6.00 |
| 6.029 | GT106.4757.010.17.60.L | 6.00 | 0.10 | 47 | 8 | 2.70 | 5.70 | 0.60 | 17.00 | 42.00 | 6.00 |
| 6.030 | GT106.4757.010.22.60.L | 6.00 | 0.10 | 47 | 8 | 2.70 | 5.70 | 0.60 | 22.00 | 47.00 | 6.00 |
| 6.031 | GT106.4757.010.27.60.L | 6.00 | 0.10 | 47 | 8 | 2.70 | 5.70 | 0.60 | 27.00 | 52.00 | 6.00 |
| 6.032 | GT106.4757.010.32.60.L | 6.00 | 0.10 | 47 | 8 | 2.70 | 5.70 | 0.60 | 32.00 | 57.00 | 6.00 |
| 6.033 | GT106.4757.010.37.60.L | 6.00 | 0.10 | 47 | 8 | 2.70 | 5.70 | 0.60 | 37.00 | 62.00 | 6.00 |
| 6.034 | GT106.4757.010.42.60.L | 6.00 | 0.10 | 47 | 8 | 2.70 | 5.70 | 0.60 | 42.00 | 67.00 | 6.00 |
| 6.035 | GT106.4757.010.47.60.L | 6.00 | 0.10 | 47 | 8 | 2.70 | 5.70 | 0.60 | 47.00 | 72.00 | 6.00 |
| 6.036 | GT106.4757.010.52.60.L | 6.00 | 0.10 | 47 | 8 | 2.70 | 5.70 | 0.60 | 52.00 | 77.00 | 6.00 |
| 6.013 | GT106.4757.015.12.60.L | 6.00 | 0.15 | 47 | 8 | 2.70 | 5.70 | 0.60 | 12.00 | 37.00 | 6.00 |
| 6.014 | GT106.4757.015.17.60.L | 6.00 | 0.15 | 47 | 8 | 2.70 | 5.70 | 0.60 | 17.00 | 42.00 | 6.00 |
| 6.015 | GT106.4757.015.22.60.L | 6.00 | 0.15 | 47 | 8 | 2.70 | 5.70 | 0.60 | 22.00 | 47.00 | 6.00 |
| 6.001 | GT106.4757.015.27.60.L | 6.00 | 0.15 | 47 | 8 | 2.70 | 5.70 | 0.60 | 27.00 | 52.00 | 6.00 |
| 6.002 | GT106.4757.015.32.60.L | 6.00 | 0.15 | 47 | 8 | 2.70 | 5.70 | 0.60 | 32.00 | 57.00 | 6.00 |
| 6.003 | GT106.4757.015.37.60.L | 6.00 | 0.15 | 47 | 8 | 2.70 | 5.70 | 0.60 | 37.00 | 62.00 | 6.00 |
| 6.004 | GT106.4757.015.42.60.L | 6.00 | 0.15 | 47 | 8 | 2.70 | 5.70 | 0.60 | 42.00 | 67.00 | 6.00 |
| 6.005 | GT106.4757.015.47.60.L | 6.00 | 0.15 | 47 | 8 | 2.70 | 5.70 | 0.60 | 47.00 | 72.00 | 6.00 |
| 6.006 | GT106.4757.015.52.60.L | 6.00 | 0.15 | 47 | 8 | 2.70 | 5.70 | 0.60 | 52.00 | 77.00 | 6.00 |
| 6.037 | GT106.4757.020.12.60.L | 6.00 | 0.20 | 47 | 8 | 2.70 | 5.70 | 0.60 | 12.00 | 37.00 | 6.00 |
| 6.038 | GT106.4757.020.17.60.L | 6.00 | 0.20 | 47 | 8 | 2.70 | 5.70 | 0.60 | 17.00 | 42.00 | 6.00 |
| 6.039 | GT106.4757.020.22.60.L | 6.00 | 0.20 | 47 | 8 | 2.70 | 5.70 | 0.60 | 22.00 | 47.00 | 6.00 |
| 6.040 | GT106.4757.020.27.60.L | 6.00 | 0.20 | 47 | 8 | 2.70 | 5.70 | 0.60 | 27.00 | 52.00 | 6.00 |
| 6.041 | GT106.4757.020.32.60.L | 6.00 | 0.20 | 47 | 8 | 2.70 | 5.70 | 0.60 | 32.00 | 57.00 | 6.00 |
| 6.042 | GT106.4757.020.37.60.L | 6.00 | 0.20 | 47 | 8 | 2.70 | 5.70 | 0.60 | 37.00 | 62.00 | 6.00 |
| 6.043 | GT106.4757.020.42.60.L | 6.00 | 0.20 | 47 | 8 | 2.70 | 5.70 | 0.60 | 42.00 | 67.00 | 6.00 |
| 6.044 | GT106.4757.020.47.60.L | 6.00 | 0.20 | 47 | 8 | 2.70 | 5.70 | 0.60 | 47.00 | 72.00 | 6.00 |
| 6.045 | GT106.4757.020.52.60.L | 6.00 | 0.20 | 47 | 8 | 2.70 | 5.70 | 0.60 | 52.00 | 77.00 | 6.00 |
| 6.016 | GT106.4757.030.12.60.L | 6.00 | 0.30 | 47 | 8 | 2.70 | 5.70 | 0.60 | 12.00 | 37.00 | 6.00 |
| 6.017 | GT106.4757.030.17.60.L | 6.00 | 0.30 | 47 | 8 | 2.70 | 5.70 | 0.60 | 17.00 | 42.00 | 6.00 |
| 6.018 | GT106.4757.030.22.60.L | 6.00 | 0.30 | 47 | 8 | 2.70 | 5.70 | 0.60 | 22.00 | 47.00 | 6.00 |
| 6.007 | GT106.4757.030.27.60.L | 6.00 | 0.30 | 47 | 8 | 2.70 | 5.70 | 0.60 | 27.00 | 52.00 | 6.00 |
| 6.008 | GT106.4757.030.32.60.L | 6.00 | 0.30 | 47 | 8 | 2.70 | 5.70 | 0.60 | 32.00 | 57.00 | 6.00 |
| 6.009 | GT106.4757.030.37.60.L | 6.00 | 0.30 | 47 | 8 | 2.70 | 5.70 | 0.60 | 37.00 | 62.00 | 6.00 |
| 6.010 | GT106.4757.030.42.60.L | 6.00 | 0.30 | 47 | 8 | 2.70 | 5.70 | 0.60 | 42.00 | 67.00 | 6.00 |
| 6.011 | GT106.4757.030.47.60.L | 6.00 | 0.30 | 47 | 8 | 2.70 | 5.70 | 0.60 | 47.00 | 72.00 | 6.00 |
| 6.012 | GT106.4757.030.52.60.L | 6.00 | 0.30 | 47 | 8 | 2.70 | 5.70 | 0.60 | 52.00 | 77.00 | 6.00 |

Cutting insert for boring out and profiling



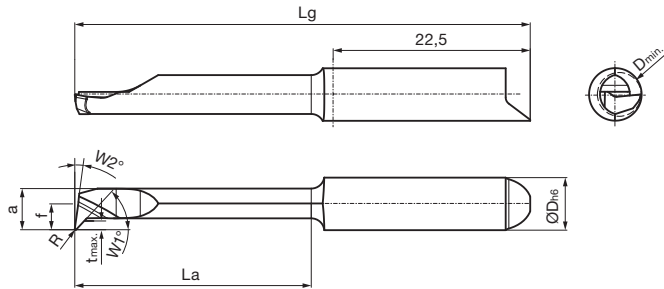
- radial free 47°, tmax 1

for tool holders type GH106/GB106 see from page 62

GUHRING NAVIGATOR

Cutting data page 184

System 106



Right hand version shown
Left hand version mirror image

| | | | |
|-------------------|--------------|--------------|--------------|
| Article no. | 25888 | 25890 | 25894 |
| Cutting direction | | | |

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|---------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 6.010 | GT106.4747.005.12.50.R.T1 | 5.00 | 0.05 | 47 | 8 | 2.95 | 4.70 | 1.00 | 12.00 | 37.00 | 6.00 |
| 6.020 | GT106.4747.005.17.50.R.T1 | 5.00 | 0.05 | 47 | 8 | 2.95 | 4.70 | 1.00 | 17.00 | 42.00 | 6.00 |
| 6.030 | GT106.4747.005.22.50.R.T1 | 5.00 | 0.05 | 47 | 8 | 2.95 | 4.70 | 1.00 | 22.00 | 47.00 | 6.00 |
| 6.040 | GT106.4747.005.27.50.R.T1 | 5.00 | 0.05 | 47 | 8 | 2.95 | 4.70 | 1.00 | 27.00 | 52.00 | 6.00 |
| 6.050 | GT106.4747.005.32.50.R.T1 | 5.00 | 0.05 | 47 | 8 | 2.95 | 4.70 | 1.00 | 32.00 | 57.00 | 6.00 |
| 6.060 | GT106.4747.005.37.50.R.T1 | 5.00 | 0.05 | 47 | 8 | 2.95 | 4.70 | 1.00 | 37.00 | 62.00 | 6.00 |
| 6.070 | GT106.4747.010.12.50.R.T1 | 5.00 | 0.05 | 47 | 8 | 2.95 | 4.70 | 1.00 | 42.00 | 67.00 | 6.00 |
| 6.110 | GT106.4747.010.12.50.R.T1 | 5.00 | 0.10 | 47 | 8 | 2.95 | 4.70 | 1.00 | 12.00 | 37.00 | 6.00 |
| 6.120 | GT106.4747.010.17.50.R.T1 | 5.00 | 0.10 | 47 | 8 | 2.95 | 4.70 | 1.00 | 17.00 | 42.00 | 6.00 |
| 6.130 | GT106.4747.010.22.50.R.T1 | 5.00 | 0.10 | 47 | 8 | 2.95 | 4.70 | 1.00 | 22.00 | 47.00 | 6.00 |
| 6.140 | GT106.4747.010.27.50.R.T1 | 5.00 | 0.10 | 47 | 8 | 2.95 | 4.70 | 1.00 | 27.00 | 52.00 | 6.00 |
| 6.150 | GT106.4747.010.32.50.R.T1 | 5.00 | 0.10 | 47 | 8 | 2.95 | 4.70 | 1.00 | 32.00 | 57.00 | 6.00 |
| 6.160 | GT106.4747.010.37.50.R.T1 | 5.00 | 0.10 | 47 | 8 | 2.95 | 4.70 | 1.00 | 37.00 | 62.00 | 6.00 |
| 6.170 | GT106.4747.010.42.50.R.T1 | 5.00 | 0.10 | 47 | 8 | 2.95 | 4.70 | 1.00 | 42.00 | 67.00 | 6.00 |
| 6.210 | GT106.4747.015.12.50.R.T1 | 5.00 | 0.15 | 47 | 8 | 2.95 | 4.70 | 1.00 | 12.00 | 37.00 | 6.00 |
| 6.220 | GT106.4747.015.17.50.R.T1 | 5.00 | 0.15 | 47 | 8 | 2.95 | 4.70 | 1.00 | 17.00 | 42.00 | 6.00 |
| 6.230 | GT106.4747.015.22.50.R.T1 | 5.00 | 0.15 | 47 | 8 | 2.95 | 4.70 | 1.00 | 22.00 | 47.00 | 6.00 |
| 6.240 | GT106.4747.015.27.50.R.T1 | 5.00 | 0.15 | 47 | 8 | 2.95 | 4.70 | 1.00 | 27.00 | 52.00 | 6.00 |
| 6.250 | GT106.4747.015.32.50.R.T1 | 5.00 | 0.15 | 47 | 8 | 2.95 | 4.70 | 1.00 | 32.00 | 57.00 | 6.00 |
| 6.260 | GT106.4747.015.37.50.R.T1 | 5.00 | 0.15 | 47 | 8 | 2.95 | 4.70 | 1.00 | 37.00 | 62.00 | 6.00 |
| 6.270 | GT106.4747.015.42.50.R.T1 | 5.00 | 0.15 | 47 | 8 | 2.95 | 4.70 | 1.00 | 42.00 | 67.00 | 6.00 |
| 6.310 | GT106.4747.020.12.50.R.T1 | 5.00 | 0.20 | 47 | 8 | 2.95 | 4.70 | 1.00 | 12.00 | 37.00 | 6.00 |
| 6.320 | GT106.4747.020.17.50.R.T1 | 5.00 | 0.20 | 47 | 8 | 2.95 | 4.70 | 1.00 | 17.00 | 42.00 | 6.00 |
| 6.330 | GT106.4747.020.22.50.R.T1 | 5.00 | 0.20 | 47 | 8 | 2.95 | 4.70 | 1.00 | 22.00 | 47.00 | 6.00 |
| 6.340 | GT106.4747.020.27.50.R.T1 | 5.00 | 0.20 | 47 | 8 | 2.95 | 4.70 | 1.00 | 27.00 | 52.00 | 6.00 |
| 6.350 | GT106.4747.020.32.50.R.T1 | 5.00 | 0.20 | 47 | 8 | 2.95 | 4.70 | 1.00 | 32.00 | 57.00 | 6.00 |
| 6.360 | GT106.4747.020.37.50.R.T1 | 5.00 | 0.20 | 47 | 8 | 2.95 | 4.70 | 1.00 | 37.00 | 62.00 | 6.00 |
| 6.370 | GT106.4747.020.42.50.R.T1 | 5.00 | 0.20 | 47 | 8 | 2.95 | 4.70 | 1.00 | 42.00 | 67.00 | 6.00 |
| 6.410 | GT106.4747.030.12.50.R.T1 | 5.00 | 0.30 | 47 | 8 | 2.95 | 4.70 | 1.00 | 12.00 | 37.00 | 6.00 |
| 6.420 | GT106.4747.030.17.50.R.T1 | 5.00 | 0.30 | 47 | 8 | 2.95 | 4.70 | 1.00 | 17.00 | 42.00 | 6.00 |
| 6.430 | GT106.4747.030.22.50.R.T1 | 5.00 | 0.30 | 47 | 8 | 2.95 | 4.70 | 1.00 | 22.00 | 47.00 | 6.00 |
| 6.440 | GT106.4747.030.27.50.R.T1 | 5.00 | 0.30 | 47 | 8 | 2.95 | 4.70 | 1.00 | 27.00 | 52.00 | 6.00 |
| 6.450 | GT106.4747.030.32.50.R.T1 | 5.00 | 0.30 | 47 | 8 | 2.95 | 4.70 | 1.00 | 32.00 | 57.00 | 6.00 |
| 6.460 | GT106.4747.030.37.50.R.T1 | 5.00 | 0.30 | 47 | 8 | 2.95 | 4.70 | 1.00 | 37.00 | 62.00 | 6.00 |
| 6.470 | GT106.4747.030.42.50.R.T1 | 5.00 | 0.30 | 47 | 8 | 2.95 | 4.70 | 1.00 | 42.00 | 67.00 | 6.00 |

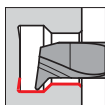
Article no. **25889** **25891** **25895**Cutting direction   

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|---------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 6.010 | GT106.4747.005.12.50.L.T1 | 5.00 | 0.05 | 47 | 8 | 2.95 | 4.70 | 1.00 | 12.00 | 37.00 | 6.00 |
| 6.020 | GT106.4747.005.17.50.L.T1 | 5.00 | 0.05 | 47 | 8 | 2.95 | 4.70 | 1.00 | 17.00 | 42.00 | 6.00 |
| 6.030 | GT106.4747.005.22.50.L.T1 | 5.00 | 0.05 | 47 | 8 | 2.95 | 4.70 | 1.00 | 22.00 | 47.00 | 6.00 |
| 6.040 | GT106.4747.005.27.50.L.T1 | 5.00 | 0.05 | 47 | 8 | 2.95 | 4.70 | 1.00 | 27.00 | 52.00 | 6.00 |
| 6.050 | GT106.4747.005.32.50.L.T1 | 5.00 | 0.05 | 47 | 8 | 2.95 | 4.70 | 1.00 | 32.00 | 57.00 | 6.00 |
| 6.060 | GT106.4747.005.37.50.L.T1 | 5.00 | 0.05 | 47 | 8 | 2.95 | 4.70 | 1.00 | 37.00 | 62.00 | 6.00 |
| 6.070 | GT106.4747.005.42.50.L.T1 | 5.00 | 0.05 | 47 | 8 | 2.95 | 4.70 | 1.00 | 42.00 | 67.00 | 6.00 |
| 6.110 | GT106.4747.010.12.50.L.T1 | 5.00 | 0.10 | 47 | 8 | 2.95 | 4.70 | 1.00 | 12.00 | 37.00 | 6.00 |
| 6.120 | GT106.4747.010.17.50.L.T1 | 5.00 | 0.10 | 47 | 8 | 2.95 | 4.70 | 1.00 | 17.00 | 42.00 | 6.00 |
| 6.130 | GT106.4747.010.22.50.L.T1 | 5.00 | 0.10 | 47 | 8 | 2.95 | 4.70 | 1.00 | 22.00 | 47.00 | 6.00 |
| 6.140 | GT106.4747.010.27.50.L.T1 | 5.00 | 0.10 | 47 | 8 | 2.95 | 4.70 | 1.00 | 27.00 | 52.00 | 6.00 |
| 6.150 | GT106.4747.010.32.50.L.T1 | 5.00 | 0.10 | 47 | 8 | 2.95 | 4.70 | 1.00 | 32.00 | 57.00 | 6.00 |
| 6.160 | GT106.4747.010.37.50.L.T1 | 5.00 | 0.10 | 47 | 8 | 2.95 | 4.70 | 1.00 | 37.00 | 62.00 | 6.00 |
| 6.170 | GT106.4747.010.42.50.L.T1 | 5.00 | 0.10 | 47 | 8 | 2.95 | 4.70 | 1.00 | 42.00 | 67.00 | 6.00 |
| 6.210 | GT106.4747.015.12.50.L.T1 | 5.00 | 0.15 | 47 | 8 | 2.95 | 4.70 | 1.00 | 12.00 | 37.00 | 6.00 |
| 6.220 | GT106.4747.015.17.50.L.T1 | 5.00 | 0.15 | 47 | 8 | 2.95 | 4.70 | 1.00 | 17.00 | 42.00 | 6.00 |
| 6.230 | GT106.4747.015.22.50.L.T1 | 5.00 | 0.15 | 47 | 8 | 2.95 | 4.70 | 1.00 | 22.00 | 47.00 | 6.00 |
| 6.240 | GT106.4747.015.27.50.L.T1 | 5.00 | 0.15 | 47 | 8 | 2.95 | 4.70 | 1.00 | 27.00 | 52.00 | 6.00 |
| 6.250 | GT106.4747.015.32.50.L.T1 | 5.00 | 0.15 | 47 | 8 | 2.95 | 4.70 | 1.00 | 32.00 | 57.00 | 6.00 |
| 6.260 | GT106.4747.015.37.50.L.T1 | 5.00 | 0.15 | 47 | 8 | 2.95 | 4.70 | 1.00 | 37.00 | 62.00 | 6.00 |
| 6.270 | GT106.4747.015.42.50.L.T1 | 5.00 | 0.15 | 47 | 8 | 2.95 | 4.70 | 1.00 | 42.00 | 67.00 | 6.00 |
| 6.310 | GT106.4747.020.12.50.L.T1 | 5.00 | 0.20 | 47 | 8 | 2.95 | 4.70 | 1.00 | 12.00 | 37.00 | 6.00 |
| 6.320 | GT106.4747.020.17.50.L.T1 | 5.00 | 0.20 | 47 | 8 | 2.95 | 4.70 | 1.00 | 17.00 | 42.00 | 6.00 |
| 6.330 | GT106.4747.020.22.50.L.T1 | 5.00 | 0.20 | 47 | 8 | 2.95 | 4.70 | 1.00 | 22.00 | 47.00 | 6.00 |
| 6.340 | GT106.4747.020.27.50.L.T1 | 5.00 | 0.20 | 47 | 8 | 2.95 | 4.70 | 1.00 | 27.00 | 52.00 | 6.00 |
| 6.350 | GT106.4747.020.32.50.L.T1 | 5.00 | 0.20 | 47 | 8 | 2.95 | 4.70 | 1.00 | 32.00 | 57.00 | 6.00 |
| 6.360 | GT106.4747.020.37.50.L.T1 | 5.00 | 0.20 | 47 | 8 | 2.95 | 4.70 | 1.00 | 37.00 | 62.00 | 6.00 |
| 6.370 | GT106.4747.020.42.50.L.T1 | 5.00 | 0.20 | 47 | 8 | 2.95 | 4.70 | 1.00 | 42.00 | 67.00 | 6.00 |
| 6.410 | GT106.4747.030.12.50.L.T1 | 5.00 | 0.30 | 47 | 8 | 2.95 | 4.70 | 1.00 | 12.00 | 37.00 | 6.00 |
| 6.420 | GT106.4747.030.17.50.L.T1 | 5.00 | 0.30 | 47 | 8 | 2.95 | 4.70 | 1.00 | 17.00 | 42.00 | 6.00 |
| 6.430 | GT106.4747.030.22.50.L.T1 | 5.00 | 0.30 | 47 | 8 | 2.95 | 4.70 | 1.00 | 22.00 | 47.00 | 6.00 |
| 6.440 | GT106.4747.030.27.50.L.T1 | 5.00 | 0.30 | 47 | 8 | 2.95 | 4.70 | 1.00 | 27.00 | 52.00 | 6.00 |
| 6.450 | GT106.4747.030.32.50.L.T1 | 5.00 | 0.30 | 47 | 8 | 2.95 | 4.70 | 1.00 | 32.00 | 57.00 | 6.00 |
| 6.460 | GT106.4747.030.37.50.L.T1 | 5.00 | 0.30 | 47 | 8 | 2.95 | 4.70 | 1.00 | 37.00 | 62.00 | 6.00 |
| 6.470 | GT106.4747.030.42.50.L.T1 | 5.00 | 0.30 | 47 | 8 | 2.95 | 4.70 | 1.00 | 42.00 | 67.00 | 6.00 |

System 106



Cutting insert for boring out and profiling



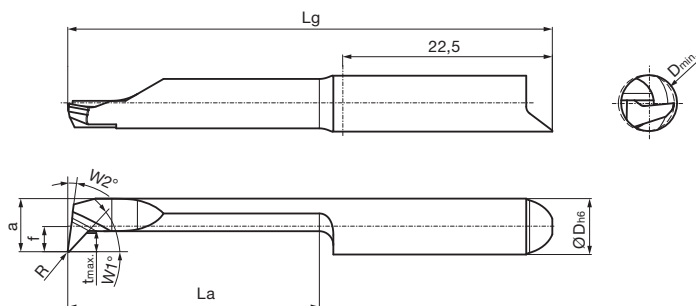
• radial free 47°, tmax 2

for tool holders type GH106/GB106 see from page 62

GUHRING NAVIGATOR

Cutting data page 184

System 106



Right hand version shown
Left hand version mirror image

Article no. **25516** **25518** **25522**

Cutting direction

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|---------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 6.010 | GT106.4757.005.12.60.R.T2 | 6.00 | 0.05 | 47 | 8 | 2.70 | 5.70 | 2.00 | 12.00 | 37.00 | 6.00 |
| 6.020 | GT106.4757.005.17.60.R.T2 | 6.00 | 0.05 | 47 | 8 | 2.70 | 5.70 | 2.00 | 17.00 | 42.00 | 6.00 |
| 6.030 | GT106.4757.005.22.60.R.T2 | 6.00 | 0.05 | 47 | 8 | 2.70 | 5.70 | 2.00 | 22.00 | 47.00 | 6.00 |
| 6.040 | GT106.4757.005.27.60.R.T2 | 6.00 | 0.05 | 47 | 8 | 2.70 | 5.70 | 2.00 | 27.00 | 52.00 | 6.00 |
| 6.050 | GT106.4757.005.32.60.R.T2 | 6.00 | 0.05 | 47 | 8 | 2.70 | 5.70 | 2.00 | 32.00 | 57.00 | 6.00 |
| 6.060 | GT106.4757.005.37.60.R.T2 | 6.00 | 0.05 | 47 | 8 | 2.70 | 5.70 | 2.00 | 37.00 | 62.00 | 6.00 |
| 6.070 | GT106.4757.005.42.60.R.T2 | 6.00 | 0.05 | 47 | 8 | 2.70 | 5.70 | 2.00 | 42.00 | 67.00 | 6.00 |
| 6.080 | GT106.4757.005.47.60.R.T2 | 6.00 | 0.05 | 47 | 8 | 2.70 | 5.70 | 2.00 | 47.00 | 72.00 | 6.00 |
| 6.090 | GT106.4757.005.52.60.R.T2 | 6.00 | 0.05 | 47 | 8 | 2.70 | 5.70 | 2.00 | 52.00 | 77.00 | 6.00 |
| 6.110 | GT106.4757.010.12.60.R.T2 | 6.00 | 0.10 | 47 | 8 | 2.70 | 5.70 | 2.00 | 12.00 | 37.00 | 6.00 |
| 6.120 | GT106.4757.010.17.60.R.T2 | 6.00 | 0.10 | 47 | 8 | 2.70 | 5.70 | 2.00 | 17.00 | 42.00 | 6.00 |
| 6.130 | GT106.4757.010.22.60.R.T2 | 6.00 | 0.10 | 47 | 8 | 2.70 | 5.70 | 2.00 | 22.00 | 47.00 | 6.00 |
| 6.140 | GT106.4757.010.27.60.R.T2 | 6.00 | 0.10 | 47 | 8 | 2.70 | 5.70 | 2.00 | 27.00 | 52.00 | 6.00 |
| 6.150 | GT106.4757.010.32.60.R.T2 | 6.00 | 0.10 | 47 | 8 | 2.70 | 5.70 | 2.00 | 32.00 | 57.00 | 6.00 |
| 6.160 | GT106.4757.010.37.60.R.T2 | 6.00 | 0.10 | 47 | 8 | 2.70 | 5.70 | 2.00 | 37.00 | 62.00 | 6.00 |
| 6.170 | GT106.4757.010.42.60.R.T2 | 6.00 | 0.10 | 47 | 8 | 2.70 | 5.70 | 2.00 | 42.00 | 67.00 | 6.00 |
| 6.180 | GT106.4757.010.47.60.R.T2 | 6.00 | 0.10 | 47 | 8 | 2.70 | 5.70 | 2.00 | 47.00 | 72.00 | 6.00 |
| 6.190 | GT106.4757.010.52.60.R.T2 | 6.00 | 0.10 | 47 | 8 | 2.70 | 5.70 | 2.00 | 52.00 | 77.00 | 6.00 |
| 6.210 | GT106.4757.015.12.60.R.T2 | 6.00 | 0.15 | 47 | 8 | 2.70 | 5.70 | 2.00 | 12.00 | 37.00 | 6.00 |
| 6.220 | GT106.4757.015.17.60.R.T2 | 6.00 | 0.15 | 47 | 8 | 2.70 | 5.70 | 2.00 | 17.00 | 42.00 | 6.00 |
| 6.230 | GT106.4757.015.22.60.R.T2 | 6.00 | 0.15 | 47 | 8 | 2.70 | 5.70 | 2.00 | 22.00 | 47.00 | 6.00 |
| 6.240 | GT106.4757.015.27.60.R.T2 | 6.00 | 0.15 | 47 | 8 | 2.70 | 5.70 | 2.00 | 27.00 | 52.00 | 6.00 |
| 6.250 | GT106.4757.015.32.60.R.T2 | 6.00 | 0.15 | 47 | 8 | 2.70 | 5.70 | 2.00 | 32.00 | 57.00 | 6.00 |
| 6.260 | GT106.4757.015.37.60.R.T2 | 6.00 | 0.15 | 47 | 8 | 2.70 | 5.70 | 2.00 | 37.00 | 62.00 | 6.00 |
| 6.270 | GT106.4757.015.42.60.R.T2 | 6.00 | 0.15 | 47 | 8 | 2.70 | 5.70 | 2.00 | 42.00 | 67.00 | 6.00 |
| 6.280 | GT106.4757.015.47.60.R.T2 | 6.00 | 0.15 | 47 | 8 | 2.70 | 5.70 | 2.00 | 47.00 | 72.00 | 6.00 |
| 6.290 | GT106.4757.015.52.60.R.T2 | 6.00 | 0.15 | 47 | 8 | 2.70 | 5.70 | 2.00 | 52.00 | 77.00 | 6.00 |
| 6.310 | GT106.4757.020.12.60.R.T2 | 6.00 | 0.20 | 47 | 8 | 2.70 | 5.70 | 2.00 | 12.00 | 37.00 | 6.00 |
| 6.320 | GT106.4757.020.17.60.R.T2 | 6.00 | 0.20 | 47 | 8 | 2.70 | 5.70 | 2.00 | 17.00 | 42.00 | 6.00 |
| 6.330 | GT106.4757.020.22.60.R.T2 | 6.00 | 0.20 | 47 | 8 | 2.70 | 5.70 | 2.00 | 22.00 | 47.00 | 6.00 |
| 6.340 | GT106.4757.020.27.60.R.T2 | 6.00 | 0.20 | 47 | 8 | 2.70 | 5.70 | 2.00 | 27.00 | 52.00 | 6.00 |
| 6.350 | GT106.4757.020.32.60.R.T2 | 6.00 | 0.20 | 47 | 8 | 2.70 | 5.70 | 2.00 | 32.00 | 57.00 | 6.00 |
| 6.360 | GT106.4757.020.37.60.R.T2 | 6.00 | 0.20 | 47 | 8 | 2.70 | 5.70 | 2.00 | 37.00 | 62.00 | 6.00 |
| 6.370 | GT106.4757.020.42.60.R.T2 | 6.00 | 0.20 | 47 | 8 | 2.70 | 5.70 | 2.00 | 42.00 | 67.00 | 6.00 |
| 6.380 | GT106.4757.020.47.60.R.T2 | 6.00 | 0.20 | 47 | 8 | 2.70 | 5.70 | 2.00 | 47.00 | 72.00 | 6.00 |
| 6.390 | GT106.4757.020.52.60.R.T2 | 6.00 | 0.20 | 47 | 8 | 2.70 | 5.70 | 2.00 | 52.00 | 77.00 | 6.00 |
| 6.410 | GT106.4757.030.12.60.R.T2 | 6.00 | 0.30 | 47 | 8 | 2.70 | 5.70 | 2.00 | 12.00 | 37.00 | 6.00 |
| 6.420 | GT106.4757.030.17.60.R.T2 | 6.00 | 0.30 | 47 | 8 | 2.70 | 5.70 | 2.00 | 17.00 | 42.00 | 6.00 |
| 6.430 | GT106.4757.030.22.60.R.T2 | 6.00 | 0.30 | 47 | 8 | 2.70 | 5.70 | 2.00 | 22.00 | 47.00 | 6.00 |
| 6.440 | GT106.4757.030.27.60.R.T2 | 6.00 | 0.30 | 47 | 8 | 2.70 | 5.70 | 2.00 | 27.00 | 52.00 | 6.00 |
| 6.450 | GT106.4757.030.32.60.R.T2 | 6.00 | 0.30 | 47 | 8 | 2.70 | 5.70 | 2.00 | 32.00 | 57.00 | 6.00 |
| 6.460 | GT106.4757.030.37.60.R.T2 | 6.00 | 0.30 | 47 | 8 | 2.70 | 5.70 | 2.00 | 37.00 | 62.00 | 6.00 |

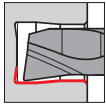
Article no. **25516** **25518** **25522**Cutting direction   

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|---------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 6.470 | GT106.4757.030.42.60.R.T2 | 6.00 | 0.30 | 47 | 8 | 2.70 | 5.70 | 2.00 | 42.00 | 67.00 | 6.00 |
| 6.480 | GT106.4757.030.47.60.R.T2 | 6.00 | 0.30 | 47 | 8 | 2.70 | 5.70 | 2.00 | 47.00 | 72.00 | 6.00 |
| 6.490 | GT106.4757.030.52.60.R.T2 | 6.00 | 0.30 | 47 | 8 | 2.70 | 5.70 | 2.00 | 52.00 | 77.00 | 6.00 |

Article no. **25517** **25519** **25523**Cutting direction   

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|---------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 6.010 | GT106.4757.005.12.60.L.T2 | 6.00 | 0.05 | 47 | 8 | 2.70 | 5.70 | 2.00 | 12.00 | 37.00 | 6.00 |
| 6.020 | GT106.4757.005.17.60.L.T2 | 6.00 | 0.05 | 47 | 8 | 2.70 | 5.70 | 2.00 | 17.00 | 42.00 | 6.00 |
| 6.030 | GT106.4757.005.22.60.L.T2 | 6.00 | 0.05 | 47 | 8 | 2.70 | 5.70 | 2.00 | 22.00 | 47.00 | 6.00 |
| 6.040 | GT106.4757.005.27.60.L.T2 | 6.00 | 0.05 | 47 | 8 | 2.70 | 5.70 | 2.00 | 27.00 | 52.00 | 6.00 |
| 6.050 | GT106.4757.005.32.60.L.T2 | 6.00 | 0.05 | 47 | 8 | 2.70 | 5.70 | 2.00 | 32.00 | 57.00 | 6.00 |
| 6.060 | GT106.4757.005.37.60.L.T2 | 6.00 | 0.05 | 47 | 8 | 2.70 | 5.70 | 2.00 | 37.00 | 62.00 | 6.00 |
| 6.070 | GT106.4757.005.42.60.L.T2 | 6.00 | 0.05 | 47 | 8 | 2.70 | 5.70 | 2.00 | 42.00 | 67.00 | 6.00 |
| 6.080 | GT106.4757.005.47.60.L.T2 | 6.00 | 0.05 | 47 | 8 | 2.70 | 5.70 | 2.00 | 47.00 | 72.00 | 6.00 |
| 6.090 | GT106.4757.010.37.60.L.T2 | 6.00 | 0.05 | 47 | 8 | 2.70 | 5.70 | 2.00 | 52.00 | 77.00 | 6.00 |
| 6.110 | GT106.4757.010.12.60.L.T2 | 6.00 | 0.10 | 47 | 8 | 2.70 | 5.70 | 2.00 | 12.00 | 37.00 | 6.00 |
| 6.120 | GT106.4757.010.17.60.L.T2 | 6.00 | 0.10 | 47 | 8 | 2.70 | 5.70 | 2.00 | 17.00 | 42.00 | 6.00 |
| 6.130 | GT106.4757.010.22.60.L.T2 | 6.00 | 0.10 | 47 | 8 | 2.70 | 5.70 | 2.00 | 22.00 | 47.00 | 6.00 |
| 6.140 | GT106.4757.010.27.60.L.T2 | 6.00 | 0.10 | 47 | 8 | 2.70 | 5.70 | 2.00 | 27.00 | 52.00 | 6.00 |
| 6.150 | GT106.4757.010.32.60.L.T2 | 6.00 | 0.10 | 47 | 8 | 2.70 | 5.70 | 2.00 | 32.00 | 57.00 | 6.00 |
| 6.160 | GT106.4757.010.37.60.L.T2 | 6.00 | 0.10 | 47 | 8 | 2.70 | 5.70 | 2.00 | 37.00 | 62.00 | 6.00 |
| 6.170 | GT106.4757.010.42.60.L.T2 | 6.00 | 0.10 | 47 | 8 | 2.70 | 5.70 | 2.00 | 42.00 | 67.00 | 6.00 |
| 6.180 | GT106.4757.010.47.60.L.T2 | 6.00 | 0.10 | 47 | 8 | 2.70 | 5.70 | 2.00 | 47.00 | 72.00 | 6.00 |
| 6.190 | GT106.4757.010.52.60.L.T2 | 6.00 | 0.10 | 47 | 8 | 2.70 | 5.70 | 2.00 | 52.00 | 77.00 | 6.00 |
| 6.210 | GT106.4757.015.12.60.L.T2 | 6.00 | 0.15 | 47 | 8 | 2.70 | 5.70 | 2.00 | 12.00 | 37.00 | 6.00 |
| 6.220 | GT106.4757.015.17.60.L.T2 | 6.00 | 0.15 | 47 | 8 | 2.70 | 5.70 | 2.00 | 17.00 | 42.00 | 6.00 |
| 6.230 | GT106.4757.015.22.60.L.T2 | 6.00 | 0.15 | 47 | 8 | 2.70 | 5.70 | 2.00 | 22.00 | 47.00 | 6.00 |
| 6.240 | GT106.4757.015.27.60.L.T2 | 6.00 | 0.15 | 47 | 8 | 2.70 | 5.70 | 2.00 | 27.00 | 52.00 | 6.00 |
| 6.250 | GT106.4757.015.32.60.L.T2 | 6.00 | 0.15 | 47 | 8 | 2.70 | 5.70 | 2.00 | 32.00 | 57.00 | 6.00 |
| 6.260 | GT106.4757.015.37.60.L.T2 | 6.00 | 0.15 | 47 | 8 | 2.70 | 5.70 | 2.00 | 37.00 | 62.00 | 6.00 |
| 6.270 | GT106.4757.015.42.60.L.T2 | 6.00 | 0.15 | 47 | 8 | 2.70 | 5.70 | 2.00 | 42.00 | 67.00 | 6.00 |
| 6.280 | GT106.4757.015.47.60.L.T2 | 6.00 | 0.15 | 47 | 8 | 2.70 | 5.70 | 2.00 | 47.00 | 72.00 | 6.00 |
| 6.290 | GT106.4757.015.52.60.L.T2 | 6.00 | 0.15 | 47 | 8 | 2.70 | 5.70 | 2.00 | 52.00 | 77.00 | 6.00 |
| 6.310 | GT106.4757.020.12.60.L.T2 | 6.00 | 0.20 | 47 | 8 | 2.70 | 5.70 | 2.00 | 12.00 | 37.00 | 6.00 |
| 6.320 | GT106.4757.020.17.60.L.T2 | 6.00 | 0.20 | 47 | 8 | 2.70 | 5.70 | 2.00 | 17.00 | 42.00 | 6.00 |
| 6.330 | GT106.4757.020.22.60.L.T2 | 6.00 | 0.20 | 47 | 8 | 2.70 | 5.70 | 2.00 | 22.00 | 47.00 | 6.00 |
| 6.340 | GT106.4757.020.27.60.L.T2 | 6.00 | 0.20 | 47 | 8 | 2.70 | 5.70 | 2.00 | 27.00 | 52.00 | 6.00 |
| 6.350 | GT106.4757.020.32.60.L.T2 | 6.00 | 0.20 | 47 | 8 | 2.70 | 5.70 | 2.00 | 32.00 | 57.00 | 6.00 |
| 6.360 | GT106.4757.020.37.60.L.T2 | 6.00 | 0.20 | 47 | 8 | 2.70 | 5.70 | 2.00 | 37.00 | 62.00 | 6.00 |
| 6.370 | GT106.4757.020.42.60.L.T2 | 6.00 | 0.20 | 47 | 8 | 2.70 | 5.70 | 2.00 | 42.00 | 67.00 | 6.00 |
| 6.380 | GT106.4757.020.47.60.L.T2 | 6.00 | 0.20 | 47 | 8 | 2.70 | 5.70 | 2.00 | 47.00 | 72.00 | 6.00 |
| 6.390 | GT106.4757.020.52.60.L.T2 | 6.00 | 0.20 | 47 | 8 | 2.70 | 5.70 | 2.00 | 52.00 | 77.00 | 6.00 |
| 6.410 | GT106.4757.030.12.60.L.T2 | 6.00 | 0.30 | 47 | 8 | 2.70 | 5.70 | 2.00 | 12.00 | 37.00 | 6.00 |
| 6.420 | GT106.4757.030.17.60.L.T2 | 6.00 | 0.30 | 47 | 8 | 2.70 | 5.70 | 2.00 | 17.00 | 42.00 | 6.00 |
| 6.430 | GT106.4757.030.22.60.L.T2 | 6.00 | 0.30 | 47 | 8 | 2.70 | 5.70 | 2.00 | 22.00 | 47.00 | 6.00 |
| 6.440 | GT106.4757.030.27.60.L.T2 | 6.00 | 0.30 | 47 | 8 | 2.70 | 5.70 | 2.00 | 27.00 | 52.00 | 6.00 |
| 6.450 | GT106.4757.030.32.60.L.T2 | 6.00 | 0.30 | 47 | 8 | 2.70 | 5.70 | 2.00 | 32.00 | 57.00 | 6.00 |
| 6.460 | GT106.4757.030.37.60.L.T2 | 6.00 | 0.30 | 47 | 8 | 2.70 | 5.70 | 2.00 | 37.00 | 62.00 | 6.00 |
| 6.470 | GT106.4757.030.42.60.L.T2 | 6.00 | 0.30 | 47 | 8 | 2.70 | 5.70 | 2.00 | 42.00 | 67.00 | 6.00 |
| 6.480 | GT106.4757.030.47.60.L.T2 | 6.00 | 0.30 | 47 | 8 | 2.70 | 5.70 | 2.00 | 47.00 | 72.00 | 6.00 |
| 6.490 | GT106.4757.030.52.60.L.T2 | 6.00 | 0.30 | 47 | 8 | 2.70 | 5.70 | 2.00 | 52.00 | 77.00 | 6.00 |

Cutting insert for boring out and profiling



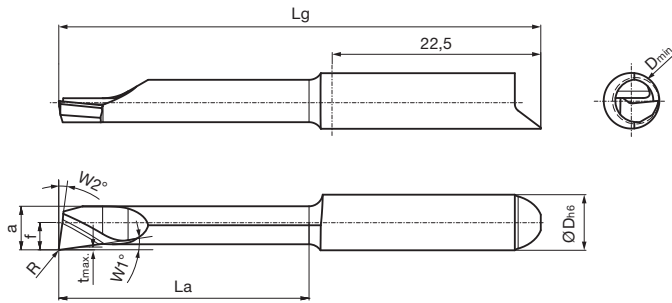
• radial free 8°

for tool holders type GH106/GB106 see from page 62

GUHRING NAVIGATOR

Cutting data page 184

System 106



Right hand version shown
Left hand version mirror image

| Tool material | Solid carbide | | | |
|---------------|---------------|-------------|--------|--------|
| | Type | GT 106 | GT 106 | GT 106 |
| Surface | S | a | ○ | |
| | TiN | TiAlN-nanoA | bright | |



Article no. **25500** **25502** **25506**

Cutting direction **(R)** **(R)** **(R)**

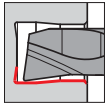
| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 6.010 | GT106.0847.005.12.50.R | 5.00 | 0.05 | 8 | 8 | 2.95 | 4.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.020 | GT106.0847.005.17.50.R | 5.00 | 0.05 | 8 | 8 | 2.95 | 4.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.030 | GT106.0847.005.22.50.R | 5.00 | 0.05 | 8 | 8 | 2.95 | 4.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.040 | GT106.0847.005.27.50.R | 5.00 | 0.05 | 8 | 8 | 2.95 | 4.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.050 | GT106.0847.005.32.50.R | 5.00 | 0.05 | 8 | 8 | 2.95 | 4.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.060 | GT106.0847.005.37.50.R | 5.00 | 0.05 | 8 | 8 | 2.95 | 4.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.070 | GT106.0847.010.12.50.R | 5.00 | 0.05 | 8 | 8 | 2.95 | 4.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.110 | GT106.0847.010.12.50.R | 5.00 | 0.10 | 8 | 8 | 2.95 | 4.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.120 | GT106.0847.010.17.50.R | 5.00 | 0.10 | 8 | 8 | 2.95 | 4.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.130 | GT106.0847.010.22.50.R | 5.00 | 0.10 | 8 | 8 | 2.95 | 4.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.140 | GT106.0847.010.27.50.R | 5.00 | 0.10 | 8 | 8 | 2.95 | 4.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.150 | GT106.0847.010.32.50.R | 5.00 | 0.10 | 8 | 8 | 2.95 | 4.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.160 | GT106.0847.010.37.50.R | 5.00 | 0.10 | 8 | 8 | 2.95 | 4.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.170 | GT106.0847.010.42.50.R | 5.00 | 0.10 | 8 | 8 | 2.95 | 4.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.210 | GT106.0847.015.12.50.R | 5.00 | 0.15 | 8 | 8 | 2.95 | 4.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.220 | GT106.0847.015.17.50.R | 5.00 | 0.15 | 8 | 8 | 2.95 | 4.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.230 | GT106.0847.015.22.50.R | 5.00 | 0.15 | 8 | 8 | 2.95 | 4.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.240 | GT106.0847.015.27.50.R | 5.00 | 0.15 | 8 | 8 | 2.95 | 4.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.250 | GT106.0847.015.32.50.R | 5.00 | 0.15 | 8 | 8 | 2.95 | 4.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.260 | GT106.0847.015.37.50.R | 5.00 | 0.15 | 8 | 8 | 2.95 | 4.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.270 | GT106.0847.015.42.50.R | 5.00 | 0.15 | 8 | 8 | 2.95 | 4.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.310 | GT106.0847.020.12.50.R | 5.00 | 0.20 | 8 | 8 | 2.95 | 4.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.320 | GT106.0847.020.17.50.R | 5.00 | 0.20 | 8 | 8 | 2.95 | 4.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.330 | GT106.0847.020.22.50.R | 5.00 | 0.20 | 8 | 8 | 2.95 | 4.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.340 | GT106.0847.020.27.50.R | 5.00 | 0.20 | 8 | 8 | 2.95 | 4.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.350 | GT106.0847.020.32.50.R | 5.00 | 0.20 | 8 | 8 | 2.95 | 4.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.360 | GT106.0847.020.37.50.R | 5.00 | 0.20 | 8 | 8 | 2.95 | 4.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.370 | GT106.0847.020.42.50.R | 5.00 | 0.20 | 8 | 8 | 2.95 | 4.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.410 | GT106.0847.030.12.50.R | 5.00 | 0.30 | 8 | 8 | 2.95 | 4.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.420 | GT106.0847.030.17.50.R | 5.00 | 0.30 | 8 | 8 | 2.95 | 4.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.430 | GT106.0847.030.22.50.R | 5.00 | 0.30 | 8 | 8 | 2.95 | 4.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.440 | GT106.0847.030.27.50.R | 5.00 | 0.30 | 8 | 8 | 2.95 | 4.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.450 | GT106.0847.030.32.50.R | 5.00 | 0.30 | 8 | 8 | 2.95 | 4.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.460 | GT106.0847.030.37.50.R | 5.00 | 0.30 | 8 | 8 | 2.95 | 4.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.470 | GT106.0847.030.42.50.R | 5.00 | 0.30 | 8 | 8 | 2.95 | 4.70 | 0.30 | 42.00 | 67.00 | 6.00 |

Article no. **25501** **25503** **25507**Cutting direction   

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 6.010 | GT106.0847.005.12.50.L | 5.00 | 0.05 | 8 | 8 | 2.95 | 4.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.020 | GT106.0847.005.17.50.L | 5.00 | 0.05 | 8 | 8 | 2.95 | 4.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.030 | GT106.0847.005.22.50.L | 5.00 | 0.05 | 8 | 8 | 2.95 | 4.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.040 | GT106.0847.005.27.50.L | 5.00 | 0.05 | 8 | 8 | 2.95 | 4.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.050 | GT106.0847.005.32.50.L | 5.00 | 0.05 | 8 | 8 | 2.95 | 4.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.060 | GT106.0847.005.37.50.L | 5.00 | 0.05 | 8 | 8 | 2.95 | 4.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.070 | GT106.0847.005.42.50.L | 5.00 | 0.05 | 8 | 8 | 2.95 | 4.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.110 | GT106.0847.010.12.50.L | 5.00 | 0.10 | 8 | 8 | 2.95 | 4.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.120 | GT106.0847.010.17.50.L | 5.00 | 0.10 | 8 | 8 | 2.95 | 4.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.130 | GT106.0847.010.22.50.L | 5.00 | 0.10 | 8 | 8 | 2.95 | 4.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.140 | GT106.0847.010.27.50.L | 5.00 | 0.10 | 8 | 8 | 2.95 | 4.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.150 | GT106.0847.010.32.50.L | 5.00 | 0.10 | 8 | 8 | 2.95 | 4.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.160 | GT106.0847.010.37.50.L | 5.00 | 0.10 | 8 | 8 | 2.95 | 4.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.170 | GT106.0847.010.42.50.L | 5.00 | 0.10 | 8 | 8 | 2.95 | 4.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.210 | GT106.0847.015.12.50.L | 5.00 | 0.15 | 8 | 8 | 2.95 | 4.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.220 | GT106.0847.015.17.50.L | 5.00 | 0.15 | 8 | 8 | 2.95 | 4.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.230 | GT106.0847.015.22.50.L | 5.00 | 0.15 | 8 | 8 | 2.95 | 4.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.240 | GT106.0847.015.27.50.L | 5.00 | 0.15 | 8 | 8 | 2.95 | 4.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.250 | GT106.0847.015.32.50.L | 5.00 | 0.15 | 8 | 8 | 2.95 | 4.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.260 | GT106.0847.015.37.50.L | 5.00 | 0.15 | 8 | 8 | 2.95 | 4.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.270 | GT106.0847.015.42.50.L | 5.00 | 0.15 | 8 | 8 | 2.95 | 4.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.310 | GT106.0847.020.12.50.L | 5.00 | 0.20 | 8 | 8 | 2.95 | 4.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.320 | GT106.0847.020.17.50.L | 5.00 | 0.20 | 8 | 8 | 2.95 | 4.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.330 | GT106.0847.020.22.50.L | 5.00 | 0.20 | 8 | 8 | 2.95 | 4.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.340 | GT106.0847.020.27.50.L | 5.00 | 0.20 | 8 | 8 | 2.95 | 4.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.350 | GT106.0847.020.32.50.L | 5.00 | 0.20 | 8 | 8 | 2.95 | 4.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.360 | GT106.0847.020.37.50.L | 5.00 | 0.20 | 8 | 8 | 2.95 | 4.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.370 | GT106.0847.020.42.50.L | 5.00 | 0.20 | 8 | 8 | 2.95 | 4.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.410 | GT106.0847.030.12.50.L | 5.00 | 0.30 | 8 | 8 | 2.95 | 4.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.420 | GT106.0847.030.17.50.L | 5.00 | 0.30 | 8 | 8 | 2.95 | 4.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.430 | GT106.0847.030.22.50.L | 5.00 | 0.30 | 8 | 8 | 2.95 | 4.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.440 | GT106.0847.030.27.50.L | 5.00 | 0.30 | 8 | 8 | 2.95 | 4.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.450 | GT106.0847.030.32.50.L | 5.00 | 0.30 | 8 | 8 | 2.95 | 4.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.460 | GT106.0847.030.37.50.L | 5.00 | 0.30 | 8 | 8 | 2.95 | 4.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.470 | GT106.0847.030.42.50.L | 5.00 | 0.30 | 8 | 8 | 2.95 | 4.70 | 0.30 | 42.00 | 67.00 | 6.00 |

System 106

Cutting insert for boring out and profiling



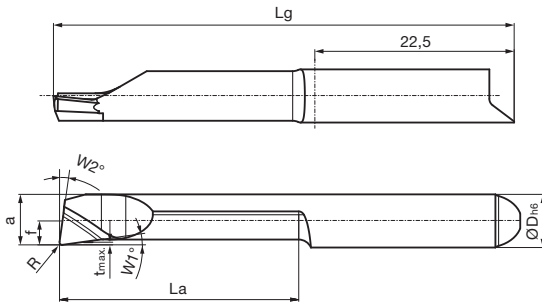
• radial free 8°

for tool holders type GH106/GB106 see from page 62

GUHRING NAVIGATOR

Cutting data page 184

System 106



Right hand version shown
Left hand version mirror image

| | | | |
|-------------------|--------------|--------------|--------------|
| Article no. | 25508 | 25510 | 25514 |
| Cutting direction | | | |

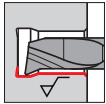
| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 6.010 | GT106.0857.005.12.60.R | 6.00 | 0.05 | 8 | 8 | 2.70 | 5.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.020 | GT106.0857.005.17.60.R | 6.00 | 0.05 | 8 | 8 | 2.70 | 5.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.030 | GT106.0857.005.22.60.R | 6.00 | 0.05 | 8 | 8 | 2.70 | 5.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.040 | GT106.0857.005.27.60.R | 6.00 | 0.05 | 8 | 8 | 2.70 | 5.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.050 | GT106.0857.005.32.60.R | 6.00 | 0.05 | 8 | 8 | 2.70 | 5.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.060 | GT106.0857.005.37.60.R | 6.00 | 0.05 | 8 | 8 | 2.70 | 5.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.070 | GT106.0857.010.12.60.R | 6.00 | 0.05 | 8 | 8 | 2.70 | 5.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.110 | GT106.0857.010.12.60.R | 6.00 | 0.10 | 8 | 8 | 2.70 | 5.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.120 | GT106.0857.010.17.60.R | 6.00 | 0.10 | 8 | 8 | 2.70 | 5.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.130 | GT106.0857.010.22.60.R | 6.00 | 0.10 | 8 | 8 | 2.70 | 5.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.140 | GT106.0857.010.27.60.R | 6.00 | 0.10 | 8 | 8 | 2.70 | 5.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.150 | GT106.0857.010.32.60.R | 6.00 | 0.10 | 8 | 8 | 2.70 | 5.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.160 | GT106.0857.010.37.60.R | 6.00 | 0.10 | 8 | 8 | 2.70 | 5.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.170 | GT106.0857.010.42.60.R | 6.00 | 0.10 | 8 | 8 | 2.70 | 5.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.210 | GT106.0857.015.12.60.R | 6.00 | 0.15 | 8 | 8 | 2.70 | 5.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.220 | GT106.0857.015.17.60.R | 6.00 | 0.15 | 8 | 8 | 2.70 | 5.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.230 | GT106.0857.015.22.60.R | 6.00 | 0.15 | 8 | 8 | 2.70 | 5.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.240 | GT106.0857.015.27.60.R | 6.00 | 0.15 | 8 | 8 | 2.70 | 5.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.250 | GT106.0857.015.32.60.R | 6.00 | 0.15 | 8 | 8 | 2.70 | 5.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.260 | GT106.0857.015.37.60.R | 6.00 | 0.15 | 8 | 8 | 2.70 | 5.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.270 | GT106.0857.015.42.60.R | 6.00 | 0.15 | 8 | 8 | 2.70 | 5.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.310 | GT106.0857.020.12.60.R | 6.00 | 0.20 | 8 | 8 | 2.70 | 5.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.320 | GT106.0857.020.17.60.R | 6.00 | 0.20 | 8 | 8 | 2.70 | 5.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.330 | GT106.0857.020.22.60.R | 6.00 | 0.20 | 8 | 8 | 2.70 | 5.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.340 | GT106.0857.020.27.60.R | 6.00 | 0.20 | 8 | 8 | 2.70 | 5.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.350 | GT106.0857.020.32.60.R | 6.00 | 0.20 | 8 | 8 | 2.70 | 5.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.360 | GT106.0857.020.37.60.R | 6.00 | 0.20 | 8 | 8 | 2.70 | 5.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.370 | GT106.0857.020.42.60.R | 6.00 | 0.20 | 8 | 8 | 2.70 | 5.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.410 | GT106.0857.030.12.60.R | 6.00 | 0.30 | 8 | 8 | 2.70 | 5.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.420 | GT106.0857.030.17.60.R | 6.00 | 0.30 | 8 | 8 | 2.70 | 5.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.430 | GT106.0857.030.22.60.R | 6.00 | 0.30 | 8 | 8 | 2.70 | 5.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.440 | GT106.0857.030.27.60.R | 6.00 | 0.30 | 8 | 8 | 2.70 | 5.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.450 | GT106.0857.030.32.60.R | 6.00 | 0.30 | 8 | 8 | 2.70 | 5.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.460 | GT106.0857.030.37.60.R | 6.00 | 0.30 | 8 | 8 | 2.70 | 5.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.470 | GT106.0857.030.42.60.R | 6.00 | 0.30 | 8 | 8 | 2.70 | 5.70 | 0.30 | 42.00 | 67.00 | 6.00 |

Article no. **25509** **25511** **25515**Cutting direction   

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 6.010 | GT106.0857.005.12.60.L | 6.00 | 0.05 | 8 | 8 | 2.70 | 5.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.020 | GT106.0857.005.17.60.L | 6.00 | 0.05 | 8 | 8 | 2.70 | 5.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.030 | GT106.0857.005.22.60.L | 6.00 | 0.05 | 8 | 8 | 2.70 | 5.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.040 | GT106.0857.005.27.60.L | 6.00 | 0.05 | 8 | 8 | 2.70 | 5.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.050 | GT106.0857.005.32.60.L | 6.00 | 0.05 | 8 | 8 | 2.70 | 5.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.060 | GT106.0857.005.37.60.L | 6.00 | 0.05 | 8 | 8 | 2.70 | 5.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.070 | GT106.0857.005.42.60.L | 6.00 | 0.05 | 8 | 8 | 2.70 | 5.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.110 | GT106.0857.010.12.60.L | 6.00 | 0.10 | 8 | 8 | 2.70 | 5.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.120 | GT106.0857.010.17.60.L | 6.00 | 0.10 | 8 | 8 | 2.70 | 5.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.130 | GT106.0857.010.22.60.L | 6.00 | 0.10 | 8 | 8 | 2.70 | 5.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.140 | GT106.0857.010.27.60.L | 6.00 | 0.10 | 8 | 8 | 2.70 | 5.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.150 | GT106.0857.010.32.60.L | 6.00 | 0.10 | 8 | 8 | 2.70 | 5.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.160 | GT106.0857.010.37.60.L | 6.00 | 0.10 | 8 | 8 | 2.70 | 5.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.170 | GT106.0857.010.42.60.L | 6.00 | 0.10 | 8 | 8 | 2.70 | 5.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.210 | GT106.0857.015.12.60.L | 6.00 | 0.15 | 8 | 8 | 2.70 | 5.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.220 | GT106.0857.015.17.60.L | 6.00 | 0.15 | 8 | 8 | 2.70 | 5.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.230 | GT106.0857.015.22.60.L | 6.00 | 0.15 | 8 | 8 | 2.70 | 5.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.240 | GT106.0857.015.27.60.L | 6.00 | 0.15 | 8 | 8 | 2.70 | 5.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.250 | GT106.0857.015.32.60.L | 6.00 | 0.15 | 8 | 8 | 2.70 | 5.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.260 | GT106.0857.015.37.60.L | 6.00 | 0.15 | 8 | 8 | 2.70 | 5.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.270 | GT106.0857.015.42.60.L | 6.00 | 0.15 | 8 | 8 | 2.70 | 5.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.310 | GT106.0857.020.12.60.L | 6.00 | 0.20 | 8 | 8 | 2.70 | 5.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.320 | GT106.0857.020.17.60.L | 6.00 | 0.20 | 8 | 8 | 2.70 | 5.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.330 | GT106.0857.020.22.60.L | 6.00 | 0.20 | 8 | 8 | 2.70 | 5.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.340 | GT106.0857.020.27.60.L | 6.00 | 0.20 | 8 | 8 | 2.70 | 5.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.350 | GT106.0857.020.32.60.L | 6.00 | 0.20 | 8 | 8 | 2.70 | 5.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.360 | GT106.0857.020.37.60.L | 6.00 | 0.20 | 8 | 8 | 2.70 | 5.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.370 | GT106.0857.020.42.60.L | 6.00 | 0.20 | 8 | 8 | 2.70 | 5.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.410 | GT106.0857.030.12.60.L | 6.00 | 0.30 | 8 | 8 | 2.70 | 5.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.420 | GT106.0857.030.17.60.L | 6.00 | 0.30 | 8 | 8 | 2.70 | 5.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.430 | GT106.0857.030.22.60.L | 6.00 | 0.30 | 8 | 8 | 2.70 | 5.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.440 | GT106.0857.030.27.60.L | 6.00 | 0.30 | 8 | 8 | 2.70 | 5.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.450 | GT106.0857.030.32.60.L | 6.00 | 0.30 | 8 | 8 | 2.70 | 5.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.460 | GT106.0857.030.37.60.L | 6.00 | 0.30 | 8 | 8 | 2.70 | 5.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.470 | GT106.0857.030.42.60.L | 6.00 | 0.30 | 8 | 8 | 2.70 | 5.70 | 0.30 | 42.00 | 67.00 | 6.00 |

System 106

Cutting insert for boring out and profiling



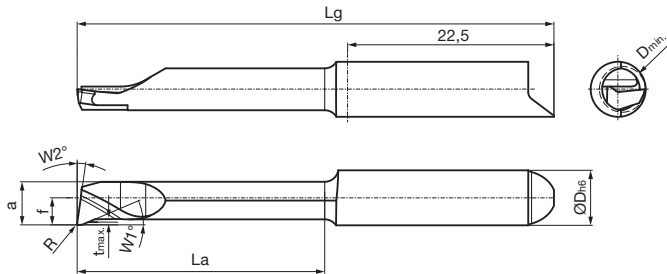
• WIPER-geometry

for tool holders type GH106/GB106 see from page 62

GUHRING NAVIGATOR

Cutting data page 184

System 106



Right hand version shown
Left hand version mirror image

Article no. **25848** **25850** **25854**

Cutting direction

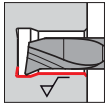
| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 6.010 | GJ106.2347.005.12.50.R | 5.00 | 0.05 | 23 | 8 | 2.95 | 4.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.020 | GJ106.2347.005.17.50.R | 5.00 | 0.05 | 23 | 8 | 2.95 | 4.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.030 | GJ106.2347.005.22.50.R | 5.00 | 0.05 | 23 | 8 | 2.95 | 4.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.040 | GJ106.2347.005.27.50.R | 5.00 | 0.05 | 23 | 8 | 2.95 | 4.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.050 | GJ106.2347.005.32.50.R | 5.00 | 0.05 | 23 | 8 | 2.95 | 4.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.060 | GJ106.2347.005.37.50.R | 5.00 | 0.05 | 23 | 8 | 2.95 | 4.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.070 | GJ106.2347.010.42.50.R | 5.00 | 0.05 | 23 | 8 | 2.95 | 4.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.110 | GJ106.2347.010.12.50.R | 5.00 | 0.10 | 23 | 8 | 2.95 | 4.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.120 | GJ106.2347.010.17.50.R | 5.00 | 0.10 | 23 | 8 | 2.95 | 4.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.130 | GJ106.2347.010.22.50.R | 5.00 | 0.10 | 23 | 8 | 2.95 | 4.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.140 | GJ106.2347.010.27.50.R | 5.00 | 0.10 | 23 | 8 | 2.95 | 4.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.150 | GJ106.2347.010.32.50.R | 5.00 | 0.10 | 23 | 8 | 2.95 | 4.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.160 | GJ106.2347.010.37.50.R | 5.00 | 0.10 | 23 | 8 | 2.95 | 4.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.170 | GJ106.2347.010.42.50.R | 5.00 | 0.10 | 23 | 8 | 2.95 | 4.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.210 | GJ106.2347.015.12.50.R | 5.00 | 0.15 | 23 | 8 | 2.95 | 4.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.220 | GJ106.2347.015.17.50.R | 5.00 | 0.15 | 23 | 8 | 2.95 | 4.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.230 | GJ106.2347.015.22.50.R | 5.00 | 0.15 | 23 | 8 | 2.95 | 4.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.240 | GJ106.2347.015.27.50.R | 5.00 | 0.15 | 23 | 8 | 2.95 | 4.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.250 | GJ106.2347.015.32.50.R | 5.00 | 0.15 | 23 | 8 | 2.95 | 4.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.260 | GJ106.2347.015.37.50.R | 5.00 | 0.15 | 23 | 8 | 2.95 | 4.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.270 | GJ106.2347.015.42.50.R | 5.00 | 0.15 | 23 | 8 | 2.95 | 4.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.310 | GJ106.2347.020.12.50.R | 5.00 | 0.20 | 23 | 8 | 2.95 | 4.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.320 | GJ106.2347.020.17.50.R | 5.00 | 0.20 | 23 | 8 | 2.95 | 4.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.330 | GJ106.2347.020.22.50.R | 5.00 | 0.20 | 23 | 8 | 2.95 | 4.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.340 | GJ106.2347.020.27.50.R | 5.00 | 0.20 | 23 | 8 | 2.95 | 4.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.350 | GJ106.2347.020.32.50.R | 5.00 | 0.20 | 23 | 8 | 2.95 | 4.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.360 | GJ106.2347.020.37.50.R | 5.00 | 0.20 | 23 | 8 | 2.95 | 4.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.370 | GJ106.2347.020.42.50.R | 5.00 | 0.20 | 23 | 8 | 2.95 | 4.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.410 | GJ106.2347.030.12.50.R | 5.00 | 0.30 | 23 | 8 | 2.95 | 4.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.420 | GJ106.2347.030.17.50.R | 5.00 | 0.30 | 23 | 8 | 2.95 | 4.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.430 | GJ106.2347.030.22.50.R | 5.00 | 0.30 | 23 | 8 | 2.95 | 4.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.440 | GJ106.2347.030.27.50.R | 5.00 | 0.30 | 23 | 8 | 2.95 | 4.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.450 | GJ106.2347.030.32.50.R | 5.00 | 0.30 | 23 | 8 | 2.95 | 4.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.460 | GJ106.2347.030.37.50.R | 5.00 | 0.30 | 23 | 8 | 2.95 | 4.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.470 | GJ106.2347.030.42.50.R | 5.00 | 0.30 | 23 | 8 | 2.95 | 4.70 | 0.30 | 42.00 | 67.00 | 6.00 |

Article no. **25849** **25851** **25855**Cutting direction   

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 6.010 | GJ106.2347.005.12.50.L | 5.00 | 0.05 | 23 | 8 | 2.95 | 4.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.020 | GJ106.2347.005.17.50.L | 5.00 | 0.05 | 23 | 8 | 2.95 | 4.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.030 | GJ106.2347.005.22.50.L | 5.00 | 0.05 | 23 | 8 | 2.95 | 4.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.040 | GJ106.2347.005.27.50.L | 5.00 | 0.05 | 23 | 8 | 2.95 | 4.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.050 | GJ106.2347.005.32.50.L | 5.00 | 0.05 | 23 | 8 | 2.95 | 4.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.060 | GJ106.2347.005.37.50.L | 5.00 | 0.05 | 23 | 8 | 2.95 | 4.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.070 | GJ106.2347.005.42.50.L | 5.00 | 0.05 | 23 | 8 | 2.95 | 4.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.110 | GJ106.2347.010.12.50.L | 5.00 | 0.10 | 23 | 8 | 2.95 | 4.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.120 | GJ106.2347.010.17.50.L | 5.00 | 0.10 | 23 | 8 | 2.95 | 4.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.130 | GJ106.2347.010.22.50.L | 5.00 | 0.10 | 23 | 8 | 2.95 | 4.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.140 | GJ106.2347.010.27.50.L | 5.00 | 0.10 | 23 | 8 | 2.95 | 4.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.150 | GJ106.2347.010.32.50.L | 5.00 | 0.10 | 23 | 8 | 2.95 | 4.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.160 | GJ106.2347.010.37.50.L | 5.00 | 0.10 | 23 | 8 | 2.95 | 4.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.170 | GJ106.2347.010.42.50.L | 5.00 | 0.10 | 23 | 8 | 2.95 | 4.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.210 | GJ106.2347.015.12.50.L | 5.00 | 0.15 | 23 | 8 | 2.95 | 4.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.220 | GJ106.2347.015.17.50.L | 5.00 | 0.15 | 23 | 8 | 2.95 | 4.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.230 | GJ106.2347.015.22.50.L | 5.00 | 0.15 | 23 | 8 | 2.95 | 4.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.240 | GJ106.2347.015.27.50.L | 5.00 | 0.15 | 23 | 8 | 2.95 | 4.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.250 | GJ106.2347.015.32.50.L | 5.00 | 0.15 | 23 | 8 | 2.95 | 4.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.260 | GJ106.2347.015.37.50.L | 5.00 | 0.15 | 23 | 8 | 2.95 | 4.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.270 | GJ106.2347.015.42.50.L | 5.00 | 0.15 | 23 | 8 | 2.95 | 4.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.310 | GJ106.2347.020.12.50.L | 5.00 | 0.20 | 23 | 8 | 2.95 | 4.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.320 | GJ106.2347.020.17.50.L | 5.00 | 0.20 | 23 | 8 | 2.95 | 4.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.330 | GJ106.2347.020.22.50.L | 5.00 | 0.20 | 23 | 8 | 2.95 | 4.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.340 | GJ106.2347.020.27.50.L | 5.00 | 0.20 | 23 | 8 | 2.95 | 4.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.350 | GJ106.2347.020.32.50.L | 5.00 | 0.20 | 23 | 8 | 2.95 | 4.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.360 | GJ106.2347.020.37.50.L | 5.00 | 0.20 | 23 | 8 | 2.95 | 4.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.370 | GJ106.2347.020.42.50.L | 5.00 | 0.20 | 23 | 8 | 2.95 | 4.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.410 | GJ106.2347.030.12.50.L | 5.00 | 0.30 | 23 | 8 | 2.95 | 4.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.420 | GJ106.2347.030.17.50.L | 5.00 | 0.30 | 23 | 8 | 2.95 | 4.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.430 | GJ106.2347.030.22.50.L | 5.00 | 0.30 | 23 | 8 | 2.95 | 4.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.440 | GJ106.2347.030.27.50.L | 5.00 | 0.30 | 23 | 8 | 2.95 | 4.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.450 | GJ106.2347.030.32.50.L | 5.00 | 0.30 | 23 | 8 | 2.95 | 4.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.460 | GJ106.2347.030.37.50.L | 5.00 | 0.30 | 23 | 8 | 2.95 | 4.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.470 | GJ106.2347.030.42.50.L | 5.00 | 0.30 | 23 | 8 | 2.95 | 4.70 | 0.30 | 42.00 | 67.00 | 6.00 |

System 106

Cutting insert for boring out and profiling

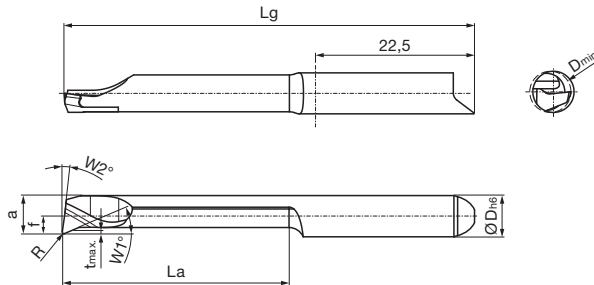


• WIPER-geometry

for tool holders type GH106/GB106 see from page 62

GUHRING NAVIGATOR

Cutting data page 184



Right hand version shown
Left hand version mirror image

| | | | |
|-------------------|--------------|--------------|--------------|
| Article no. | 25716 | 25718 | 25722 |
| Cutting direction | | | |

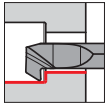
| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 6.019 | GJ106.2357.005.12.60.R | 6.00 | 0.05 | 23 | 8 | 2.70 | 5.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.020 | GJ106.2357.005.17.60.R | 6.00 | 0.05 | 23 | 8 | 2.70 | 5.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.021 | GJ106.2357.005.22.60.R | 6.00 | 0.05 | 23 | 8 | 2.70 | 5.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.022 | GJ106.2357.005.27.60.R | 6.00 | 0.05 | 23 | 8 | 2.70 | 5.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.023 | GJ106.2357.005.32.60.R | 6.00 | 0.05 | 23 | 8 | 2.70 | 5.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.024 | GJ106.2357.005.37.60.R | 6.00 | 0.05 | 23 | 8 | 2.70 | 5.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.025 | GJ106.2357.005.42.60.R | 6.00 | 0.05 | 23 | 8 | 2.70 | 5.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.026 | GJ106.2357.005.47.60.R | 6.00 | 0.05 | 23 | 8 | 2.70 | 5.70 | 0.30 | 47.00 | 72.00 | 6.00 |
| 6.027 | GJ106.2357.005.52.60.R | 6.00 | 0.05 | 23 | 8 | 2.70 | 5.70 | 0.30 | 52.00 | 77.00 | 6.00 |
| 6.013 | GJ106.2357.015.12.60.R | 6.00 | 0.15 | 23 | 8 | 2.70 | 5.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.014 | GJ106.2357.015.17.60.R | 6.00 | 0.15 | 23 | 8 | 2.70 | 5.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.015 | GJ106.2357.015.22.60.R | 6.00 | 0.15 | 23 | 8 | 2.70 | 5.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.001 | GJ106.2357.015.27.60.R | 6.00 | 0.15 | 23 | 8 | 2.70 | 5.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.002 | GJ106.2357.015.32.60.R | 6.00 | 0.15 | 23 | 8 | 2.70 | 5.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.003 | GJ106.2357.015.37.60.R | 6.00 | 0.15 | 23 | 8 | 2.70 | 5.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.004 | GJ106.2357.015.42.60.R | 6.00 | 0.15 | 23 | 8 | 2.70 | 5.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.005 | GJ106.2357.015.47.60.R | 6.00 | 0.15 | 23 | 8 | 2.70 | 5.70 | 0.30 | 47.00 | 72.00 | 6.00 |
| 6.006 | GJ106.2357.015.52.60.R | 6.00 | 0.15 | 23 | 8 | 2.70 | 5.70 | 0.30 | 52.00 | 77.00 | 6.00 |
| 6.028 | GJ106.2357.020.12.60.R | 6.00 | 0.20 | 23 | 8 | 2.70 | 5.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.029 | GJ106.2357.020.17.60.R | 6.00 | 0.20 | 23 | 8 | 2.70 | 5.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.030 | GJ106.2357.020.22.60.R | 6.00 | 0.20 | 23 | 8 | 2.70 | 5.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.031 | GJ106.2357.020.27.60.R | 6.00 | 0.20 | 23 | 8 | 2.70 | 5.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.032 | GJ106.2357.020.32.60.R | 6.00 | 0.20 | 23 | 8 | 2.70 | 5.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.033 | GJ106.2357.020.37.60.R | 6.00 | 0.20 | 23 | 8 | 2.70 | 5.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.034 | GJ106.2357.020.42.60.R | 6.00 | 0.20 | 23 | 8 | 2.70 | 5.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.035 | GJ106.2357.020.47.60.R | 6.00 | 0.20 | 23 | 8 | 2.70 | 5.70 | 0.30 | 47.00 | 72.00 | 6.00 |
| 6.036 | GJ106.2357.020.52.60.R | 6.00 | 0.20 | 23 | 8 | 2.70 | 5.70 | 0.30 | 52.00 | 77.00 | 6.00 |
| 6.016 | GJ106.2357.030.12.60.R | 6.00 | 0.30 | 23 | 8 | 2.70 | 5.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.017 | GJ106.2357.030.17.60.R | 6.00 | 0.30 | 23 | 8 | 2.70 | 5.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.018 | GJ106.2357.030.22.60.R | 6.00 | 0.30 | 23 | 8 | 2.70 | 5.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.007 | GJ106.2357.030.27.60.R | 6.00 | 0.30 | 23 | 8 | 2.70 | 5.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.008 | GJ106.2357.030.32.60.R | 6.00 | 0.30 | 23 | 8 | 2.70 | 5.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.009 | GJ106.2357.030.37.60.R | 6.00 | 0.30 | 23 | 8 | 2.70 | 5.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.010 | GJ106.2357.030.42.60.R | 6.00 | 0.30 | 23 | 8 | 2.70 | 5.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.011 | GJ106.2357.030.47.60.R | 6.00 | 0.30 | 23 | 8 | 2.70 | 5.70 | 0.30 | 47.00 | 72.00 | 6.00 |
| 6.012 | GJ106.2357.030.52.60.R | 6.00 | 0.30 | 23 | 8 | 2.70 | 5.70 | 0.30 | 52.00 | 77.00 | 6.00 |

Article no. **25717** **25719** **25723**Cutting direction   

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 6.019 | GJ106.2357.005.12.60.L | 6.00 | 0.05 | 23 | 8 | 2.70 | 5.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.020 | GJ106.2357.005.17.60.L | 6.00 | 0.05 | 23 | 8 | 2.70 | 5.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.021 | GJ106.2357.005.22.60.L | 6.00 | 0.05 | 23 | 8 | 2.70 | 5.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.022 | GJ106.2357.005.27.60.L | 6.00 | 0.05 | 23 | 8 | 2.70 | 5.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.023 | GJ106.2357.005.32.60.L | 6.00 | 0.05 | 23 | 8 | 2.70 | 5.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.024 | GJ106.2357.005.37.60.L | 6.00 | 0.05 | 23 | 8 | 2.70 | 5.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.025 | GJ106.2357.005.42.60.L | 6.00 | 0.05 | 23 | 8 | 2.70 | 5.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.026 | GJ106.2357.005.47.60.L | 6.00 | 0.05 | 23 | 8 | 2.70 | 5.70 | 0.30 | 47.00 | 72.00 | 6.00 |
| 6.027 | GJ106.2357.005.52.60.L | 6.00 | 0.05 | 23 | 8 | 2.70 | 5.70 | 0.30 | 52.00 | 77.00 | 6.00 |
| 6.013 | GJ106.2357.015.12.60.L | 6.00 | 0.15 | 23 | 8 | 2.70 | 5.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.014 | GJ106.2357.015.17.60.L | 6.00 | 0.15 | 23 | 8 | 2.70 | 5.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.015 | GJ106.2357.015.22.60.L | 6.00 | 0.15 | 23 | 8 | 2.70 | 5.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.001 | GJ106.2357.015.27.60.L | 6.00 | 0.15 | 23 | 8 | 2.70 | 5.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.002 | GJ106.2357.015.32.60.L | 6.00 | 0.15 | 23 | 8 | 2.70 | 5.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.003 | GJ106.2357.015.37.60.L | 6.00 | 0.15 | 23 | 8 | 2.70 | 5.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.004 | GJ106.2357.015.42.60.L | 6.00 | 0.15 | 23 | 8 | 2.70 | 5.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.005 | GJ106.2357.015.47.60.L | 6.00 | 0.15 | 23 | 8 | 2.70 | 5.70 | 0.30 | 47.00 | 72.00 | 6.00 |
| 6.006 | GJ106.2357.015.52.60.L | 6.00 | 0.15 | 23 | 8 | 2.70 | 5.70 | 0.30 | 52.00 | 77.00 | 6.00 |
| 6.028 | GJ106.2357.020.12.60.L | 6.00 | 0.20 | 23 | 8 | 2.70 | 5.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.029 | GJ106.2357.020.17.60.L | 6.00 | 0.20 | 23 | 8 | 2.70 | 5.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.030 | GJ106.2357.020.22.60.L | 6.00 | 0.20 | 23 | 8 | 2.70 | 5.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.031 | GJ106.2357.020.27.60.L | 6.00 | 0.20 | 23 | 8 | 2.70 | 5.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.032 | GJ106.2357.020.32.60.L | 6.00 | 0.20 | 23 | 8 | 2.70 | 5.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.033 | GJ106.2357.020.37.60.L | 6.00 | 0.20 | 23 | 8 | 2.70 | 5.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.034 | GJ106.2357.020.42.60.L | 6.00 | 0.20 | 23 | 8 | 2.70 | 5.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.035 | GJ106.2357.020.47.60.L | 6.00 | 0.20 | 23 | 8 | 2.70 | 5.70 | 0.30 | 47.00 | 72.00 | 6.00 |
| 6.036 | GJ106.2357.020.52.60.L | 6.00 | 0.20 | 23 | 8 | 2.70 | 5.70 | 0.30 | 52.00 | 77.00 | 6.00 |
| 6.016 | GJ106.2357.030.12.60.L | 6.00 | 0.30 | 23 | 8 | 2.70 | 5.70 | 0.30 | 12.00 | 37.00 | 6.00 |
| 6.017 | GJ106.2357.030.17.60.L | 6.00 | 0.30 | 23 | 8 | 2.70 | 5.70 | 0.30 | 17.00 | 42.00 | 6.00 |
| 6.018 | GJ106.2357.030.22.60.L | 6.00 | 0.30 | 23 | 8 | 2.70 | 5.70 | 0.30 | 22.00 | 47.00 | 6.00 |
| 6.007 | GJ106.2357.030.27.60.L | 6.00 | 0.30 | 23 | 8 | 2.70 | 5.70 | 0.30 | 27.00 | 52.00 | 6.00 |
| 6.008 | GJ106.2357.030.32.60.L | 6.00 | 0.30 | 23 | 8 | 2.70 | 5.70 | 0.30 | 32.00 | 57.00 | 6.00 |
| 6.009 | GJ106.2357.030.37.60.L | 6.00 | 0.30 | 23 | 8 | 2.70 | 5.70 | 0.30 | 37.00 | 62.00 | 6.00 |
| 6.010 | GJ106.2357.030.42.60.L | 6.00 | 0.30 | 23 | 8 | 2.70 | 5.70 | 0.30 | 42.00 | 67.00 | 6.00 |
| 6.011 | GJ106.2357.030.47.60.L | 6.00 | 0.30 | 23 | 8 | 2.70 | 5.70 | 0.30 | 47.00 | 72.00 | 6.00 |
| 6.012 | GJ106.2357.030.52.60.L | 6.00 | 0.30 | 23 | 8 | 2.70 | 5.70 | 0.30 | 52.00 | 77.00 | 6.00 |

System 106

Cutting insert for back boring and profiling

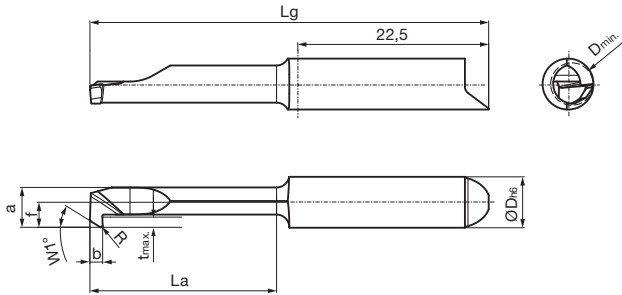


• radial free 32°

for tool holders type GH106/GB106 see from page 62

GUHRING NAVIGATOR

Cutting data page 184



Right hand version shown
Left hand version mirror image

| Tool material | Solid carbide | | |
|---------------|---------------|-------------|--------|
| | GT 106 | GT 106 | GT 106 |
| Type | GT 106 | GT 106 | GT 106 |
| Surface | S | a | ○ |
| | TiN | TiAlN-nanoA | bright |



Article no. **25856** **25858** **25862**

Cutting direction

| Code no. | Description | D min | R | W1 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | mm | mm | mm | mm | mm | mm |
| 6.010 | GT106.3247.020.12.50.R | 5.00 | 0.20 | 32 | 2.95 | 4.70 | 1.20 | 12.00 | 37.00 | 6.00 |
| 6.020 | GT106.3247.020.17.50.R | 5.00 | 0.20 | 32 | 2.95 | 4.70 | 1.20 | 17.00 | 42.00 | 6.00 |
| 6.030 | GT106.3247.020.22.50.R | 5.00 | 0.20 | 32 | 2.95 | 4.70 | 1.20 | 22.00 | 47.00 | 6.00 |
| 6.040 | GT106.3247.020.27.50.R | 5.00 | 0.20 | 32 | 2.95 | 4.70 | 1.20 | 27.00 | 52.00 | 6.00 |
| 6.050 | GT106.3247.020.32.50.R | 5.00 | 0.20 | 32 | 2.95 | 4.70 | 1.20 | 32.00 | 57.00 | 6.00 |
| 6.060 | GT106.3247.020.37.50.R | 5.00 | 0.20 | 32 | 2.95 | 4.70 | 1.20 | 37.00 | 62.00 | 6.00 |
| 6.070 | GT106.3247.020.42.50.R | 5.00 | 0.20 | 32 | 2.95 | 4.70 | 1.20 | 42.00 | 67.00 | 6.00 |

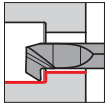
Article no. **25857** **25859** **25863**

Cutting direction

| Code no. | Description | D min | R | W1 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | mm | mm | mm | mm | mm | mm |
| 6.010 | GT106.3247.020.12.50.L | 5.00 | 0.20 | 32 | 2.95 | 4.70 | 1.20 | 12.00 | 37.00 | 6.00 |
| 6.020 | GT106.3247.020.17.50.L | 5.00 | 0.20 | 32 | 2.95 | 4.70 | 1.20 | 17.00 | 42.00 | 6.00 |
| 6.030 | GT106.3247.020.22.50.L | 5.00 | 0.20 | 32 | 2.95 | 4.70 | 1.20 | 22.00 | 47.00 | 6.00 |
| 6.040 | GT106.3247.020.27.50.L | 5.00 | 0.20 | 32 | 2.95 | 4.70 | 1.20 | 27.00 | 52.00 | 6.00 |
| 6.050 | GT106.3247.020.32.50.L | 5.00 | 0.20 | 32 | 2.95 | 4.70 | 1.20 | 32.00 | 57.00 | 6.00 |
| 6.060 | GT106.3247.020.37.50.L | 5.00 | 0.20 | 32 | 2.95 | 4.70 | 1.20 | 37.00 | 62.00 | 6.00 |
| 6.070 | GT106.3247.020.42.50.L | 5.00 | 0.20 | 32 | 2.95 | 4.70 | 1.20 | 42.00 | 67.00 | 6.00 |



Cutting insert for back boring and profiling

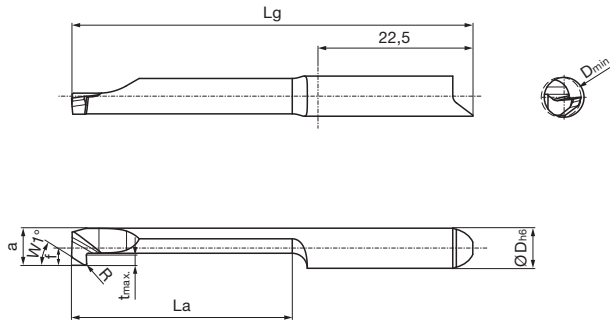


• radial free 32°

for tool holders type GH106/GB106 see from page 62

GUHRING NAVIGATOR

Cutting data page 184



Right hand version shown
Left hand version mirror image

| Tool material | Solid carbide | | |
|---------------|---------------|-------------|--------|
| Type | GT 106 | GT 106 | GT 106 |
| Surface | S | a | ○ |
| | TiN | TiAlN-nanoA | bright |



System 106

Article no. **25732** **25734** **25738**

Cutting direction **(R)** **(R)** **(R)**

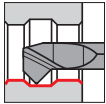
| Code no. | Description | D min | R | W1 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | mm | mm | mm | mm | mm | mm |
| 6.001 | GT106.3257.020.22.60.R | 6.00 | 0.20 | 32 | 2.70 | 5.70 | 2.00 | 22.00 | 47.00 | 6.00 |
| 6.002 | GT106.3257.020.32.60.R | 6.00 | 0.20 | 32 | 2.70 | 5.70 | 2.00 | 32.00 | 57.00 | 6.00 |
| 6.003 | GT106.3257.020.42.60.R | 6.00 | 0.20 | 32 | 2.70 | 5.70 | 2.00 | 42.00 | 67.00 | 6.00 |
| 6.004 | GT106.3257.020.52.60.R | 6.00 | 0.20 | 32 | 2.70 | 5.70 | 2.00 | 52.00 | 77.00 | 6.00 |
| 6.013 | GT106.3257.020.12.60.R | 6.00 | 0.20 | 32 | 2.70 | 5.70 | 2.00 | 12.00 | 37.00 | 6.00 |
| 6.014 | GT106.3257.020.17.60.R | 6.00 | 0.20 | 32 | 2.70 | 5.70 | 2.00 | 17.00 | 42.00 | 6.00 |

Article no. **25733** **25735** **25739**

Cutting direction **(L)** **(L)** **(L)**

| Code no. | Description | D min | R | W1 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | mm | mm | mm | mm | mm | mm |
| 6.001 | GT106.3257.020.22.60.L | 6.00 | 0.20 | 32 | 2.70 | 5.70 | 2.00 | 22.00 | 47.00 | 6.00 |
| 6.002 | GT106.3257.020.32.60.L | 6.00 | 0.20 | 32 | 2.70 | 5.70 | 2.00 | 32.00 | 57.00 | 6.00 |
| 6.003 | GT106.3257.020.42.60.L | 6.00 | 0.20 | 32 | 2.70 | 5.70 | 2.00 | 42.00 | 67.00 | 6.00 |
| 6.004 | GT106.3257.020.52.60.L | 6.00 | 0.20 | 32 | 2.70 | 5.70 | 2.00 | 52.00 | 77.00 | 6.00 |
| 6.013 | GT106.3257.020.12.60.L | 6.00 | 0.20 | 32 | 2.70 | 5.70 | 2.00 | 12.00 | 37.00 | 6.00 |
| 6.014 | GT106.3257.020.17.60.L | 6.00 | 0.20 | 32 | 2.70 | 5.70 | 2.00 | 17.00 | 42.00 | 6.00 |

Cutting insert for boring out and chamfering

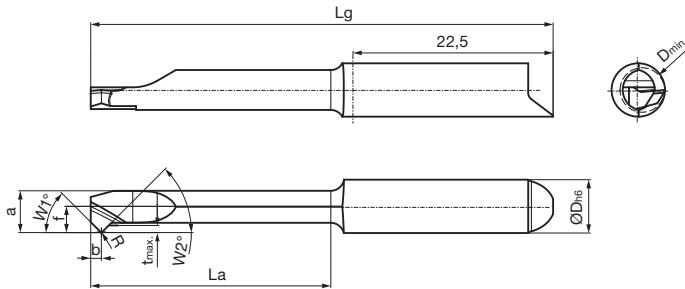


• 45° both sides

for tool holders type GH106/GB106 see from page 62

GUHRING NAVIGATOR

Cutting data page 184



Right hand version shown
Left hand version mirror image

Article no. **25864** **25866** **25870**

Cutting direction

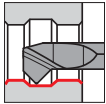
| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 6.010 | GT106.4547.010.12.50.R | 5.00 | 0.10 | 45 | 45 | 2.95 | 4.70 | 0.80 | 12.00 | 37.00 | 6.00 |
| 6.020 | GT106.4547.010.17.50.R | 5.00 | 0.10 | 45 | 45 | 2.95 | 4.70 | 0.80 | 17.00 | 42.00 | 6.00 |
| 6.030 | GT106.4547.010.22.50.R | 5.00 | 0.10 | 45 | 45 | 2.95 | 4.70 | 0.80 | 22.00 | 47.00 | 6.00 |
| 6.040 | GT106.4547.010.27.50.R | 5.00 | 0.10 | 45 | 45 | 2.95 | 4.70 | 0.80 | 27.00 | 52.00 | 6.00 |
| 6.050 | GT106.4547.010.32.50.R | 5.00 | 0.10 | 45 | 45 | 2.95 | 4.70 | 0.80 | 32.00 | 57.00 | 6.00 |
| 6.060 | GT106.4547.010.37.50.R | 5.00 | 0.10 | 45 | 45 | 2.95 | 4.70 | 0.80 | 37.00 | 62.00 | 6.00 |
| 6.070 | GT106.4547.015.12.50.R | 5.00 | 0.10 | 45 | 45 | 2.95 | 4.70 | 0.80 | 42.00 | 67.00 | 6.00 |
| 6.110 | GT106.4547.015.12.50.R | 5.00 | 0.15 | 45 | 45 | 2.95 | 4.70 | 0.80 | 12.00 | 37.00 | 6.00 |
| 6.120 | GT106.4547.015.17.50.R | 5.00 | 0.15 | 45 | 45 | 2.95 | 4.70 | 0.80 | 17.00 | 42.00 | 6.00 |
| 6.130 | GT106.4547.015.22.50.R | 5.00 | 0.15 | 45 | 45 | 2.95 | 4.70 | 0.80 | 22.00 | 47.00 | 6.00 |
| 6.140 | GT106.4547.015.27.50.R | 5.00 | 0.15 | 45 | 45 | 2.95 | 4.70 | 0.80 | 27.00 | 52.00 | 6.00 |
| 6.150 | GT106.4547.015.32.50.R | 5.00 | 0.15 | 45 | 45 | 2.95 | 4.70 | 0.80 | 32.00 | 57.00 | 6.00 |
| 6.160 | GT106.4547.015.37.50.R | 5.00 | 0.15 | 45 | 45 | 2.95 | 4.70 | 0.80 | 37.00 | 62.00 | 6.00 |
| 6.170 | GT106.4547.015.42.50.R | 5.00 | 0.15 | 45 | 45 | 2.95 | 4.70 | 0.80 | 42.00 | 67.00 | 6.00 |
| 6.210 | GT106.4547.020.12.50.R | 5.00 | 0.20 | 45 | 45 | 2.95 | 4.70 | 0.80 | 12.00 | 37.00 | 6.00 |
| 6.220 | GT106.4547.020.17.50.R | 5.00 | 0.20 | 45 | 45 | 2.95 | 4.70 | 0.80 | 17.00 | 42.00 | 6.00 |
| 6.230 | GT106.4547.020.22.50.R | 5.00 | 0.20 | 45 | 45 | 2.95 | 4.70 | 0.80 | 22.00 | 47.00 | 6.00 |
| 6.240 | GT106.4547.020.27.50.R | 5.00 | 0.20 | 45 | 45 | 2.95 | 4.70 | 0.80 | 27.00 | 52.00 | 6.00 |
| 6.250 | GT106.4547.020.32.50.R | 5.00 | 0.20 | 45 | 45 | 2.95 | 4.70 | 0.80 | 32.00 | 57.00 | 6.00 |
| 6.260 | GT106.4547.020.37.50.R | 5.00 | 0.20 | 45 | 45 | 2.95 | 4.70 | 0.80 | 37.00 | 62.00 | 6.00 |
| 6.270 | GT106.4547.020.42.50.R | 5.00 | 0.20 | 45 | 45 | 2.95 | 4.70 | 0.80 | 42.00 | 67.00 | 6.00 |
| 6.310 | GT106.4547.030.12.50.R | 5.00 | 0.30 | 45 | 45 | 2.95 | 4.70 | 0.80 | 12.00 | 37.00 | 6.00 |
| 6.320 | GT106.4547.030.17.50.R | 5.00 | 0.30 | 45 | 45 | 2.95 | 4.70 | 0.80 | 17.00 | 42.00 | 6.00 |
| 6.330 | GT106.4547.030.22.50.R | 5.00 | 0.30 | 45 | 45 | 2.95 | 4.70 | 0.80 | 22.00 | 47.00 | 6.00 |
| 6.340 | GT106.4547.030.27.50.R | 5.00 | 0.30 | 45 | 45 | 2.95 | 4.70 | 0.80 | 27.00 | 52.00 | 6.00 |
| 6.350 | GT106.4547.030.32.50.R | 5.00 | 0.30 | 45 | 45 | 2.95 | 4.70 | 0.80 | 32.00 | 57.00 | 6.00 |
| 6.360 | GT106.4547.030.37.50.R | 5.00 | 0.30 | 45 | 45 | 2.95 | 4.70 | 0.80 | 37.00 | 62.00 | 6.00 |
| 6.370 | GT106.4547.030.42.50.R | 5.00 | 0.30 | 45 | 45 | 2.95 | 4.70 | 0.80 | 42.00 | 67.00 | 6.00 |

Article no. **25865** **25867** **25871**Cutting direction   

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 6.010 | GT106.4547.010.12.50.L | 5.00 | 0.10 | 45 | 45 | 2.95 | 4.70 | 0.80 | 12.00 | 37.00 | 6.00 |
| 6.020 | GT106.4547.010.17.50.L | 5.00 | 0.10 | 45 | 45 | 2.95 | 4.70 | 0.80 | 17.00 | 42.00 | 6.00 |
| 6.030 | GT106.4547.010.22.50.L | 5.00 | 0.10 | 45 | 45 | 2.95 | 4.70 | 0.80 | 22.00 | 47.00 | 6.00 |
| 6.040 | GT106.4547.010.27.50.L | 5.00 | 0.10 | 45 | 45 | 2.95 | 4.70 | 0.80 | 27.00 | 52.00 | 6.00 |
| 6.050 | GT106.4547.010.32.50.L | 5.00 | 0.10 | 45 | 45 | 2.95 | 4.70 | 0.80 | 32.00 | 57.00 | 6.00 |
| 6.060 | GT106.4547.010.37.50.L | 5.00 | 0.10 | 45 | 45 | 2.95 | 4.70 | 0.80 | 37.00 | 62.00 | 6.00 |
| 6.070 | GT106.4547.010.42.50.L | 5.00 | 0.10 | 45 | 45 | 2.95 | 4.70 | 0.80 | 42.00 | 67.00 | 6.00 |
| 6.110 | GT106.4547.015.12.50.L | 5.00 | 0.15 | 45 | 45 | 2.95 | 4.70 | 0.80 | 12.00 | 37.00 | 6.00 |
| 6.120 | GT106.4547.015.17.50.L | 5.00 | 0.15 | 45 | 45 | 2.95 | 4.70 | 0.80 | 17.00 | 42.00 | 6.00 |
| 6.130 | GT106.4547.015.22.50.L | 5.00 | 0.15 | 45 | 45 | 2.95 | 4.70 | 0.80 | 22.00 | 47.00 | 6.00 |
| 6.140 | GT106.4547.015.27.50.L | 5.00 | 0.15 | 45 | 45 | 2.95 | 4.70 | 0.80 | 27.00 | 52.00 | 6.00 |
| 6.150 | GT106.4547.015.32.50.L | 5.00 | 0.15 | 45 | 45 | 2.95 | 4.70 | 0.80 | 32.00 | 57.00 | 6.00 |
| 6.160 | GT106.4547.015.37.50.L | 5.00 | 0.15 | 45 | 45 | 2.95 | 4.70 | 0.80 | 37.00 | 62.00 | 6.00 |
| 6.170 | GT106.4547.015.42.50.L | 5.00 | 0.15 | 45 | 45 | 2.95 | 4.70 | 0.80 | 42.00 | 67.00 | 6.00 |
| 6.210 | GT106.4547.020.12.50.L | 5.00 | 0.20 | 45 | 45 | 2.95 | 4.70 | 0.80 | 12.00 | 37.00 | 6.00 |
| 6.220 | GT106.4547.020.17.50.L | 5.00 | 0.20 | 45 | 45 | 2.95 | 4.70 | 0.80 | 17.00 | 42.00 | 6.00 |
| 6.230 | GT106.4547.020.22.50.L | 5.00 | 0.20 | 45 | 45 | 2.95 | 4.70 | 0.80 | 22.00 | 47.00 | 6.00 |
| 6.240 | GT106.4547.020.27.50.L | 5.00 | 0.20 | 45 | 45 | 2.95 | 4.70 | 0.80 | 27.00 | 52.00 | 6.00 |
| 6.250 | GT106.4547.020.32.50.L | 5.00 | 0.20 | 45 | 45 | 2.95 | 4.70 | 0.80 | 32.00 | 57.00 | 6.00 |
| 6.260 | GT106.4547.020.37.50.L | 5.00 | 0.20 | 45 | 45 | 2.95 | 4.70 | 0.80 | 37.00 | 62.00 | 6.00 |
| 6.270 | GT106.4547.020.42.50.L | 5.00 | 0.20 | 45 | 45 | 2.95 | 4.70 | 0.80 | 42.00 | 67.00 | 6.00 |
| 6.310 | GT106.4547.030.12.50.L | 5.00 | 0.30 | 45 | 45 | 2.95 | 4.70 | 0.80 | 12.00 | 37.00 | 6.00 |
| 6.320 | GT106.4547.030.17.50.L | 5.00 | 0.30 | 45 | 45 | 2.95 | 4.70 | 0.80 | 17.00 | 42.00 | 6.00 |
| 6.330 | GT106.4547.030.22.50.L | 5.00 | 0.30 | 45 | 45 | 2.95 | 4.70 | 0.80 | 22.00 | 47.00 | 6.00 |
| 6.340 | GT106.4547.030.27.50.L | 5.00 | 0.30 | 45 | 45 | 2.95 | 4.70 | 0.80 | 27.00 | 52.00 | 6.00 |
| 6.350 | GT106.4547.030.32.50.L | 5.00 | 0.30 | 45 | 45 | 2.95 | 4.70 | 0.80 | 32.00 | 57.00 | 6.00 |
| 6.360 | GT106.4547.030.37.50.L | 5.00 | 0.30 | 45 | 45 | 2.95 | 4.70 | 0.80 | 37.00 | 62.00 | 6.00 |
| 6.370 | GT106.4547.030.42.50.L | 5.00 | 0.30 | 45 | 45 | 2.95 | 4.70 | 0.80 | 42.00 | 67.00 | 6.00 |

System 106

Cutting insert for boring out and chamfering



• 45° both sides

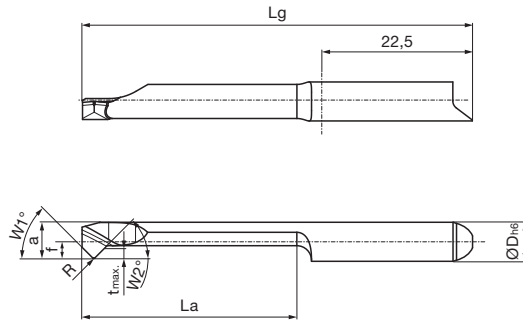
for tool holders type GH106/GB106 see from page 62

GUHRING NAVIGATOR

Cutting data page 184

| Tool material | Solid carbide | | | |
|---------------|---------------|-------------|--------|--------|
| | Type | GT 106 | GT 106 | GT 106 |
| Surface | S | a | ○ | |
| | TiN | TiAlN-nanoA | bright | |

System 106



Right hand version shown
Left hand version mirror image

Article no. **25740** **25742** **25746**

Cutting direction **(R)** **(R)** **(R)**

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 6.019 | GT106.4557.010.12.60.R | 6.00 | 0.10 | 45 | 45 | 2.70 | 5.70 | 1.00 | 12.00 | 37.00 | 6.00 |
| 6.020 | GT106.4557.010.17.60.R | 6.00 | 0.10 | 45 | 45 | 2.70 | 5.70 | 1.00 | 17.00 | 42.00 | 6.00 |
| 6.021 | GT106.4557.010.22.60.R | 6.00 | 0.10 | 45 | 45 | 2.70 | 5.70 | 1.00 | 22.00 | 47.00 | 6.00 |
| 6.022 | GT106.4557.010.27.60.R | 6.00 | 0.10 | 45 | 45 | 2.70 | 5.70 | 1.00 | 27.00 | 52.00 | 6.00 |
| 6.023 | GT106.4557.010.32.60.R | 6.00 | 0.10 | 45 | 45 | 2.70 | 5.70 | 1.00 | 32.00 | 57.00 | 6.00 |
| 6.024 | GT106.4557.010.37.60.R | 6.00 | 0.10 | 45 | 45 | 2.70 | 5.70 | 1.00 | 37.00 | 62.00 | 6.00 |
| 6.025 | GT106.4557.010.42.60.R | 6.00 | 0.10 | 45 | 45 | 2.70 | 5.70 | 1.00 | 42.00 | 67.00 | 6.00 |
| 6.026 | GT106.4557.010.47.60.R | 6.00 | 0.10 | 45 | 45 | 2.70 | 5.70 | 1.00 | 47.00 | 72.00 | 6.00 |
| 6.027 | GT106.4557.010.52.60.R | 6.00 | 0.10 | 45 | 45 | 2.70 | 5.70 | 1.00 | 52.00 | 77.00 | 6.00 |
| 6.013 | GT106.4557.015.12.60.R | 6.00 | 0.15 | 45 | 45 | 2.70 | 5.70 | 1.00 | 12.00 | 37.00 | 6.00 |
| 6.014 | GT106.4557.015.17.60.R | 6.00 | 0.15 | 45 | 45 | 2.70 | 5.70 | 1.00 | 17.00 | 42.00 | 6.00 |
| 6.015 | GT106.4557.015.22.60.R | 6.00 | 0.15 | 45 | 45 | 2.70 | 5.70 | 1.00 | 22.00 | 47.00 | 6.00 |
| 6.001 | GT106.4557.015.27.60.R | 6.00 | 0.15 | 45 | 45 | 2.70 | 5.70 | 1.00 | 27.00 | 52.00 | 6.00 |
| 6.002 | GT106.4557.015.32.60.R | 6.00 | 0.15 | 45 | 45 | 2.70 | 5.70 | 1.00 | 32.00 | 57.00 | 6.00 |
| 6.003 | GT106.4557.015.37.60.R | 6.00 | 0.15 | 45 | 45 | 2.70 | 5.70 | 1.00 | 37.00 | 62.00 | 6.00 |
| 6.004 | GT106.4557.015.42.60.R | 6.00 | 0.15 | 45 | 45 | 2.70 | 5.70 | 1.00 | 42.00 | 67.00 | 6.00 |
| 6.005 | GT106.4557.015.47.60.R | 6.00 | 0.15 | 45 | 45 | 2.70 | 5.70 | 1.00 | 47.00 | 72.00 | 6.00 |
| 6.006 | GT106.4557.015.52.60.R | 6.00 | 0.15 | 45 | 45 | 2.70 | 5.70 | 1.00 | 52.00 | 77.00 | 6.00 |
| 6.028 | GT106.4557.020.12.60.R | 6.00 | 0.20 | 45 | 45 | 2.70 | 5.70 | 1.00 | 12.00 | 37.00 | 6.00 |
| 6.029 | GT106.4557.020.17.60.R | 6.00 | 0.20 | 45 | 45 | 2.70 | 5.70 | 1.00 | 17.00 | 42.00 | 6.00 |
| 6.030 | GT106.4557.020.22.60.R | 6.00 | 0.20 | 45 | 45 | 2.70 | 5.70 | 1.00 | 22.00 | 47.00 | 6.00 |
| 6.031 | GT106.4557.020.27.60.R | 6.00 | 0.20 | 45 | 45 | 2.70 | 5.70 | 1.00 | 27.00 | 52.00 | 6.00 |
| 6.032 | GT106.4557.020.32.60.R | 6.00 | 0.20 | 45 | 45 | 2.70 | 5.70 | 1.00 | 32.00 | 57.00 | 6.00 |
| 6.033 | GT106.4557.020.37.60.R | 6.00 | 0.20 | 45 | 45 | 2.70 | 5.70 | 1.00 | 37.00 | 62.00 | 6.00 |
| 6.034 | GT106.4557.020.42.60.R | 6.00 | 0.20 | 45 | 45 | 2.70 | 5.70 | 1.00 | 42.00 | 67.00 | 6.00 |
| 6.035 | GT106.4557.020.47.60.R | 6.00 | 0.20 | 45 | 45 | 2.70 | 5.70 | 1.00 | 47.00 | 72.00 | 6.00 |
| 6.036 | GT106.4557.020.52.60.R | 6.00 | 0.20 | 45 | 45 | 2.70 | 5.70 | 1.00 | 52.00 | 77.00 | 6.00 |
| 6.016 | GT106.4557.030.12.60.R | 6.00 | 0.30 | 45 | 45 | 2.70 | 5.70 | 1.00 | 12.00 | 37.00 | 6.00 |
| 6.017 | GT106.4557.030.17.60.R | 6.00 | 0.30 | 45 | 45 | 2.70 | 5.70 | 1.00 | 17.00 | 42.00 | 6.00 |
| 6.018 | GT106.4557.030.22.60.R | 6.00 | 0.30 | 45 | 45 | 2.70 | 5.70 | 1.00 | 22.00 | 47.00 | 6.00 |
| 6.007 | GT106.4557.030.27.60.R | 6.00 | 0.30 | 45 | 45 | 2.70 | 5.70 | 1.00 | 27.00 | 52.00 | 6.00 |
| 6.008 | GT106.4557.030.32.60.R | 6.00 | 0.30 | 45 | 45 | 2.70 | 5.70 | 1.00 | 32.00 | 57.00 | 6.00 |
| 6.009 | GT106.4557.030.37.60.R | 6.00 | 0.30 | 45 | 45 | 2.70 | 5.70 | 1.00 | 37.00 | 62.00 | 6.00 |
| 6.010 | GT106.4557.030.42.60.R | 6.00 | 0.30 | 45 | 45 | 2.70 | 5.70 | 1.00 | 42.00 | 67.00 | 6.00 |
| 6.011 | GT106.4557.030.47.60.R | 6.00 | 0.30 | 45 | 45 | 2.70 | 5.70 | 1.00 | 47.00 | 72.00 | 6.00 |
| 6.012 | GT106.4557.030.52.60.R | 6.00 | 0.30 | 45 | 45 | 2.70 | 5.70 | 1.00 | 52.00 | 77.00 | 6.00 |

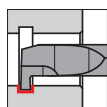
Article no. **25741** **25743** **25747**Cutting direction   

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 6.019 | GT106.4557.010.12.60.L | 6.00 | 0.10 | 45 | 45 | 2.70 | 5.70 | 1.00 | 12.00 | 37.00 | 6.00 |
| 6.020 | GT106.4557.010.17.60.L | 6.00 | 0.10 | 45 | 45 | 2.70 | 5.70 | 1.00 | 17.00 | 42.00 | 6.00 |
| 6.021 | GT106.4557.010.22.60.L | 6.00 | 0.10 | 45 | 45 | 2.70 | 5.70 | 1.00 | 22.00 | 47.00 | 6.00 |
| 6.022 | GT106.4557.010.27.60.L | 6.00 | 0.10 | 45 | 45 | 2.70 | 5.70 | 1.00 | 27.00 | 52.00 | 6.00 |
| 6.023 | GT106.4557.010.32.60.L | 6.00 | 0.10 | 45 | 45 | 2.70 | 5.70 | 1.00 | 32.00 | 57.00 | 6.00 |
| 6.024 | GT106.4557.010.37.60.L | 6.00 | 0.10 | 45 | 45 | 2.70 | 5.70 | 1.00 | 37.00 | 62.00 | 6.00 |
| 6.025 | GT106.4557.010.42.60.L | 6.00 | 0.10 | 45 | 45 | 2.70 | 5.70 | 1.00 | 42.00 | 67.00 | 6.00 |
| 6.026 | GT106.4557.010.47.60.L | 6.00 | 0.10 | 45 | 45 | 2.70 | 5.70 | 1.00 | 47.00 | 72.00 | 6.00 |
| 6.027 | GT106.4557.010.52.60.L | 6.00 | 0.10 | 45 | 45 | 2.70 | 5.70 | 1.00 | 52.00 | 77.00 | 6.00 |
| 6.013 | GT106.4557.015.12.60.L | 6.00 | 0.15 | 45 | 45 | 2.70 | 5.70 | 1.00 | 12.00 | 37.00 | 6.00 |
| 6.014 | GT106.4557.015.17.60.L | 6.00 | 0.15 | 45 | 45 | 2.70 | 5.70 | 1.00 | 17.00 | 42.00 | 6.00 |
| 6.015 | GT106.4557.015.22.60.L | 6.00 | 0.15 | 45 | 45 | 2.70 | 5.70 | 1.00 | 22.00 | 47.00 | 6.00 |
| 6.001 | GT106.4557.015.27.60.L | 6.00 | 0.15 | 45 | 45 | 2.70 | 5.70 | 1.00 | 27.00 | 52.00 | 6.00 |
| 6.002 | GT106.4557.015.32.60.L | 6.00 | 0.15 | 45 | 45 | 2.70 | 5.70 | 1.00 | 32.00 | 57.00 | 6.00 |
| 6.003 | GT106.4557.015.37.60.L | 6.00 | 0.15 | 45 | 45 | 2.70 | 5.70 | 1.00 | 37.00 | 62.00 | 6.00 |
| 6.004 | GT106.4557.015.42.60.L | 6.00 | 0.15 | 45 | 45 | 2.70 | 5.70 | 1.00 | 42.00 | 67.00 | 6.00 |
| 6.005 | GT106.4557.015.47.60.L | 6.00 | 0.15 | 45 | 45 | 2.70 | 5.70 | 1.00 | 47.00 | 72.00 | 6.00 |
| 6.006 | GT106.4557.015.52.60.L | 6.00 | 0.15 | 45 | 45 | 2.70 | 5.70 | 1.00 | 52.00 | 77.00 | 6.00 |
| 6.028 | GT106.4557.020.12.60.L | 6.00 | 0.20 | 45 | 45 | 2.70 | 5.70 | 1.00 | 12.00 | 37.00 | 6.00 |
| 6.029 | GT106.4557.020.17.60.L | 6.00 | 0.20 | 45 | 45 | 2.70 | 5.70 | 1.00 | 17.00 | 42.00 | 6.00 |
| 6.030 | GT106.4557.020.22.60.L | 6.00 | 0.20 | 45 | 45 | 2.70 | 5.70 | 1.00 | 22.00 | 47.00 | 6.00 |
| 6.031 | GT106.4557.020.27.60.L | 6.00 | 0.20 | 45 | 45 | 2.70 | 5.70 | 1.00 | 27.00 | 52.00 | 6.00 |
| 6.032 | GT106.4557.020.32.60.L | 6.00 | 0.20 | 45 | 45 | 2.70 | 5.70 | 1.00 | 32.00 | 57.00 | 6.00 |
| 6.033 | GT106.4557.020.37.60.L | 6.00 | 0.20 | 45 | 45 | 2.70 | 5.70 | 1.00 | 37.00 | 62.00 | 6.00 |
| 6.034 | GT106.4557.020.42.60.L | 6.00 | 0.20 | 45 | 45 | 2.70 | 5.70 | 1.00 | 42.00 | 67.00 | 6.00 |
| 6.035 | GT106.4557.020.47.60.L | 6.00 | 0.20 | 45 | 45 | 2.70 | 5.70 | 1.00 | 47.00 | 72.00 | 6.00 |
| 6.036 | GT106.4557.020.52.60.L | 6.00 | 0.20 | 45 | 45 | 2.70 | 5.70 | 1.00 | 52.00 | 77.00 | 6.00 |
| 6.016 | GT106.4557.030.12.60.L | 6.00 | 0.30 | 45 | 45 | 2.70 | 5.70 | 1.00 | 12.00 | 37.00 | 6.00 |
| 6.017 | GT106.4557.030.17.60.L | 6.00 | 0.30 | 45 | 45 | 2.70 | 5.70 | 1.00 | 17.00 | 42.00 | 6.00 |
| 6.018 | GT106.4557.030.22.60.L | 6.00 | 0.30 | 45 | 45 | 2.70 | 5.70 | 1.00 | 22.00 | 47.00 | 6.00 |
| 6.007 | GT106.4557.030.27.60.L | 6.00 | 0.30 | 45 | 45 | 2.70 | 5.70 | 1.00 | 27.00 | 52.00 | 6.00 |
| 6.008 | GT106.4557.030.32.60.L | 6.00 | 0.30 | 45 | 45 | 2.70 | 5.70 | 1.00 | 32.00 | 57.00 | 6.00 |
| 6.009 | GT106.4557.030.37.60.L | 6.00 | 0.30 | 45 | 45 | 2.70 | 5.70 | 1.00 | 37.00 | 62.00 | 6.00 |
| 6.010 | GT106.4557.030.42.60.L | 6.00 | 0.30 | 45 | 45 | 2.70 | 5.70 | 1.00 | 42.00 | 67.00 | 6.00 |
| 6.011 | GT106.4557.030.47.60.L | 6.00 | 0.30 | 45 | 45 | 2.70 | 5.70 | 1.00 | 47.00 | 72.00 | 6.00 |
| 6.012 | GT106.4557.030.52.60.L | 6.00 | 0.30 | 45 | 45 | 2.70 | 5.70 | 1.00 | 52.00 | 77.00 | 6.00 |

System 106



Cutting insert for internal grooving, straight slots



- grooving depth up to 1.2 mm

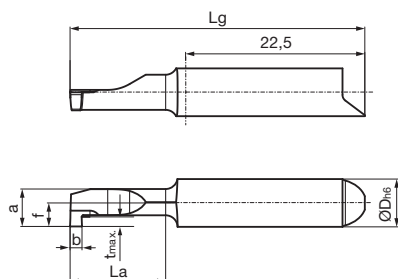
for tool holders type GH106/GB106 see from page 62

GUHRING NAVIGATOR

Cutting data page 184

System 106

| Tool material | Solid carbide | | |
|---------------|---------------|-------------|--------|
| Type | GE 106 | GE 106 | GE 106 |
| Surface | S | a | ○ |
| | TiN | TiAlN-nanoA | bright |



Right hand version shown
Left hand version mirror image

Article no. **25872** **25874** **25878**

Cutting direction **(R)** **(R)** **(R)**

| Code no. | Description | D min | b | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm |
| 6.010 | GE106.0100.000.12.50.R | 5.00 | 1.00 | 2.95 | 4.70 | 1.20 | 12.00 | 37.00 | 6.00 |
| 6.020 | GE106.0100.000.17.50.R | 5.00 | 1.00 | 2.95 | 4.70 | 1.20 | 17.00 | 42.00 | 6.00 |
| 6.030 | GE106.0100.000.22.50.R | 5.00 | 1.00 | 2.95 | 4.70 | 1.20 | 22.00 | 47.00 | 6.00 |
| 6.040 | GE106.0100.000.27.50.R | 5.00 | 1.00 | 2.95 | 4.70 | 1.20 | 27.00 | 52.00 | 6.00 |
| 6.050 | GE106.0100.000.32.50.R | 5.00 | 1.00 | 2.95 | 4.70 | 1.20 | 32.00 | 57.00 | 6.00 |
| 6.060 | GE106.0100.000.37.50.R | 5.00 | 1.00 | 2.95 | 4.70 | 1.20 | 37.00 | 62.00 | 6.00 |
| 6.070 | GE106.0100.000.42.50.R | 5.00 | 1.00 | 2.95 | 4.70 | 1.20 | 42.00 | 67.00 | 6.00 |
| 6.110 | GE106.0150.000.12.50.R | 5.00 | 1.50 | 2.95 | 4.70 | 1.20 | 12.00 | 37.00 | 6.00 |
| 6.120 | GE106.0150.000.17.50.R | 5.00 | 1.50 | 2.95 | 4.70 | 1.20 | 17.00 | 42.00 | 6.00 |
| 6.130 | GE106.0150.000.22.50.R | 5.00 | 1.50 | 2.95 | 4.70 | 1.20 | 22.00 | 47.00 | 6.00 |
| 6.140 | GE106.0150.000.27.50.R | 5.00 | 1.50 | 2.95 | 4.70 | 1.20 | 27.00 | 52.00 | 6.00 |
| 6.150 | GE106.0150.000.32.50.R | 5.00 | 1.50 | 2.95 | 4.70 | 1.20 | 32.00 | 57.00 | 6.00 |
| 6.160 | GE106.0150.000.37.50.R | 5.00 | 1.50 | 2.95 | 4.70 | 1.20 | 37.00 | 62.00 | 6.00 |
| 6.170 | GE106.0150.000.42.50.R | 5.00 | 1.50 | 2.95 | 4.70 | 1.20 | 42.00 | 67.00 | 6.00 |
| 6.210 | GE106.0200.000.12.50.R | 5.00 | 2.00 | 2.95 | 4.70 | 1.20 | 12.00 | 37.00 | 6.00 |
| 6.220 | GE106.0200.000.17.50.R | 5.00 | 2.00 | 2.95 | 4.70 | 1.20 | 17.00 | 42.00 | 6.00 |
| 6.230 | GE106.0200.000.22.50.R | 5.00 | 2.00 | 2.95 | 4.70 | 1.20 | 22.00 | 47.00 | 6.00 |
| 6.240 | GE106.0200.000.27.50.R | 5.00 | 2.00 | 2.95 | 4.70 | 1.20 | 27.00 | 52.00 | 6.00 |
| 6.250 | GE106.0200.000.32.50.R | 5.00 | 2.00 | 2.95 | 4.70 | 1.20 | 32.00 | 57.00 | 6.00 |
| 6.260 | GE106.0200.000.37.50.R | 5.00 | 2.00 | 2.95 | 4.70 | 1.20 | 37.00 | 62.00 | 6.00 |
| 6.270 | GE106.0200.000.42.50.R | 5.00 | 2.00 | 2.95 | 4.70 | 1.20 | 42.00 | 67.00 | 6.00 |

Article no. **25873** **25875** **25879**

Cutting direction **(L)** **(L)** **(L)**

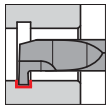
| Code no. | Description | D min | b | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm |
| 6.010 | GE106.0100.000.12.50.L | 5.00 | 1.00 | 2.95 | 4.70 | 1.20 | 12.00 | 37.00 | 6.00 |
| 6.020 | GE106.0100.000.17.50.L | 5.00 | 1.00 | 2.95 | 4.70 | 1.20 | 17.00 | 42.00 | 6.00 |
| 6.030 | GE106.0100.000.22.50.L | 5.00 | 1.00 | 2.95 | 4.70 | 1.20 | 22.00 | 47.00 | 6.00 |
| 6.040 | GE106.0100.000.27.50.L | 5.00 | 1.00 | 2.95 | 4.70 | 1.20 | 27.00 | 52.00 | 6.00 |
| 6.050 | GE106.0100.000.32.50.L | 5.00 | 1.00 | 2.95 | 4.70 | 1.20 | 32.00 | 57.00 | 6.00 |
| 6.060 | GE106.0100.000.37.50.L | 5.00 | 1.00 | 2.95 | 4.70 | 1.20 | 37.00 | 62.00 | 6.00 |

Article no. **25873** **25875** **25879**Cutting direction   

| Code no. | Description | D min | b | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm |
| 6.070 | GE106.0100.000.42.50.L | 5.00 | 1.00 | 2.95 | 4.70 | 1.20 | 42.00 | 67.00 | 6.00 |
| 6.110 | GE106.0150.000.12.50.L | 5.00 | 1.50 | 2.95 | 4.70 | 1.20 | 12.00 | 37.00 | 6.00 |
| 6.120 | GE106.0150.000.17.50.L | 5.00 | 1.50 | 2.95 | 4.70 | 1.20 | 17.00 | 42.00 | 6.00 |
| 6.130 | GE106.0150.000.22.50.L | 5.00 | 1.50 | 2.95 | 4.70 | 1.20 | 22.00 | 47.00 | 6.00 |
| 6.140 | GE106.0150.000.27.50.L | 5.00 | 1.50 | 2.95 | 4.70 | 1.20 | 27.00 | 52.00 | 6.00 |
| 6.150 | GE106.0150.000.32.50.L | 5.00 | 1.50 | 2.95 | 4.70 | 1.20 | 32.00 | 57.00 | 6.00 |
| 6.160 | GE106.0150.000.37.50.L | 5.00 | 1.50 | 2.95 | 4.70 | 1.20 | 37.00 | 62.00 | 6.00 |
| 6.170 | GE106.0150.000.42.50.L | 5.00 | 1.50 | 2.95 | 4.70 | 1.20 | 42.00 | 67.00 | 6.00 |
| 6.210 | GE106.0200.000.12.50.L | 5.00 | 2.00 | 2.95 | 4.70 | 1.20 | 12.00 | 37.00 | 6.00 |
| 6.220 | GE106.0200.000.17.50.L | 5.00 | 2.00 | 2.95 | 4.70 | 1.20 | 17.00 | 42.00 | 6.00 |
| 6.230 | GE106.0200.000.22.50.L | 5.00 | 2.00 | 2.95 | 4.70 | 1.20 | 22.00 | 47.00 | 6.00 |
| 6.240 | GE106.0200.000.27.50.L | 5.00 | 2.00 | 2.95 | 4.70 | 1.20 | 27.00 | 52.00 | 6.00 |
| 6.250 | GE106.0200.000.32.50.L | 5.00 | 2.00 | 2.95 | 4.70 | 1.20 | 32.00 | 57.00 | 6.00 |
| 6.260 | GE106.0200.000.37.50.L | 5.00 | 2.00 | 2.95 | 4.70 | 1.20 | 37.00 | 62.00 | 6.00 |
| 6.270 | GE106.0200.000.42.50.L | 5.00 | 2.00 | 2.95 | 4.70 | 1.20 | 42.00 | 67.00 | 6.00 |

System 106

Cutting insert for internal grooving, straight slots

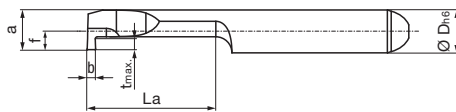
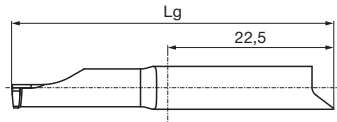


- grooving depth up to 2 mm

for tool holders type GH106/GB106 see from page 62

GUHRING NAVIGATOR

Cutting data page 184



Right hand version shown
Left hand version mirror image

| Tool material | Solid carbide | | |
|---------------|---------------|-------------|--------|
| Type | GE 106 | GE 106 | GE 106 |
| Surface | S | a | ○ |
| | TiN | TiAlN-nanoA | bright |



Article no. **25748** **25750** **25754**

Cutting direction **(R)** **(R)** **(R)**

| Code no. | Description | D min | b | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm |
| 6.001 | GE106.0100.000.12.60.R | 6.00 | 1.00 | 2.70 | 5.70 | 2.00 | 12.00 | 37.00 | 6.00 |
| 6.002 | GE106.0100.000.17.60.R | 6.00 | 1.00 | 2.70 | 5.70 | 2.00 | 17.00 | 42.00 | 6.00 |
| 6.003 | GE106.0100.000.22.60.R | 6.00 | 1.00 | 2.70 | 5.70 | 2.00 | 22.00 | 47.00 | 6.00 |
| 6.004 | GE106.0100.000.27.60.R | 6.00 | 1.00 | 2.70 | 5.70 | 2.00 | 27.00 | 52.00 | 6.00 |
| 6.005 | GE106.0100.000.32.60.R | 6.00 | 1.00 | 2.70 | 5.70 | 2.00 | 32.00 | 57.00 | 6.00 |
| 6.006 | GE106.0100.000.37.60.R | 6.00 | 1.00 | 2.70 | 5.70 | 2.00 | 37.00 | 62.00 | 6.00 |
| 6.007 | GE106.0100.000.42.60.R | 6.00 | 1.00 | 2.70 | 5.70 | 2.00 | 42.00 | 67.00 | 6.00 |
| 6.008 | GE106.0150.000.12.60.R | 6.00 | 1.50 | 2.70 | 5.70 | 2.00 | 12.00 | 37.00 | 6.00 |
| 6.009 | GE106.0150.000.17.60.R | 6.00 | 1.50 | 2.70 | 5.70 | 2.00 | 17.00 | 42.00 | 6.00 |
| 6.010 | GE106.0150.000.22.60.R | 6.00 | 1.50 | 2.70 | 5.70 | 2.00 | 22.00 | 47.00 | 6.00 |
| 6.011 | GE106.0150.000.27.60.R | 6.00 | 1.50 | 2.70 | 5.70 | 2.00 | 27.00 | 52.00 | 6.00 |
| 6.012 | GE106.0150.000.32.60.R | 6.00 | 1.50 | 2.70 | 5.70 | 2.00 | 32.00 | 57.00 | 6.00 |
| 6.013 | GE106.0150.000.37.60.R | 6.00 | 1.50 | 2.70 | 5.70 | 2.00 | 37.00 | 62.00 | 6.00 |
| 6.014 | GE106.0150.000.42.60.R | 6.00 | 1.50 | 2.70 | 5.70 | 2.00 | 42.00 | 67.00 | 6.00 |
| 6.015 | GE106.0200.000.12.60.R | 6.00 | 2.00 | 2.70 | 5.70 | 2.00 | 12.00 | 37.00 | 6.00 |
| 6.016 | GE106.0200.000.17.60.R | 6.00 | 2.00 | 2.70 | 5.70 | 2.00 | 17.00 | 42.00 | 6.00 |
| 6.017 | GE106.0200.000.22.60.R | 6.00 | 2.00 | 2.70 | 5.70 | 2.00 | 22.00 | 47.00 | 6.00 |
| 6.018 | GE106.0200.000.27.60.R | 6.00 | 2.00 | 2.70 | 5.70 | 2.00 | 27.00 | 52.00 | 6.00 |
| 6.019 | GE106.0200.000.32.60.R | 6.00 | 2.00 | 2.70 | 5.70 | 2.00 | 32.00 | 57.00 | 6.00 |
| 6.020 | GE106.0200.000.37.60.R | 6.00 | 2.00 | 2.70 | 5.70 | 2.00 | 37.00 | 62.00 | 6.00 |
| 6.021 | GE106.0200.000.42.60.R | 6.00 | 2.00 | 2.70 | 5.70 | 2.00 | 42.00 | 67.00 | 6.00 |

Article no. **25749** **25751** **25755**

Cutting direction **(L)** **(L)** **(L)**

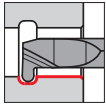
| Code no. | Description | D min | b | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm |
| 6.001 | GE106.0100.000.12.60.L | 6.00 | 1.00 | 2.70 | 5.70 | 2.00 | 12.00 | 37.00 | 6.00 |
| 6.002 | GE106.0100.000.17.60.L | 6.00 | 1.00 | 2.70 | 5.70 | 2.00 | 17.00 | 42.00 | 6.00 |
| 6.003 | GE106.0100.000.22.60.L | 6.00 | 1.00 | 2.70 | 5.70 | 2.00 | 22.00 | 47.00 | 6.00 |
| 6.004 | GE106.0100.000.27.60.L | 6.00 | 1.00 | 2.70 | 5.70 | 2.00 | 27.00 | 52.00 | 6.00 |
| 6.005 | GE106.0100.000.32.60.L | 6.00 | 1.00 | 2.70 | 5.70 | 2.00 | 32.00 | 57.00 | 6.00 |
| 6.006 | GE106.0100.000.37.60.L | 6.00 | 1.00 | 2.70 | 5.70 | 2.00 | 37.00 | 62.00 | 6.00 |

Article no. **25749** **25751** **25755**Cutting direction   

| Code no. | Description | D min | b | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm |
| 6.007 | GE106.0100.000.42.60.L | 6.00 | 1.00 | 2.70 | 5.70 | 2.00 | 42.00 | 67.00 | 6.00 |
| 6.008 | GE106.0150.000.12.60.L | 6.00 | 1.50 | 2.70 | 5.70 | 2.00 | 12.00 | 37.00 | 6.00 |
| 6.009 | GE106.0150.000.17.60.L | 6.00 | 1.50 | 2.70 | 5.70 | 2.00 | 17.00 | 42.00 | 6.00 |
| 6.010 | GE106.0150.000.22.60.L | 6.00 | 1.50 | 2.70 | 5.70 | 2.00 | 22.00 | 47.00 | 6.00 |
| 6.011 | GE106.0150.000.27.60.L | 6.00 | 1.50 | 2.70 | 5.70 | 2.00 | 27.00 | 52.00 | 6.00 |
| 6.012 | GE106.0150.000.32.60.L | 6.00 | 1.50 | 2.70 | 5.70 | 2.00 | 32.00 | 57.00 | 6.00 |
| 6.013 | GE106.0150.000.37.60.L | 6.00 | 1.50 | 2.70 | 5.70 | 2.00 | 37.00 | 62.00 | 6.00 |
| 6.014 | GE106.0150.000.42.60.L | 6.00 | 1.50 | 2.70 | 5.70 | 2.00 | 42.00 | 67.00 | 6.00 |
| 6.015 | GE106.0200.000.12.60.L | 6.00 | 2.00 | 2.70 | 5.70 | 2.00 | 12.00 | 37.00 | 6.00 |
| 6.016 | GE106.0200.000.17.60.L | 6.00 | 2.00 | 2.70 | 5.70 | 2.00 | 17.00 | 42.00 | 6.00 |
| 6.017 | GE106.0200.000.22.60.L | 6.00 | 2.00 | 2.70 | 5.70 | 2.00 | 22.00 | 47.00 | 6.00 |
| 6.018 | GE106.0200.000.27.60.L | 6.00 | 2.00 | 2.70 | 5.70 | 2.00 | 27.00 | 52.00 | 6.00 |
| 6.019 | GE106.0200.000.32.60.L | 6.00 | 2.00 | 2.70 | 5.70 | 2.00 | 32.00 | 57.00 | 6.00 |
| 6.020 | GE106.0200.000.37.60.L | 6.00 | 2.00 | 2.70 | 5.70 | 2.00 | 37.00 | 62.00 | 6.00 |
| 6.021 | GE106.0200.000.42.60.L | 6.00 | 2.00 | 2.70 | 5.70 | 2.00 | 42.00 | 67.00 | 6.00 |

System 106

Cutting insert for internal grooving, full radius slots



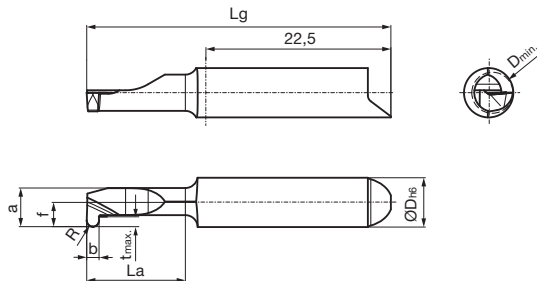
• full radius R0.5-R1.0

for tool holders type GH106/GB106 see from page 62

GUHRING NAVIGATOR

Cutting data page 184

System 106



Right hand version shown
Left hand version mirror image

| | | | |
|---------------|---------------|-------------|--------|
| Tool material | Solid carbide | | |
| Type | GE 106 | GE 106 | GE 106 |
| Surface | S | a | ○ |
| | TiN | TiAlN-nanoA | bright |



Article no. **25880** **25882** **25886**

Cutting direction **(R)** **(R)** **(R)**

| Code no. | Description | D min | b | R | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm | mm |
| 6.010 | GE106.0100.050.12.50.R | 5.00 | 1.00 | 0.50 | 2.95 | 4.70 | 1.20 | 12.00 | 37.00 | 6.00 |
| 6.020 | GE106.0100.050.17.50.R | 5.00 | 1.00 | 0.50 | 2.95 | 4.70 | 1.20 | 17.00 | 42.00 | 6.00 |
| 6.030 | GE106.0100.050.22.50.R | 5.00 | 1.00 | 0.50 | 2.95 | 4.70 | 1.20 | 22.00 | 47.00 | 6.00 |
| 6.040 | GE106.0100.050.27.50.R | 5.00 | 1.00 | 0.50 | 2.95 | 4.70 | 1.20 | 27.00 | 52.00 | 6.00 |
| 6.050 | GE106.0100.050.32.50.R | 5.00 | 1.00 | 0.50 | 2.95 | 4.70 | 1.20 | 32.00 | 57.00 | 6.00 |
| 6.060 | GE106.0100.050.37.50.R | 5.00 | 1.00 | 0.50 | 2.95 | 4.70 | 1.20 | 37.00 | 62.00 | 6.00 |
| 6.070 | GE106.0100.050.42.50.R | 5.00 | 1.00 | 0.50 | 2.95 | 4.70 | 1.20 | 42.00 | 67.00 | 6.00 |
| 6.110 | GE106.0150.075.12.50.R | 5.00 | 1.50 | 0.75 | 2.95 | 4.70 | 1.20 | 12.00 | 37.00 | 6.00 |
| 6.120 | GE106.0150.075.17.50.R | 5.00 | 1.50 | 0.75 | 2.95 | 4.70 | 1.20 | 17.00 | 42.00 | 6.00 |
| 6.130 | GE106.0150.075.22.50.R | 5.00 | 1.50 | 0.75 | 2.95 | 4.70 | 1.20 | 22.00 | 47.00 | 6.00 |
| 6.140 | GE106.0150.075.27.50.R | 5.00 | 1.50 | 0.75 | 2.95 | 4.70 | 1.20 | 27.00 | 52.00 | 6.00 |
| 6.150 | GE106.0150.075.32.50.R | 5.00 | 1.50 | 0.75 | 2.95 | 4.70 | 1.20 | 32.00 | 57.00 | 6.00 |
| 6.160 | GE106.0150.075.37.50.R | 5.00 | 1.50 | 0.75 | 2.95 | 4.70 | 1.20 | 37.00 | 62.00 | 6.00 |
| 6.170 | GE106.0150.075.42.50.R | 5.00 | 1.50 | 0.75 | 2.95 | 4.70 | 1.20 | 42.00 | 67.00 | 6.00 |
| 6.210 | GE106.0200.100.12.50.R | 5.00 | 2.00 | 1.00 | 2.95 | 4.70 | 1.20 | 12.00 | 37.00 | 6.00 |
| 6.220 | GE106.0200.100.17.50.R | 5.00 | 2.00 | 1.00 | 2.95 | 4.70 | 1.20 | 17.00 | 42.00 | 6.00 |
| 6.230 | GE106.0200.100.22.50.R | 5.00 | 2.00 | 1.00 | 2.95 | 4.70 | 1.20 | 22.00 | 47.00 | 6.00 |
| 6.240 | GE106.0200.100.27.50.R | 5.00 | 2.00 | 1.00 | 2.95 | 4.70 | 1.20 | 27.00 | 52.00 | 6.00 |
| 6.250 | GE106.0200.100.32.50.R | 5.00 | 2.00 | 1.00 | 2.95 | 4.70 | 1.20 | 32.00 | 57.00 | 6.00 |
| 6.260 | GE106.0200.100.37.50.R | 5.00 | 2.00 | 1.00 | 2.95 | 4.70 | 1.20 | 37.00 | 62.00 | 6.00 |
| 6.270 | GE106.0200.100.42.50.R | 5.00 | 2.00 | 1.00 | 2.95 | 4.70 | 1.20 | 42.00 | 67.00 | 6.00 |

Article no. **25881** **25883** **25887**

Cutting direction **(L)** **(L)** **(L)**

| Code no. | Description | D min | b | R | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm | mm |
| 6.010 | GE106.0100.050.12.50.L | 5.00 | 1.00 | 0.50 | 2.95 | 4.70 | 1.20 | 12.00 | 37.00 | 6.00 |
| 6.020 | GE106.0100.050.17.50.L | 5.00 | 1.00 | 0.50 | 2.95 | 4.70 | 1.20 | 17.00 | 42.00 | 6.00 |
| 6.030 | GE106.0100.050.22.50.L | 5.00 | 1.00 | 0.50 | 2.95 | 4.70 | 1.20 | 22.00 | 47.00 | 6.00 |
| 6.040 | GE106.0100.050.27.50.L | 5.00 | 1.00 | 0.50 | 2.95 | 4.70 | 1.20 | 27.00 | 52.00 | 6.00 |
| 6.050 | GE106.0100.050.32.50.L | 5.00 | 1.00 | 0.50 | 2.95 | 4.70 | 1.20 | 32.00 | 57.00 | 6.00 |
| 6.060 | GE106.0100.050.37.50.L | 5.00 | 1.00 | 0.50 | 2.95 | 4.70 | 1.20 | 37.00 | 62.00 | 6.00 |

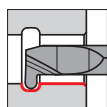
Article no. **25881** **25883** **25887**Cutting direction   

| Code no. | Description | D min | b | R | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm | mm |
| 6.070 | GE106.0100.050.42.50.L | 5.00 | 1.00 | 0.50 | 2.95 | 4.70 | 1.20 | 42.00 | 67.00 | 6.00 |
| 6.110 | GE106.0150.075.12.50.L | 5.00 | 1.50 | 0.75 | 2.95 | 4.70 | 1.20 | 12.00 | 37.00 | 6.00 |
| 6.120 | GE106.0150.075.17.50.L | 5.00 | 1.50 | 0.75 | 2.95 | 4.70 | 1.20 | 17.00 | 42.00 | 6.00 |
| 6.130 | GE106.0150.075.22.50.L | 5.00 | 1.50 | 0.75 | 2.95 | 4.70 | 1.20 | 22.00 | 47.00 | 6.00 |
| 6.140 | GE106.0150.075.27.50.L | 5.00 | 1.50 | 0.75 | 2.95 | 4.70 | 1.20 | 27.00 | 52.00 | 6.00 |
| 6.150 | GE106.0150.075.32.50.L | 5.00 | 1.50 | 0.75 | 2.95 | 4.70 | 1.20 | 32.00 | 57.00 | 6.00 |
| 6.160 | GE106.0150.075.37.50.L | 5.00 | 1.50 | 0.75 | 2.95 | 4.70 | 1.20 | 37.00 | 62.00 | 6.00 |
| 6.170 | GE106.0150.075.42.50.L | 5.00 | 1.50 | 0.75 | 2.95 | 4.70 | 1.20 | 42.00 | 67.00 | 6.00 |
| 6.210 | GE106.0200.100.12.50.L | 5.00 | 2.00 | 1.00 | 2.95 | 4.70 | 1.20 | 12.00 | 37.00 | 6.00 |
| 6.220 | GE106.0200.100.17.50.L | 5.00 | 2.00 | 1.00 | 2.95 | 4.70 | 1.20 | 17.00 | 42.00 | 6.00 |
| 6.230 | GE106.0200.100.22.50.L | 5.00 | 2.00 | 1.00 | 2.95 | 4.70 | 1.20 | 22.00 | 47.00 | 6.00 |
| 6.240 | GE106.0200.100.27.50.L | 5.00 | 2.00 | 1.00 | 2.95 | 4.70 | 1.20 | 27.00 | 52.00 | 6.00 |
| 6.250 | GE106.0200.100.32.50.L | 5.00 | 2.00 | 1.00 | 2.95 | 4.70 | 1.20 | 32.00 | 57.00 | 6.00 |
| 6.260 | GE106.0200.100.37.50.L | 5.00 | 2.00 | 1.00 | 2.95 | 4.70 | 1.20 | 37.00 | 62.00 | 6.00 |
| 6.270 | GE106.0200.100.42.50.L | 5.00 | 2.00 | 1.00 | 2.95 | 4.70 | 1.20 | 42.00 | 67.00 | 6.00 |

System 106



Cutting insert for internal grooving, full radius slots

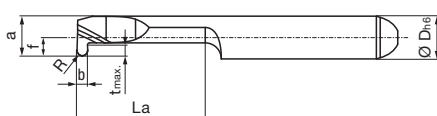
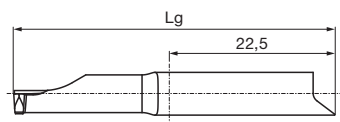


• full radius R0.5-R1.0

for tool holders type GH106/GB106 see from page 62

GUHRING NAVIGATOR

Cutting data page 184



Right hand version shown
Left hand version mirror image



Article no. **25756** **25758** **25762**

Cutting direction

| Code no. | Description | D min | b | R | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm | mm |
| 6.001 | GE106.0100.050.12.60.R | 6.00 | 1.00 | 0.50 | 2.70 | 5.70 | 2.00 | 12.00 | 37.00 | 6.00 |
| 6.002 | GE106.0100.050.17.60.R | 6.00 | 1.00 | 0.50 | 2.70 | 5.70 | 2.00 | 17.00 | 42.00 | 6.00 |
| 6.003 | GE106.0100.050.22.60.R | 6.00 | 1.00 | 0.50 | 2.70 | 5.70 | 2.00 | 22.00 | 47.00 | 6.00 |
| 6.004 | GE106.0100.050.27.60.R | 6.00 | 1.00 | 0.50 | 2.70 | 5.70 | 2.00 | 27.00 | 52.00 | 6.00 |
| 6.005 | GE106.0100.050.32.60.R | 6.00 | 1.00 | 0.50 | 2.70 | 5.70 | 2.00 | 32.00 | 57.00 | 6.00 |
| 6.006 | GE106.0100.050.37.60.R | 6.00 | 1.00 | 0.50 | 2.70 | 5.70 | 2.00 | 37.00 | 62.00 | 6.00 |
| 6.007 | GE106.0100.050.42.60.R | 6.00 | 1.00 | 0.50 | 2.70 | 5.70 | 2.00 | 42.00 | 67.00 | 6.00 |
| 6.008 | GE106.0150.075.12.60.R | 6.00 | 1.50 | 0.75 | 2.70 | 5.70 | 2.00 | 12.00 | 37.00 | 6.00 |
| 6.009 | GE106.0150.075.17.60.R | 6.00 | 1.50 | 0.75 | 2.70 | 5.70 | 2.00 | 17.00 | 42.00 | 6.00 |
| 6.010 | GE106.0150.075.22.60.R | 6.00 | 1.50 | 0.75 | 2.70 | 5.70 | 2.00 | 22.00 | 47.00 | 6.00 |
| 6.011 | GE106.0150.075.27.60.R | 6.00 | 1.50 | 0.75 | 2.70 | 5.70 | 2.00 | 27.00 | 52.00 | 6.00 |
| 6.012 | GE106.0150.075.32.60.R | 6.00 | 1.50 | 0.75 | 2.70 | 5.70 | 2.00 | 32.00 | 57.00 | 6.00 |
| 6.013 | GE106.0150.075.37.60.R | 6.00 | 1.50 | 0.75 | 2.70 | 5.70 | 2.00 | 37.00 | 62.00 | 6.00 |
| 6.014 | GE106.0150.075.42.60.R | 6.00 | 1.50 | 0.75 | 2.70 | 5.70 | 2.00 | 42.00 | 67.00 | 6.00 |
| 6.015 | GE106.0200.100.12.60.R | 6.00 | 2.00 | 1.00 | 2.70 | 5.70 | 2.00 | 12.00 | 37.00 | 6.00 |
| 6.016 | GE106.0200.100.17.60.R | 6.00 | 2.00 | 1.00 | 2.70 | 5.70 | 2.00 | 17.00 | 42.00 | 6.00 |
| 6.017 | GE106.0200.100.22.60.R | 6.00 | 2.00 | 1.00 | 2.70 | 5.70 | 2.00 | 22.00 | 47.00 | 6.00 |
| 6.018 | GE106.0200.100.27.60.R | 6.00 | 2.00 | 1.00 | 2.70 | 5.70 | 2.00 | 27.00 | 52.00 | 6.00 |
| 6.019 | GE106.0200.100.32.60.R | 6.00 | 2.00 | 1.00 | 2.70 | 5.70 | 2.00 | 32.00 | 57.00 | 6.00 |
| 6.020 | GE106.0200.100.37.60.R | 6.00 | 2.00 | 1.00 | 2.70 | 5.70 | 2.00 | 37.00 | 62.00 | 6.00 |
| 6.021 | GE106.0200.100.42.60.R | 6.00 | 2.00 | 1.00 | 2.70 | 5.70 | 2.00 | 42.00 | 67.00 | 6.00 |

Article no. **25757** **25759** **25763**

Cutting direction

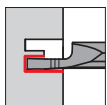
| Code no. | Description | D min | b | R | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm | mm |
| 6.001 | GE106.0100.050.12.60.L | 6.00 | 1.00 | 0.50 | 2.70 | 5.70 | 2.00 | 12.00 | 37.00 | 6.00 |
| 6.002 | GE106.0100.050.17.60.L | 6.00 | 1.00 | 0.50 | 2.70 | 5.70 | 2.00 | 17.00 | 42.00 | 6.00 |
| 6.003 | GE106.0100.050.22.60.L | 6.00 | 1.00 | 0.50 | 2.70 | 5.70 | 2.00 | 22.00 | 47.00 | 6.00 |
| 6.004 | GE106.0100.050.27.60.L | 6.00 | 1.00 | 0.50 | 2.70 | 5.70 | 2.00 | 27.00 | 52.00 | 6.00 |
| 6.005 | GE106.0100.050.32.60.L | 6.00 | 1.00 | 0.50 | 2.70 | 5.70 | 2.00 | 32.00 | 57.00 | 6.00 |
| 6.006 | GE106.0100.050.37.60.L | 6.00 | 1.00 | 0.50 | 2.70 | 5.70 | 2.00 | 37.00 | 62.00 | 6.00 |

Article no. **25757** **25759** **25763**Cutting direction   

| Code no. | Description | D min | b | R | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm | mm |
| 6.007 | GE106.0100.050.42.60.L | 6.00 | 1.00 | 0.50 | 2.70 | 5.70 | 2.00 | 42.00 | 67.00 | 6.00 |
| 6.008 | GE106.0150.075.12.60.L | 6.00 | 1.50 | 0.75 | 2.70 | 5.70 | 2.00 | 12.00 | 37.00 | 6.00 |
| 6.009 | GE106.0150.075.17.60.L | 6.00 | 1.50 | 0.75 | 2.70 | 5.70 | 2.00 | 17.00 | 42.00 | 6.00 |
| 6.010 | GE106.0150.075.22.60.L | 6.00 | 1.50 | 0.75 | 2.70 | 5.70 | 2.00 | 22.00 | 47.00 | 6.00 |
| 6.011 | GE106.0150.075.27.60.L | 6.00 | 1.50 | 0.75 | 2.70 | 5.70 | 2.00 | 27.00 | 52.00 | 6.00 |
| 6.012 | GE106.0150.075.32.60.L | 6.00 | 1.50 | 0.75 | 2.70 | 5.70 | 2.00 | 32.00 | 57.00 | 6.00 |
| 6.013 | GE106.0150.075.37.60.L | 6.00 | 1.50 | 0.75 | 2.70 | 5.70 | 2.00 | 37.00 | 62.00 | 6.00 |
| 6.014 | GE106.0150.075.42.60.L | 6.00 | 1.50 | 0.75 | 2.70 | 5.70 | 2.00 | 42.00 | 67.00 | 6.00 |
| 6.015 | GE106.0200.100.12.60.L | 6.00 | 2.00 | 1.00 | 2.70 | 5.70 | 2.00 | 12.00 | 37.00 | 6.00 |
| 6.016 | GE106.0200.100.17.60.L | 6.00 | 2.00 | 1.00 | 2.70 | 5.70 | 2.00 | 17.00 | 42.00 | 6.00 |
| 6.017 | GE106.0200.100.22.60.L | 6.00 | 2.00 | 1.00 | 2.70 | 5.70 | 2.00 | 22.00 | 47.00 | 6.00 |
| 6.018 | GE106.0200.100.27.60.L | 6.00 | 2.00 | 1.00 | 2.70 | 5.70 | 2.00 | 27.00 | 52.00 | 6.00 |
| 6.019 | GE106.0200.100.32.60.L | 6.00 | 2.00 | 1.00 | 2.70 | 5.70 | 2.00 | 32.00 | 57.00 | 6.00 |
| 6.020 | GE106.0200.100.37.60.L | 6.00 | 2.00 | 1.00 | 2.70 | 5.70 | 2.00 | 37.00 | 62.00 | 6.00 |
| 6.021 | GE106.0200.100.42.60.L | 6.00 | 2.00 | 1.00 | 2.70 | 5.70 | 2.00 | 42.00 | 67.00 | 6.00 |

System 106

Cutting insert for axial grooving bores, straight slots

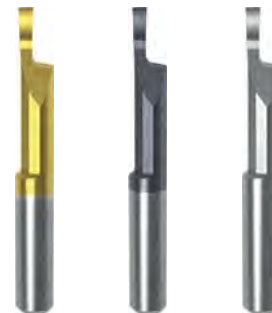
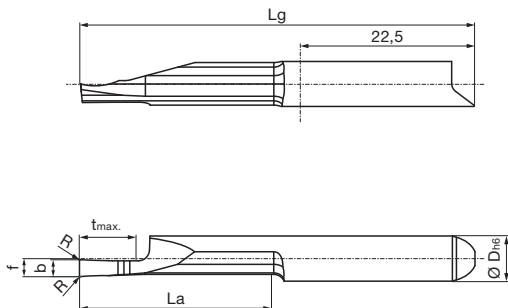


• grooving depth up to 8 mm

for tool holders type GH106/GB106 see from page 62

GUHRING NAVIGATOR

Cutting data page 184



Right hand version shown
Left hand version mirror image

Article no. **25780** **25782** **25786**

Cutting direction

| Code no. | Description | D min | b | R | f | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm |
| 6.001 | GA106.0150.010.17.60.R | 6.00 | 1.50 | 0.10 | 2.60 | 5.00 | 17.00 | 42.00 | 6.00 |
| 6.002 | GA106.0150.010.22.60.R | 6.00 | 1.50 | 0.10 | 2.60 | 5.00 | 22.00 | 47.00 | 6.00 |
| 6.003 | GA106.0200.015.17.60.R | 6.00 | 2.00 | 0.15 | 2.60 | 8.00 | 17.00 | 42.00 | 6.00 |
| 6.004 | GA106.0200.015.22.60.R | 6.00 | 2.00 | 0.15 | 2.60 | 8.00 | 22.00 | 47.00 | 6.00 |

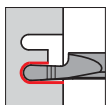
Article no. **25781** **25783** **25787**

Cutting direction

| Code no. | Description | D min | b | R | f | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm |
| 6.001 | GA106.0150.010.17.60.L | 6.00 | 1.50 | 0.10 | 2.60 | 5.00 | 17.00 | 42.00 | 6.00 |
| 6.002 | GA106.0150.010.22.60.L | 6.00 | 1.50 | 0.10 | 2.60 | 5.00 | 22.00 | 47.00 | 6.00 |
| 6.003 | GA106.0200.015.17.60.L | 6.00 | 2.00 | 0.15 | 2.60 | 8.00 | 17.00 | 42.00 | 6.00 |
| 6.004 | GA106.0200.015.22.60.L | 6.00 | 2.00 | 0.15 | 2.60 | 8.00 | 22.00 | 47.00 | 6.00 |



Cutting insert for axial grooving bores, full radius slots

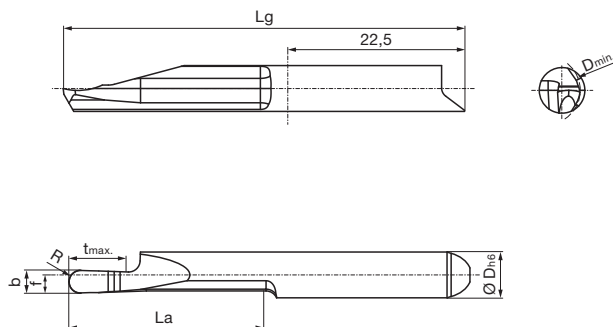


- grooving depth up to 8 mm

for tool holders type GH106/GB106 see from page 62

GUHRING NAVIGATOR

Cutting data page 184



Right hand version shown
Left hand version mirror image



Article no. **25788** **25790** **25794**

Cutting direction

| Code no. | Description | D min | b | R | f | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm |
| 6.001 | GA106.0150.075.17.60.R | 6.00 | 1.50 | 0.75 | 2.60 | 5.00 | 17.00 | 42.00 | 6.00 |
| 6.002 | GA106.0150.075.22.60.R | 6.00 | 1.50 | 0.75 | 2.60 | 5.00 | 22.00 | 47.00 | 6.00 |
| 6.003 | GA106.0200.100.17.60.R | 6.00 | 2.00 | 1.00 | 2.60 | 8.00 | 17.00 | 42.00 | 6.00 |
| 6.004 | GA106.0200.100.22.60.R | 6.00 | 2.00 | 1.00 | 2.60 | 8.00 | 22.00 | 47.00 | 6.00 |

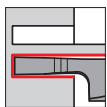
Article no. **25789** **25791** **25795**

Cutting direction

| Code no. | Description | D min | b | R | f | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm |
| 6.001 | GA106.0150.075.17.60.L | 6.00 | 1.50 | 0.75 | 2.60 | 5.00 | 17.00 | 42.00 | 6.00 |
| 6.002 | GA106.0150.075.22.60.L | 6.00 | 1.50 | 0.75 | 2.60 | 5.00 | 22.00 | 47.00 | 6.00 |
| 6.003 | GA106.0200.100.17.60.L | 6.00 | 2.00 | 1.00 | 2.60 | 8.00 | 17.00 | 42.00 | 6.00 |
| 6.004 | GA106.0200.100.22.60.L | 6.00 | 2.00 | 1.00 | 2.60 | 8.00 | 22.00 | 47.00 | 6.00 |

System 106

Cutting insert for axial grooving studs, straight slots

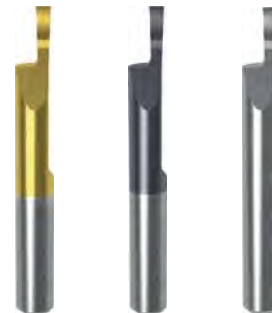
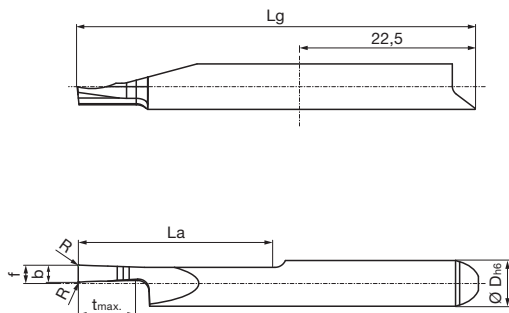


• grooving depth up to 8 mm

for tool holders type GH106/GB106 see from page 62

GUHRING NAVIGATOR

Cutting data page 184



Right hand version shown
Left hand version mirror image

Article no. **25796** **25798** **25802**

Cutting direction

| Code no. | Description | D min | b | R | f | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm |
| 6.001 | GA106.Z150.010.17.60.R | 6.00 | 1.50 | 0.10 | 2.60 | 5.00 | 17.00 | 42.00 | 6.00 |
| 6.002 | GA106.Z150.010.22.60.R | 6.00 | 1.50 | 0.10 | 2.60 | 5.00 | 22.00 | 47.00 | 6.00 |
| 6.003 | GA106.Z200.015.17.60.R | 6.00 | 2.00 | 0.15 | 2.60 | 8.00 | 17.00 | 42.00 | 6.00 |
| 6.004 | GA106.Z200.015.22.60.R | 6.00 | 2.00 | 0.15 | 2.60 | 8.00 | 22.00 | 47.00 | 6.00 |

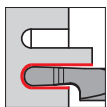
Article no. **25797** **25799** **25803**

Cutting direction

| Code no. | Description | D min | b | R | f | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm |
| 6.001 | GA106.Z150.010.17.60.L | 6.00 | 1.50 | 0.10 | 2.60 | 5.00 | 17.00 | 42.00 | 6.00 |
| 6.002 | GA106.Z150.010.22.60.L | 6.00 | 1.50 | 0.10 | 2.60 | 5.00 | 22.00 | 47.00 | 6.00 |
| 6.003 | GA106.Z200.015.17.60.L | 6.00 | 2.00 | 0.15 | 2.60 | 8.00 | 17.00 | 42.00 | 6.00 |
| 6.004 | GA106.Z200.015.22.60.L | 6.00 | 2.00 | 0.15 | 2.60 | 8.00 | 22.00 | 47.00 | 6.00 |



Cutting insert for axial grooving studs, full radius slots

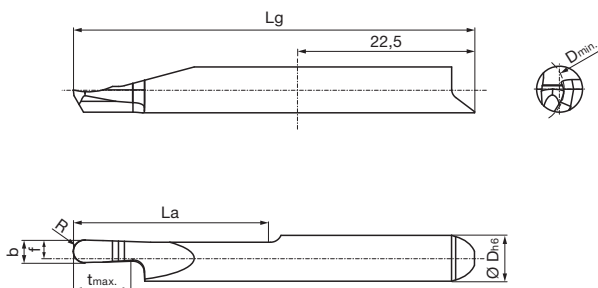


- grooving depth up to 8 mm

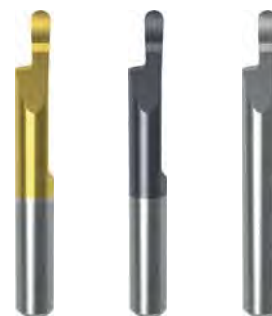
for tool holders type GH106/GB106 see from page 62

GUHRING NAVIGATOR

Cutting data page 184



Right hand version shown
Left hand version mirror image



System 106

Article no. **25804** **25806** **25810**

Cutting direction

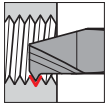
| Code no. | Description | D min | b | R | f | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm |
| 6.001 | GA106.Z150.075.17.60.R | 6.00 | 1.50 | 0.75 | 2.60 | 5.00 | 17.00 | 42.00 | 6.00 |
| 6.002 | GA106.Z150.075.22.60.R | 6.00 | 1.50 | 0.75 | 2.60 | 5.00 | 22.00 | 47.00 | 6.00 |
| 6.003 | GA106.Z200.100.17.60.R | 6.00 | 2.00 | 1.00 | 2.60 | 8.00 | 17.00 | 42.00 | 6.00 |
| 6.004 | GA106.Z200.100.22.60.R | 6.00 | 2.00 | 1.00 | 2.60 | 8.00 | 22.00 | 47.00 | 6.00 |

Article no. **25805** **25807** **25811**

Cutting direction

| Code no. | Description | D min | b | R | f | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm |
| 6.001 | GA106.Z150.075.17.60.L | 6.00 | 1.50 | 0.75 | 2.60 | 5.00 | 17.00 | 42.00 | 6.00 |
| 6.002 | GA106.Z150.075.22.60.L | 6.00 | 1.50 | 0.75 | 2.60 | 5.00 | 22.00 | 47.00 | 6.00 |
| 6.003 | GA106.Z200.100.17.60.L | 6.00 | 2.00 | 1.00 | 2.60 | 8.00 | 17.00 | 42.00 | 6.00 |
| 6.004 | GA106.Z200.100.22.60.L | 6.00 | 2.00 | 1.00 | 2.60 | 8.00 | 22.00 | 47.00 | 6.00 |

Cutting insert for internal threading, part profile - metric standard threads



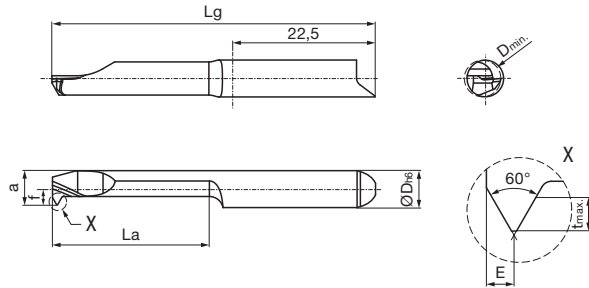
• pitch P = 1.25-1.75

for tool holders type GH106/GB106 see from page 62

GUHRING NAVIGATOR

Cutting data page 184

System 106



Right hand version shown
Left hand version mirror image

Article no. **25764** **25766** **25770**

Cutting direction

| Code no. | Description | G | P | D min | f | E | a | t max | La | Lg | D h6 |
|----------|------------------------|-----|------|-------|------|------|------|-------|-------|-------|------|
| | | | mm | mm | mm | mm | mm | mm | mm | mm | mm |
| 6.010 | GG106.TM08.125.12.68.R | M8 | 1.25 | 6.80 | 2.95 | 0.70 | 5.95 | 0.70 | 12.00 | 37.00 | 6.00 |
| 6.001 | GG106.TM08.125.17.68.R | M8 | 1.25 | 6.80 | 2.95 | 0.70 | 5.95 | 0.70 | 17.00 | 42.00 | 6.00 |
| 6.002 | GG106.TM08.125.22.68.R | M8 | 1.25 | 6.80 | 2.95 | 0.70 | 5.95 | 0.70 | 22.00 | 47.00 | 6.00 |
| 6.003 | GG106.TM08.125.27.68.R | M8 | 1.25 | 6.80 | 2.95 | 0.70 | 5.95 | 0.70 | 27.00 | 52.00 | 6.00 |
| 6.011 | GG106.TM08.125.32.68.R | M8 | 1.25 | 6.80 | 2.95 | 0.70 | 5.95 | 0.70 | 32.00 | 57.00 | 6.00 |
| 6.012 | GG106.TM08.125.37.68.R | M8 | 1.25 | 6.80 | 2.95 | 0.70 | 5.95 | 0.70 | 37.00 | 62.00 | 6.00 |
| 6.013 | GG106.TM08.125.42.68.R | M8 | 1.25 | 6.80 | 2.95 | 0.70 | 5.95 | 0.70 | 42.00 | 67.00 | 6.00 |
| 6.014 | GG106.TM10.150.12.85.R | M10 | 1.50 | 8.50 | 2.95 | 0.85 | 5.95 | 0.85 | 12.00 | 37.00 | 6.00 |
| 6.004 | GG106.TM10.150.17.85.R | M10 | 1.50 | 8.50 | 2.95 | 0.85 | 5.95 | 0.85 | 17.00 | 42.00 | 6.00 |
| 6.005 | GG106.TM10.150.22.85.R | M10 | 1.50 | 8.50 | 2.95 | 0.85 | 5.95 | 0.85 | 22.00 | 47.00 | 6.00 |
| 6.006 | GG106.TM10.150.27.85.R | M10 | 1.50 | 8.50 | 2.95 | 0.85 | 5.95 | 0.85 | 27.00 | 52.00 | 6.00 |
| 6.015 | GG106.TM10.150.32.85.R | M10 | 1.50 | 8.50 | 2.95 | 0.85 | 5.95 | 0.85 | 32.00 | 57.00 | 6.00 |
| 6.016 | GG106.TM10.150.37.85.R | M10 | 1.50 | 8.50 | 2.95 | 0.85 | 5.95 | 0.85 | 37.00 | 62.00 | 6.00 |
| 6.017 | GG106.TM10.150.42.85.R | M10 | 1.50 | 8.50 | 2.95 | 0.85 | 5.95 | 0.85 | 42.00 | 67.00 | 6.00 |
| 6.018 | GG106.TM12.175.12.99.R | M12 | 1.75 | 10.20 | 2.95 | 1.00 | 5.95 | 1.00 | 12.00 | 37.00 | 6.00 |
| 6.007 | GG106.TM12.175.17.99.R | M12 | 1.75 | 10.20 | 2.95 | 1.00 | 5.95 | 1.00 | 17.00 | 42.00 | 6.00 |
| 6.008 | GG106.TM12.175.22.99.R | M12 | 1.75 | 10.20 | 2.95 | 1.00 | 5.95 | 1.00 | 22.00 | 47.00 | 6.00 |
| 6.009 | GG106.TM12.175.27.99.R | M12 | 1.75 | 10.20 | 2.95 | 1.00 | 5.95 | 1.00 | 27.00 | 52.00 | 6.00 |
| 6.019 | GG106.TM12.175.32.99.R | M12 | 1.75 | 10.20 | 2.95 | 1.00 | 5.95 | 1.00 | 32.00 | 57.00 | 6.00 |
| 6.020 | GG106.TM12.175.37.99.R | M12 | 1.75 | 10.20 | 2.95 | 1.00 | 5.95 | 1.00 | 37.00 | 62.00 | 6.00 |
| 6.021 | GG106.TM12.175.42.99.R | M12 | 1.75 | 10.20 | 2.95 | 1.00 | 5.95 | 1.00 | 42.00 | 67.00 | 6.00 |

Article no. **25765** **25767** **25771**

Cutting direction

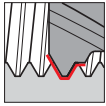
| Code no. | Description | G | P | D min | f | E | a | t max | La | Lg | D h6 |
|----------|------------------------|----|------|-------|------|------|------|-------|-------|-------|------|
| | | | mm | mm | mm | mm | mm | mm | mm | mm | mm |
| 6.010 | GG106.TM08.125.12.68.L | M8 | 1.25 | 6.80 | 2.95 | 0.70 | 5.95 | 0.70 | 12.00 | 37.00 | 6.00 |
| 6.001 | GG106.TM08.125.17.68.L | M8 | 1.25 | 6.80 | 2.95 | 0.70 | 5.95 | 0.70 | 17.00 | 42.00 | 6.00 |
| 6.002 | GG106.TM08.125.22.68.L | M8 | 1.25 | 6.80 | 2.95 | 0.70 | 5.95 | 0.70 | 22.00 | 47.00 | 6.00 |
| 6.003 | GG106.TM08.125.27.68.L | M8 | 1.25 | 6.80 | 2.95 | 0.70 | 5.95 | 0.70 | 27.00 | 52.00 | 6.00 |
| 6.011 | GG106.TM08.125.32.68.L | M8 | 1.25 | 6.80 | 2.95 | 0.70 | 5.95 | 0.70 | 32.00 | 57.00 | 6.00 |
| 6.012 | GG106.TM08.125.37.68.L | M8 | 1.25 | 6.80 | 2.95 | 0.70 | 5.95 | 0.70 | 37.00 | 62.00 | 6.00 |

Article no. **25765** **25767** **25771**Cutting direction   

| Code no. | Description | G | P | D min | f | E | a | t max | La | Lg | D h6 |
|----------|------------------------|-----|------|-------|------|------|------|-------|-------|-------|------|
| | | | mm | mm | mm | mm | mm | mm | mm | mm | mm |
| 6.013 | GG106.TM08.125.42.68.L | M8 | 1.25 | 6.80 | 2.95 | 0.70 | 5.95 | 0.70 | 42.00 | 67.00 | 6.00 |
| 6.014 | GG106.TM10.150.12.85.L | M10 | 1.50 | 8.50 | 2.95 | 0.85 | 5.95 | 0.85 | 12.00 | 37.00 | 6.00 |
| 6.004 | GG106.TM10.150.17.85.L | M10 | 1.50 | 8.50 | 2.95 | 0.85 | 5.95 | 0.85 | 17.00 | 42.00 | 6.00 |
| 6.005 | GG106.TM10.150.22.85.L | M10 | 1.50 | 8.50 | 2.95 | 0.85 | 5.95 | 0.85 | 22.00 | 47.00 | 6.00 |
| 6.006 | GG106.TM10.150.27.85.L | M10 | 1.50 | 8.50 | 2.95 | 0.85 | 5.95 | 0.85 | 27.00 | 52.00 | 6.00 |
| 6.015 | GG106.TM10.150.32.85.L | M10 | 1.50 | 8.50 | 2.95 | 0.85 | 5.95 | 0.85 | 32.00 | 57.00 | 6.00 |
| 6.016 | GG106.TM10.150.37.85.L | M10 | 1.50 | 8.50 | 2.95 | 0.85 | 5.95 | 0.85 | 37.00 | 62.00 | 6.00 |
| 6.017 | GG106.TM10.150.42.85.L | M10 | 1.50 | 8.50 | 2.95 | 0.85 | 5.95 | 0.85 | 42.00 | 67.00 | 6.00 |
| 6.018 | GG106.TM12.175.12.99.L | M12 | 1.75 | 10.20 | 2.95 | 1.00 | 5.95 | 1.00 | 12.00 | 37.00 | 6.00 |
| 6.007 | GG106.TM12.175.17.99.L | M12 | 1.75 | 10.20 | 2.95 | 1.00 | 5.95 | 1.00 | 17.00 | 42.00 | 6.00 |
| 6.008 | GG106.TM12.175.22.99.L | M12 | 1.75 | 10.20 | 2.95 | 1.00 | 5.95 | 1.00 | 22.00 | 47.00 | 6.00 |
| 6.009 | GG106.TM12.175.27.99.L | M12 | 1.75 | 10.20 | 2.95 | 1.00 | 5.95 | 1.00 | 27.00 | 52.00 | 6.00 |
| 6.019 | GG106.TM12.175.32.99.L | M12 | 1.75 | 10.20 | 2.95 | 1.00 | 5.95 | 1.00 | 32.00 | 57.00 | 6.00 |
| 6.020 | GG106.TM12.175.37.99.L | M12 | 1.75 | 10.20 | 2.95 | 1.00 | 5.95 | 1.00 | 37.00 | 62.00 | 6.00 |
| 6.021 | GG106.TM12.175.42.99.L | M12 | 1.75 | 10.20 | 2.95 | 1.00 | 5.95 | 1.00 | 42.00 | 67.00 | 6.00 |

System 106

Cutting insert for internal threading, full profile - metric standard threads



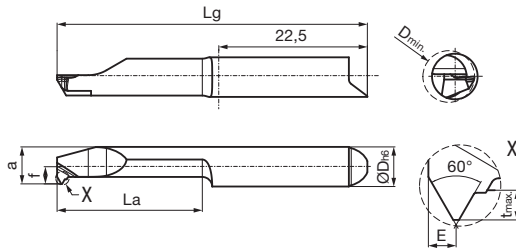
• pitch P = 1-1.75

for tool holders type GH106/GB106 see from page 62

GUHRING NAVIGATOR

Cutting data page 184

System 106



Right hand version shown
Left hand version mirror image

| | | | |
|-------------------|--------------|--------------|--------------|
| Article no. | 25772 | 25774 | 25778 |
| Cutting direction | | | |

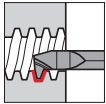
| Code no. | Description | G | P | D min | f | E | a | t max | La | Lg | D h6 |
|----------|------------------------|-----|------|-------|------|------|------|-------|-------|-------|------|
| | | | mm | mm | mm | mm | mm | mm | mm | mm | mm |
| 6.010 | GG106.VM06.100.12.50.R | M6 | 1.00 | 5.00 | 2.95 | 0.50 | 4.50 | 0.60 | 12.00 | 37.00 | 6.00 |
| 6.020 | GG106.VM06.100.17.50.R | M6 | 1.00 | 5.00 | 2.95 | 0.50 | 4.50 | 0.60 | 17.00 | 42.00 | 6.00 |
| 6.030 | GG106.VM06.100.22.50.R | M6 | 1.00 | 5.00 | 2.95 | 0.50 | 4.50 | 0.60 | 22.00 | 47.00 | 6.00 |
| 6.040 | GG106.VM06.100.27.50.R | M6 | 1.00 | 5.00 | 2.95 | 0.50 | 4.50 | 0.60 | 27.00 | 52.00 | 6.00 |
| 6.050 | GG106.VM06.100.32.50.R | M6 | 1.00 | 5.00 | 2.95 | 0.50 | 4.50 | 0.60 | 32.00 | 57.00 | 6.00 |
| 6.060 | GG106.VM06.100.37.50.R | M6 | 1.00 | 5.00 | 2.95 | 0.50 | 4.50 | 0.60 | 37.00 | 62.00 | 6.00 |
| 6.070 | GG106.VM06.100.42.50.R | M6 | 1.00 | 5.00 | 2.95 | 0.50 | 4.50 | 0.60 | 42.00 | 67.00 | 6.00 |
| 6.110 | GG106.VM08.125.12.68.R | M8 | 1.25 | 6.80 | 2.95 | 0.70 | 5.95 | 0.75 | 12.00 | 37.00 | 6.00 |
| 6.120 | GG106.VM08.125.17.68.R | M8 | 1.25 | 6.80 | 2.95 | 0.70 | 5.95 | 0.75 | 17.00 | 42.00 | 6.00 |
| 6.130 | GG106.VM08.125.22.68.R | M8 | 1.25 | 6.80 | 2.95 | 0.70 | 5.95 | 0.75 | 22.00 | 47.00 | 6.00 |
| 6.140 | GG106.VM08.125.27.68.R | M8 | 1.25 | 6.80 | 2.95 | 0.70 | 5.95 | 0.75 | 27.00 | 52.00 | 6.00 |
| 6.150 | GG106.VM08.125.32.68.R | M8 | 1.25 | 6.80 | 2.95 | 0.70 | 5.95 | 0.75 | 32.00 | 57.00 | 6.00 |
| 6.160 | GG106.VM08.125.37.68.R | M8 | 1.25 | 6.80 | 2.95 | 0.70 | 5.95 | 0.75 | 37.00 | 62.00 | 6.00 |
| 6.170 | GG106.VM08.125.42.68.R | M8 | 1.25 | 6.80 | 2.95 | 0.70 | 5.95 | 0.75 | 42.00 | 67.00 | 6.00 |
| 6.210 | GG106.VM10.150.12.85.R | M10 | 1.50 | 8.50 | 2.95 | 0.90 | 5.95 | 0.90 | 12.00 | 37.00 | 6.00 |
| 6.220 | GG106.VM10.150.17.85.R | M10 | 1.50 | 8.50 | 2.95 | 0.90 | 5.95 | 0.90 | 17.00 | 42.00 | 6.00 |
| 6.230 | GG106.VM10.150.22.85.R | M10 | 1.50 | 8.50 | 2.95 | 0.90 | 5.95 | 0.90 | 22.00 | 47.00 | 6.00 |
| 6.240 | GG106.VM10.150.27.85.R | M10 | 1.50 | 8.50 | 2.95 | 0.90 | 5.95 | 0.90 | 27.00 | 52.00 | 6.00 |
| 6.250 | GG106.VM10.150.32.85.R | M10 | 1.50 | 8.50 | 2.95 | 0.90 | 5.95 | 0.90 | 32.00 | 57.00 | 6.00 |
| 6.260 | GG106.VM10.150.37.85.R | M10 | 1.50 | 8.50 | 2.95 | 0.90 | 5.95 | 0.90 | 37.00 | 62.00 | 6.00 |
| 6.270 | GG106.VM10.150.42.85.R | M10 | 1.50 | 8.50 | 2.95 | 0.90 | 5.95 | 0.90 | 42.00 | 67.00 | 6.00 |
| 6.310 | GG106.VM12.175.12.00.R | M12 | 1.75 | 10.20 | 2.95 | 0.90 | 5.95 | 1.05 | 12.00 | 37.00 | 6.00 |
| 6.320 | GG106.VM12.175.17.00.R | M12 | 1.75 | 10.20 | 2.95 | 0.90 | 5.95 | 1.05 | 17.00 | 42.00 | 6.00 |
| 6.330 | GG106.VM12.175.22.00.R | M12 | 1.75 | 10.20 | 2.95 | 0.90 | 5.95 | 1.05 | 22.00 | 47.00 | 6.00 |
| 6.340 | GG106.VM12.175.27.00.R | M12 | 1.75 | 10.20 | 2.95 | 0.90 | 5.95 | 1.05 | 27.00 | 52.00 | 6.00 |
| 6.350 | GG106.VM12.175.32.00.R | M12 | 1.75 | 10.20 | 2.95 | 0.90 | 5.95 | 1.05 | 32.00 | 57.00 | 6.00 |
| 6.360 | GG106.VM12.175.37.00.R | M12 | 1.75 | 10.20 | 2.95 | 0.90 | 5.95 | 1.05 | 37.00 | 62.00 | 6.00 |
| 6.370 | GG106.VM12.175.42.00.R | M12 | 1.75 | 10.20 | 2.95 | 0.90 | 5.95 | 1.05 | 42.00 | 67.00 | 6.00 |

Article no. **25773** **25775** **25779**Cutting direction   

| Code no. | Description | G | P | D min | f | E | a | t max | La | Lg | D h6 |
|----------|------------------------|-----|------|-------|------|------|------|-------|-------|-------|------|
| | | | mm | mm | mm | mm | mm | mm | mm | mm | mm |
| 6.010 | GG106.VM06.100.12.50.L | M6 | 1.00 | 5.00 | 2.95 | 0.50 | 4.50 | 0.60 | 12.00 | 37.00 | 6.00 |
| 6.020 | GG106.VM06.100.17.50.L | M6 | 1.00 | 5.00 | 2.95 | 0.50 | 4.50 | 0.60 | 17.00 | 42.00 | 6.00 |
| 6.030 | GG106.VM06.100.22.50.L | M6 | 1.00 | 5.00 | 2.95 | 0.50 | 4.50 | 0.60 | 22.00 | 47.00 | 6.00 |
| 6.040 | GG106.VM06.100.27.50.L | M6 | 1.00 | 5.00 | 2.95 | 0.50 | 4.50 | 0.60 | 27.00 | 52.00 | 6.00 |
| 6.050 | GG106.VM06.100.32.50.L | M6 | 1.00 | 5.00 | 2.95 | 0.50 | 4.50 | 0.60 | 32.00 | 57.00 | 6.00 |
| 6.060 | GG106.VM06.100.37.50.L | M6 | 1.00 | 5.00 | 2.95 | 0.50 | 4.50 | 0.60 | 37.00 | 62.00 | 6.00 |
| 6.070 | GG106.VM06.100.42.50.L | M6 | 1.00 | 5.00 | 2.95 | 0.50 | 4.50 | 0.60 | 42.00 | 67.00 | 6.00 |
| 6.110 | GG106.VM08.125.12.68.L | M8 | 1.25 | 6.80 | 2.95 | 0.70 | 5.95 | 0.75 | 12.00 | 37.00 | 6.00 |
| 6.120 | GG106.VM08.125.17.68.L | M8 | 1.25 | 6.80 | 2.95 | 0.70 | 5.95 | 0.75 | 17.00 | 42.00 | 6.00 |
| 6.130 | GG106.VM08.125.22.68.L | M8 | 1.25 | 6.80 | 2.95 | 0.70 | 5.95 | 0.75 | 22.00 | 47.00 | 6.00 |
| 6.140 | GG106.VM08.125.27.68.L | M8 | 1.25 | 6.80 | 2.95 | 0.70 | 5.95 | 0.75 | 27.00 | 52.00 | 6.00 |
| 6.150 | GG106.VM08.125.32.68.L | M8 | 1.25 | 6.80 | 2.95 | 0.70 | 5.95 | 0.75 | 32.00 | 57.00 | 6.00 |
| 6.160 | GG106.VM08.125.37.68.L | M8 | 1.25 | 6.80 | 2.95 | 0.70 | 5.95 | 0.75 | 37.00 | 62.00 | 6.00 |
| 6.170 | GG106.VM08.125.42.68.L | M8 | 1.25 | 6.80 | 2.95 | 0.70 | 5.95 | 0.75 | 42.00 | 67.00 | 6.00 |
| 6.210 | GG106.VM10.150.12.85.L | M10 | 1.50 | 8.50 | 2.95 | 0.90 | 5.95 | 0.90 | 12.00 | 37.00 | 6.00 |
| 6.220 | GG106.VM10.150.17.85.L | M10 | 1.50 | 8.50 | 2.95 | 0.90 | 5.95 | 0.90 | 17.00 | 42.00 | 6.00 |
| 6.230 | GG106.VM10.150.22.85.L | M10 | 1.50 | 8.50 | 2.95 | 0.90 | 5.95 | 0.90 | 22.00 | 47.00 | 6.00 |
| 6.240 | GG106.VM10.150.27.85.L | M10 | 1.50 | 8.50 | 2.95 | 0.90 | 5.95 | 0.90 | 27.00 | 52.00 | 6.00 |
| 6.250 | GG106.VM10.150.32.85.L | M10 | 1.50 | 8.50 | 2.95 | 0.90 | 5.95 | 0.90 | 32.00 | 57.00 | 6.00 |
| 6.260 | GG106.VM10.150.37.85.L | M10 | 1.50 | 8.50 | 2.95 | 0.90 | 5.95 | 0.90 | 37.00 | 62.00 | 6.00 |
| 6.270 | GG106.VM10.150.42.85.L | M10 | 1.50 | 8.50 | 2.95 | 0.90 | 5.95 | 0.90 | 42.00 | 67.00 | 6.00 |
| 6.310 | GG106.VM12.175.12.00.L | M12 | 1.75 | 10.20 | 2.95 | 0.90 | 5.95 | 1.05 | 12.00 | 37.00 | 6.00 |
| 6.320 | GG106.VM12.175.17.00.L | M12 | 1.75 | 10.20 | 2.95 | 0.90 | 5.95 | 1.05 | 17.00 | 42.00 | 6.00 |
| 6.330 | GG106.VM12.175.22.00.L | M12 | 1.75 | 10.20 | 2.95 | 0.90 | 5.95 | 1.05 | 22.00 | 47.00 | 6.00 |
| 6.340 | GG106.VM12.175.27.00.L | M12 | 1.75 | 10.20 | 2.95 | 0.90 | 5.95 | 1.05 | 27.00 | 52.00 | 6.00 |
| 6.350 | GG106.VM12.175.32.00.L | M12 | 1.75 | 10.20 | 2.95 | 0.90 | 5.95 | 1.05 | 32.00 | 57.00 | 6.00 |
| 6.360 | GG106.VM12.175.37.00.L | M12 | 1.75 | 10.20 | 2.95 | 0.90 | 5.95 | 1.05 | 37.00 | 62.00 | 6.00 |
| 6.370 | GG106.VM12.175.42.00.L | M12 | 1.75 | 10.20 | 2.95 | 0.90 | 5.95 | 1.05 | 42.00 | 67.00 | 6.00 |

System 106

Cutting insert for internal threading, part profile - trapezoidal thread



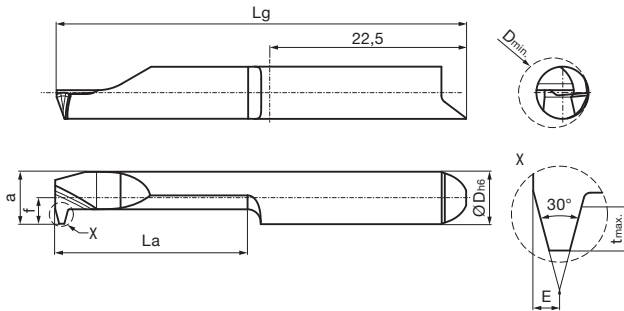
• pitch P = 1.5-3.0

for tool holders type GH106/GB106 see from page 62

GUHRING NAVIGATOR

Cutting data page 184

System 106



Right hand version shown
Left hand version mirror image

Article no. **25824** **25826** **25830**

Cutting direction

| Code no. | Description | G | P | D min | f | E | a | t max | La | Lg | D h6 |
|----------|------------------------|------|------|-------|------|------|------|-------|-------|-------|------|
| | | | mm | mm | mm | mm | mm | mm | mm | mm | mm |
| 6.002 | GG106.TT08.200.22.60.R | Tr8 | 2.00 | 6.00 | 2.70 | 0.75 | 5.70 | 1.25 | 22.00 | 47.00 | 6.00 |
| 6.001 | GG106.TT08.150.22.65.R | Tr8 | 1.50 | 6.50 | 2.95 | 0.60 | 5.95 | 0.90 | 22.00 | 47.00 | 6.00 |
| 6.003 | GG106.TT10.200.22.80.R | Tr10 | 2.00 | 8.00 | 2.95 | 0.75 | 5.95 | 1.25 | 22.00 | 47.00 | 6.00 |
| 6.005 | GG106.TT10.300.22.70.R | Tr10 | 3.00 | 7.00 | 2.95 | 1.10 | 5.95 | 1.75 | 22.00 | 47.00 | 6.00 |
| 6.004 | GG106.TT10.200.32.80.R | Tr10 | 2.00 | 8.00 | 2.95 | 0.75 | 5.95 | 1.25 | 32.00 | 57.00 | 6.00 |
| 6.006 | GG106.TT10.300.32.70.R | Tr10 | 3.00 | 7.00 | 2.95 | 1.10 | 5.95 | 1.75 | 32.00 | 57.00 | 6.00 |

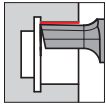
Article no. **25825** **25827** **25831**

Cutting direction

| Code no. | Description | G | P | D min | f | E | a | t max | La | Lg | D h6 |
|----------|------------------------|------|------|-------|------|------|------|-------|-------|-------|------|
| | | | mm | mm | mm | mm | mm | mm | mm | mm | mm |
| 6.002 | GG106.TT08.200.22.60.L | Tr8 | 2.00 | 6.00 | 2.70 | 0.75 | 5.70 | 1.25 | 22.00 | 47.00 | 6.00 |
| 6.001 | GG106.TT08.150.22.65.L | Tr8 | 1.50 | 6.50 | 2.95 | 0.60 | 5.95 | 0.90 | 22.00 | 47.00 | 6.00 |
| 6.003 | GG106.TT10.200.22.80.L | Tr10 | 2.00 | 8.00 | 2.95 | 0.75 | 5.95 | 1.25 | 22.00 | 47.00 | 6.00 |
| 6.005 | GG106.TT10.300.22.70.L | Tr10 | 3.00 | 7.00 | 2.95 | 1.10 | 5.95 | 1.75 | 22.00 | 47.00 | 6.00 |
| 6.004 | GG106.TT10.200.32.80.L | Tr10 | 2.00 | 8.00 | 2.95 | 0.75 | 5.95 | 1.25 | 32.00 | 57.00 | 6.00 |
| 6.006 | GG106.TT10.300.32.70.L | Tr10 | 3.00 | 7.00 | 2.95 | 1.10 | 5.95 | 1.75 | 32.00 | 57.00 | 6.00 |



Cutting insert for broaching longitudinal slots



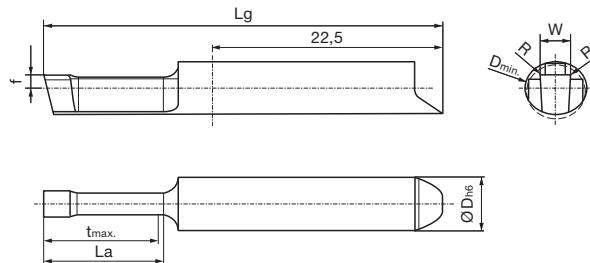
• tolerance class C11, P9, JS9

for tool holders type GB106 Art. No. 25302 see page 74

GUHRING NAVIGATOR

Cutting data page 184

| Tool material | Solid carbide | | |
|---------------|---------------|-------------|--------|
| Type | GN 106 | GN 106 | GN 106 |
| Surface | S | a | ○ |
| | TiN | TiAlN-nanoA | bright |



Article no. **25812** **25813** **25815**

| Code no. | Description | for slot width | D min | W | R | f | t max | La | Lg | D h6 |
|----------|------------------------|----------------|-------|------|------|------|-------|-------|-------|------|
| | | | mm | mm | mm | mm | mm | mm | mm | mm |
| 6.001 | GN106.0198.010.12.06.N | 2 P9 | 6.00 | 1.98 | 0.10 | 1.50 | 11.50 | 12.00 | 37.00 | 6.00 |
| 6.002 | GN106.0298.010.12.06.N | 3 P9 | 6.00 | 2.98 | 0.10 | 1.50 | 11.50 | 12.00 | 37.00 | 6.00 |
| 6.003 | GN106.0398.010.12.06.N | 4 P9 | 6.00 | 3.98 | 0.10 | 1.50 | 11.50 | 12.00 | 37.00 | 6.00 |
| 6.004 | GN106.0498.020.12.07.N | 5 P9 | 7.00 | 4.98 | 0.20 | 1.50 | 11.50 | 12.00 | 37.00 | 6.00 |

Article no. **25816** **25817** **25819**

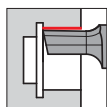
| Code no. | Description | for slot width | D min | W | R | f | t max | La | Lg | D h6 |
|----------|------------------------|----------------|-------|------|------|------|-------|-------|-------|------|
| | | | mm | mm | mm | mm | mm | mm | mm | mm |
| 6.001 | GN106.0200.010.12.06.N | 2 JS9 | 6.00 | 2.00 | 0.10 | 1.50 | 11.50 | 12.00 | 37.00 | 6.00 |
| 6.002 | GN106.0300.010.12.06.N | 3 JS9 | 6.00 | 3.00 | 0.10 | 1.50 | 11.50 | 12.00 | 37.00 | 6.00 |
| 6.003 | GN106.0400.010.12.06.N | 4 JS9 | 6.00 | 4.00 | 0.10 | 1.50 | 11.50 | 12.00 | 37.00 | 6.00 |
| 6.004 | GN106.0500.020.12.07.N | 5 JS9 | 7.00 | 5.00 | 0.20 | 1.50 | 11.50 | 12.00 | 37.00 | 6.00 |

Article no. **25820** **25821** **25823**

| Code no. | Description | for slot width | D min | W | R | f | t max | La | Lg | D h6 |
|----------|------------------------|----------------|-------|------|------|------|-------|-------|-------|------|
| | | | mm | mm | mm | mm | mm | mm | mm | mm |
| 6.001 | GN106.0211.035.12.06.N | 2 C11 | 6.00 | 2.11 | 0.35 | 1.50 | 11.50 | 12.00 | 37.00 | 6.00 |
| 6.002 | GN106.0311.035.12.06.N | 3 C11 | 6.00 | 3.11 | 0.35 | 1.50 | 11.50 | 12.00 | 37.00 | 6.00 |
| 6.003 | GN106.0413.050.12.06.N | 4 C11 | 6.00 | 4.13 | 0.50 | 1.50 | 11.50 | 12.00 | 37.00 | 6.00 |
| 6.004 | GN106.0513.050.12.07.N | 5 C11 | 7.00 | 5.13 | 0.50 | 1.50 | 11.50 | 12.00 | 37.00 | 6.00 |

System 106

Cutting insert for internal hexagon



• SW 4.0-10.0

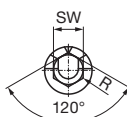
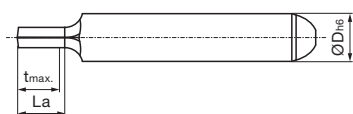
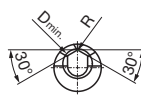
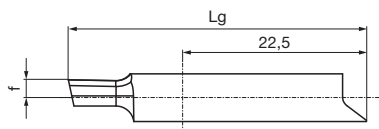
for tool holders type GB106 Art. No. 25302 see page 74

GÜHRING NAVIGATOR

Cutting data page 184

| Tool material | Solid carbide | | |
|---------------|---------------|-------------|--------|
| Type | GN 106 | GN 106 | GN 106 |
| Surface | | | |
| | TiN | TiAlN-nanoA | bright |

System 106



Article no. **25896** **25897** **25898**

| Code no. | Description | SW | D min | R | f | t max | La | Lg | D h6 |
|----------|------------------------|------------|-------|------|------|-------|-------|-------|------|
| | | | mm | mm | mm | mm | mm | mm | mm |
| 6.001 | GN106.SW40.010.06.40.N | 4,00-4,50 | 4.00 | 0.10 | 1.50 | 6.00 | 6.50 | 37.00 | 6.00 |
| 6.002 | GN106.SW45.010.07.45.N | 4,50-5,00 | 4.50 | 0.10 | 1.50 | 7.00 | 7.50 | 37.00 | 6.00 |
| 6.003 | GN106.SW50.010.09.50.N | 5,00-8,00 | 5.00 | 0.10 | 1.50 | 9.00 | 9.50 | 37.00 | 6.00 |
| 6.004 | GN106.SW80.010.12.80.N | 8,00-10,00 | 8.00 | 0.10 | 1.50 | 12.00 | 12.50 | 37.00 | 6.00 |

RT 100 S



RT 100 S

THE RT 100 S – FOR DEMANDING MACHINING JOBS

- ▶ Top quality tools for top performance
- ▶ The ideal tool for use with structural and free-cutting steels, alloyed and non-alloyed heat-treatable steels, alloyed and non-alloyed case-hardened steels, tool and high-speed steels

108





SYSTEM 108

MICRO-PRECISION TOOLS



Round shank holder

from page 124

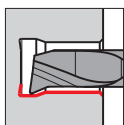


Square shank holder

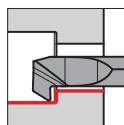
from page 128

Tool holder

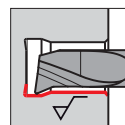
System 108



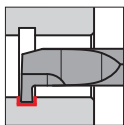
Boring out
and profiling, type GT
from page 130



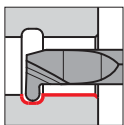
Back boring
and profiling, type GT
from page 138



Boring out
with Wiper, type GJ
from page 136



Internal grooving,
straight slots, type GE
from page 140



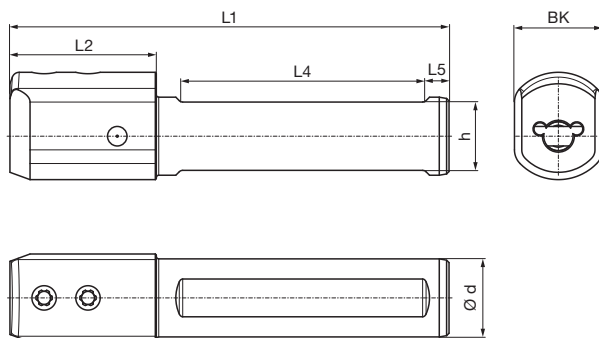
Internal grooving,
full radius slots, type GE
from page 144

Cutting inserts from hole-Ø 7 mm

Round shank holder, clamping screw top

- for inserts type 108
- with internal coolant supply

Type GB 108



System 108

Article no. 27000

| Code no. | Description | d | h | L1 | L2 | L4 | L5 | BK |
|----------|---------------------------|-------|-------|--------|-------|-------|------|------|
| | | mm | mm | mm | mm | mm | mm | mm |
| 8.001 | GB108.0010.090.00.22.N.IK | 10.00 | 9.00 | 90.00 | 30.00 | 50.00 | 5.00 | 16.5 |
| 8.002 | GB108.0012.090.00.22.N.IK | 12.00 | 11.00 | 90.00 | 30.00 | 50.00 | 5.00 | 16.5 |
| 8.015 | GB108.0500.354.00.22.N.IK | 12.70 | 11.00 | 89.92 | 26.67 | 54.86 | 5.00 | 16.5 |
| 8.016 | GB108.0625.354.00.22.N.IK | 15.87 | 14.00 | 89.92 | 26.67 | 54.86 | 5.00 | 16.5 |
| 8.003 | GB108.0016.090.00.22.N.IK | 16.00 | 14.00 | 90.00 | 30.00 | 50.00 | 5.00 | 16.5 |
| 8.017 | GB108.0750.415.00.22.N.IK | 19.05 | 17.00 | 105.41 | 26.67 | 69.85 | 5.00 | 20.5 |
| 8.004 | GB108.0020.095.00.22.N.IK | 20.00 | 18.00 | 95.00 | 30.00 | 55.00 | 5.00 | 20.5 |
| 8.005 | GB108.0022.095.00.22.N.IK | 22.00 | 20.00 | 95.00 | 30.00 | 55.00 | 5.00 | |
| 8.006 | GB108.0025.100.00.22.N.IK | 25.00 | 23.00 | 100.00 | | 55.00 | 5.00 | |
| 8.018 | GB108.1000.415.00.22.N.IK | 25.40 | 23.40 | 105.41 | | 69.85 | 5.00 | |

Spare parts

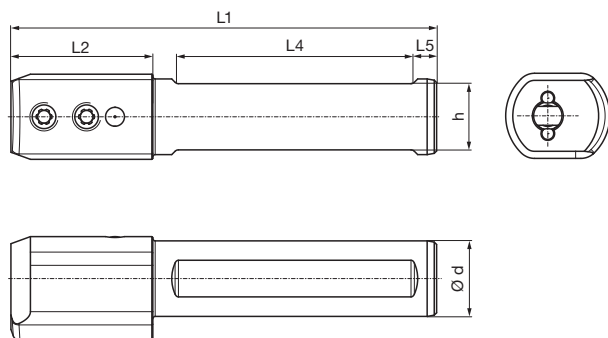
| Article no. | Clamping screw | Tightening torque |
|-------------|----------------|-------------------|
| 25900 | | Nm |
| Code 6.000 | M6x7.5x15IP | 4-4.5 |

| Article no. | Torx-Plus Wrench |
|-------------|------------------|
| 25904 | |
| Code 15.000 | T15IP T-handle |


Round shank holder, clamping screw lateral

- for inserts type 108
- with internal coolant supply

Type GB 108



System 108

Article no. 27001

| Code no. | Description | d | h | L1 | L2 | L4 | L5 |
|----------|------------------------------|-------|-------|--------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm |
| 8.001 | GB108.0010.090.00.22.N.IK.90 | 10.00 | 9.00 | 90.00 | 30.00 | 50.00 | 5.00 |
| 8.002 | GB108.0012.090.00.22.N.IK.90 | 12.00 | 11.00 | 90.00 | 30.00 | 50.00 | 5.00 |
| 8.015 | GB108.0500.354.00.22.N.IK.90 | 12.70 | 11.00 | 89.92 | 26.67 | 54.86 | 5.00 |
| 8.016 | GB108.0625.354.00.22.N.IK.90 | 15.87 | 14.00 | 89.92 | 26.67 | 54.86 | 5.00 |
| 8.003 | GB108.0016.090.00.22.N.IK.90 | 16.00 | 14.00 | 90.00 | 30.00 | 50.00 | 5.00 |
| 8.017 | GB108.0750.415.00.22.N.IK.90 | 19.05 | 17.00 | 105.41 | 26.67 | 69.85 | 5.00 |
| 8.004 | GB108.0020.095.00.22.N.IK.90 | 20.00 | 18.00 | 95.00 | 30.00 | 55.00 | 5.00 |
| 8.005 | GB108.0022.095.00.22.N.IK.90 | 22.00 | 20.00 | 95.00 | 30.00 | 55.00 | 5.00 |
| 8.006 | GB108.0025.100.00.22.N.IK.90 | 25.00 | 23.00 | 100.00 | | 55.00 | 5.00 |
| 8.018 | GB108.1000.415.00.22.N.IK.90 | 25.40 | 23.40 | 105.41 | | 69.85 | 5.00 |

Spare parts

| Article no. | Clamping screw | Tightening torque |
|-------------|----------------|-------------------|
| 25900 | | Nm |
| Code 6.000 | M6x7.5x15IP | 4-4.5 |

| Article no. | Torx-Plus Wrench |
|-------------|------------------|
| 25904 | |
| Code 15.000 | T15IP T-handle |

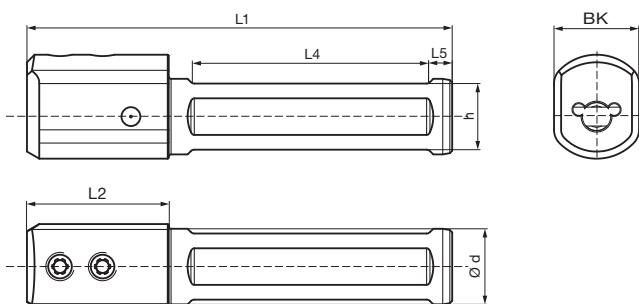


Round shank holder, clamping screw above, four clamping surfaces

- for inserts type 108
- with internal coolant supply

Type GB 108

System 108



Article no. **27002**

version left and right

| Code no. | Description | d | h | L1 | L2 | L4 | L5 | BK |
|----------|-------------------------------|-------|-------|--------|-------|-------|------|------|
| | | mm | mm | mm | mm | mm | mm | mm |
| 8.010 | GB108.0016.090.00.22.N.IK.VSP | 16.00 | 14.00 | 90.00 | 30.00 | 50.00 | 5.00 | 16.5 |
| 8.020 | GB108.0020.095.00.22.N.IK.VSP | 20.00 | 18.00 | 95.00 | 30.00 | 55.00 | 5.00 | 20.5 |
| 8.030 | GB108.0022.095.00.22.N.IK.VSP | 22.00 | 20.00 | 95.00 | 30.00 | 55.00 | 5.00 | |
| 8.040 | GB108.0025.100.00.22.N.IK.VSP | 25.00 | 23.00 | 100.00 | | 55.00 | 5.00 | |

Spare parts

| Article no. | Clamping screw | Tightening torque |
|-------------|----------------|-------------------|
| 25900 | | Nm |
| Code 6.000 | M6x7.5x15IP | 4-4.5 |

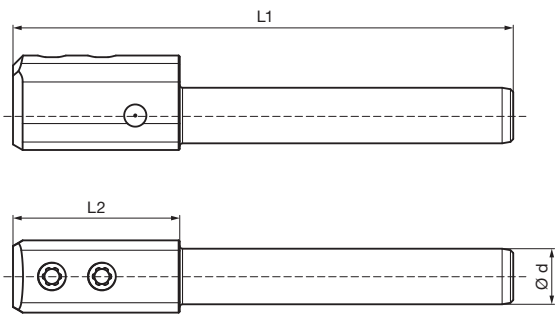
| Article no. | Torx-Plus Wrench |
|-------------|------------------|
| 25904 | |
| Code 15.000 | T15IP T-handle |



Round shank holder, clamping screw above, without clamping surfaces

- for inserts type 108
- with internal coolant supply

| | |
|------|--------|
| Type | GB 108 |
|------|--------|



System 108

Article no. **27003**
version left and right

| Code no. | Description | d | L1 | L2 | BK |
|----------|-------------------------------|-------|-------|-------|------|
| | | mm | mm | mm | mm |
| 8.010 | GB108.0010.090.00.22.N.IK.RND | 10.00 | 90.00 | 30.00 | 16.5 |
| 8.020 | GB108.0012.090.00.22.N.IK.RND | 12.00 | 90.00 | 30.00 | 16.5 |
| 8.030 | GB108.0016.090.00.22.N.IK.RND | 16.00 | 90.00 | 30.00 | 16.5 |

Spare parts

| Article no. | Clamping screw | Tightening torque |
|-------------|----------------|-------------------|
| 25900 | | Nm |
| Code 6.000 | M6x7.5x15IP | 4-4.5 |

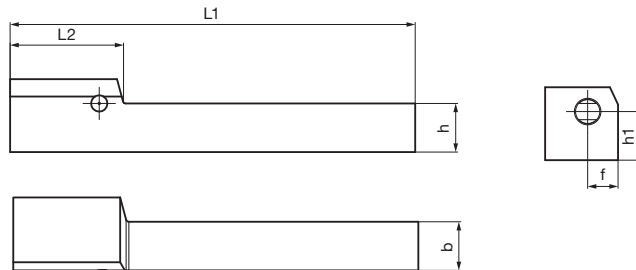
| Article no. | Torx-Plus Wrench |
|-------------|------------------|
| 25904 | |
| Code 15.000 | T15IP T-handle |

Square shank holder, straight 0°

- for inserts type 108
- without internal coolant supply

Type GH 108

System 108



Right hand version shown
Left hand version mirror image

Article no. **27007**
version right-hand

| Code no. | Description | b | h | h1 | f | L1 | L2 |
|----------|------------------------|-------|-------|-------|------|--------|-------|
| | | mm | mm | mm | mm | mm | mm |
| 8.110 | GH108.0375.350.00.22.R | 9.52 | 9.52 | 9.52 | 7.62 | 88.90 | 27.94 |
| 8.010 | GH108.1010.100.00.22.R | 10.00 | 10.00 | 10.00 | 7.50 | 100.00 | 28.00 |
| 8.020 | GH108.1212.100.00.22.R | 12.00 | 12.00 | 12.00 | 7.50 | 100.00 | 28.00 |
| 8.120 | GH108.0500.350.00.22.R | 12.70 | 12.70 | 12.70 | 7.62 | 88.90 | 27.94 |
| 8.130 | GH108.0625.400.00.22.R | 15.87 | 15.87 | 15.87 | 7.62 | 101.60 | 27.94 |
| 8.030 | GH108.1616.120.00.22.R | 16.00 | 16.00 | 16.00 | 7.50 | 120.00 | 28.00 |

Article no. **27008**
version left-hand

| Code no. | Description | b | h | h1 | f | L1 | L2 |
|----------|------------------------|-------|-------|-------|------|--------|-------|
| | | mm | mm | mm | mm | mm | mm |
| 8.110 | GH108.0375.350.00.22.L | 9.52 | 9.52 | 9.52 | 7.62 | 88.90 | 27.94 |
| 8.010 | GH108.1010.100.00.22.L | 10.00 | 10.00 | 10.00 | 7.50 | 100.00 | 28.00 |
| 8.020 | GH108.1212.100.00.22.L | 12.00 | 12.00 | 12.00 | 7.50 | 100.00 | 28.00 |
| 8.120 | GH108.0500.350.00.22.L | 12.70 | 12.70 | 12.70 | 7.62 | 88.90 | 27.94 |
| 8.130 | GH108.0625.400.00.22.L | 15.87 | 15.87 | 15.87 | 7.62 | 101.60 | 27.94 |
| 8.030 | GH108.1616.120.00.22.L | 16.00 | 16.00 | 16.00 | 7.50 | 120.00 | 28.00 |

Spare parts

| Article no. | Clamping screw | Tightening torque |
|-------------|----------------|-------------------|
| 25900 | | Nm |
| Code 6.000 | M6x7.5x15IP | 4-4.5 |

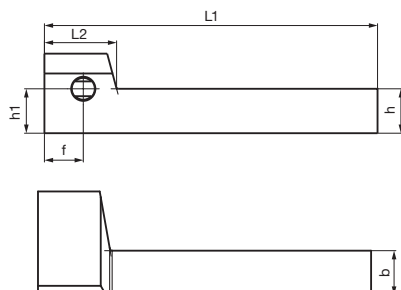
| Article no. | Torx-Plus Wrench |
|-------------|------------------|
| 25904 | |
| Code 15.000 | T15IP T-handle |



Square shank holder, 90° offset

- for inserts type 108
- without internal coolant supply

Type GH 108



System 108

Right hand version shown
Left hand version mirror image

Article no. **27009**

version right-hand

| Code no. | Description | b | h | h1 | f | L1 | L2 |
|----------|------------------------|-------|-------|-------|-------|--------|-------|
| | | mm | mm | mm | mm | mm | mm |
| 8.010 | GH108.0375.350.90.22.R | 9.52 | 9.52 | 9.52 | 11.43 | 88.90 | 20.32 |
| 8.001 | GH108.1010.090.90.22.R | 10.00 | 10.00 | 10.00 | 11.50 | 90.00 | 20.50 |
| 8.002 | GH108.1212.090.90.22.R | 12.00 | 12.00 | 12.00 | 11.50 | 90.00 | 20.50 |
| 8.011 | GH108.0500.350.90.22.R | 12.70 | 12.70 | 12.70 | 11.43 | 88.90 | 20.32 |
| 8.012 | GH108.0625.400.90.22.R | 15.87 | 15.87 | 15.87 | 11.43 | 101.60 | 20.32 |
| 8.003 | GH108.1616.120.90.22.R | 16.00 | 16.00 | 16.00 | 11.50 | 120.00 | 20.50 |

Article no. **27010**

version left-hand

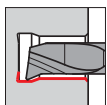
| Code no. | Description | b | h | h1 | f | L1 | L2 |
|----------|------------------------|-------|-------|-------|-------|--------|-------|
| | | mm | mm | mm | mm | mm | mm |
| 8.010 | GH108.0375.350.90.22.L | 9.52 | 9.52 | 9.52 | 11.43 | 88.90 | 20.32 |
| 8.001 | GH108.1010.090.90.22.L | 10.00 | 10.00 | 10.00 | 11.50 | 90.00 | 20.50 |
| 8.002 | GH108.1212.090.90.22.L | 12.00 | 12.00 | 12.00 | 11.50 | 90.00 | 20.50 |
| 8.011 | GH108.0500.350.90.22.L | 12.70 | 12.70 | 12.70 | 11.43 | 88.90 | 20.32 |
| 8.012 | GH108.0625.400.90.22.L | 15.87 | 15.87 | 15.87 | 11.43 | 101.60 | 20.32 |
| 8.003 | GH108.1616.120.90.22.L | 16.00 | 16.00 | 16.00 | 11.50 | 120.00 | 20.50 |

Spare parts

| Article no. | Clamping screw | Tightening torque |
|-------------|----------------|-------------------|
| 25900 | | Nm |
| Code 6.000 | M6x7.5x15IP | 4-4.5 |

| Article no. | Torx-Plus Wrench |
|-------------|------------------|
| 25904 | |
| Code 15.000 | T15IP T-handle |

Cutting insert for boring out and profiling



• radial free 23°

for tool holders type GH108/GB108 see from page 124

GUHRING NAVIGATOR

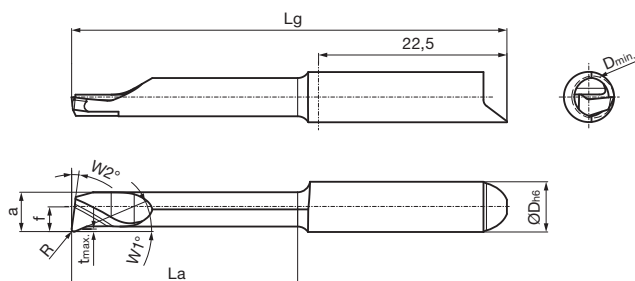
Cutting data page 184

Tool material **Solid carbide**

Type GT 108 GT 108

Surface **a** ○
TiAlN-nanoA bright

System 108



Right hand version shown
Left hand version mirror image

Article no. **27100 27102**

Cutting direction **(R) (R)**

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 8.120 | GT108.2367.010.17.70.R | 7.00 | 0.10 | 23 | 8 | 3.95 | 6.70 | 0.50 | 17.00 | 42.00 | 8.00 |
| 8.140 | GT108.2367.010.27.70.R | 7.00 | 0.10 | 23 | 8 | 3.95 | 6.70 | 0.50 | 27.00 | 52.00 | 8.00 |
| 8.160 | GT108.2367.010.37.70.R | 7.00 | 0.10 | 23 | 8 | 3.95 | 6.70 | 0.50 | 37.00 | 62.00 | 8.00 |
| 8.170 | GT108.2367.010.42.70.R | 7.00 | 0.10 | 23 | 8 | 3.95 | 6.70 | 0.50 | 42.00 | 67.00 | 8.00 |
| 8.180 | GT108.2367.010.47.70.R | 7.00 | 0.10 | 23 | 8 | 3.95 | 6.70 | 0.50 | 47.00 | 72.00 | 8.00 |
| 8.190 | GT108.2367.010.52.70.R | 7.00 | 0.10 | 23 | 8 | 3.95 | 6.70 | 0.50 | 52.00 | 77.00 | 8.00 |
| 8.320 | GT108.2367.020.17.70.R | 7.00 | 0.20 | 23 | 8 | 3.95 | 6.70 | 0.50 | 17.00 | 42.00 | 8.00 |
| 8.340 | GT108.2367.020.27.70.R | 7.00 | 0.20 | 23 | 8 | 3.95 | 6.70 | 0.50 | 27.00 | 52.00 | 8.00 |
| 8.360 | GT108.2367.020.37.70.R | 7.00 | 0.20 | 23 | 8 | 3.95 | 6.70 | 0.50 | 37.00 | 62.00 | 8.00 |
| 8.370 | GT108.2367.020.42.70.R | 7.00 | 0.20 | 23 | 8 | 3.95 | 6.70 | 0.50 | 42.00 | 67.00 | 8.00 |
| 8.380 | GT108.2367.020.47.70.R | 7.00 | 0.20 | 23 | 8 | 3.95 | 6.70 | 0.50 | 47.00 | 72.00 | 8.00 |
| 8.390 | GT108.2367.020.52.70.R | 7.00 | 0.20 | 23 | 8 | 3.95 | 6.70 | 0.50 | 52.00 | 77.00 | 8.00 |

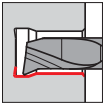
Article no. **27101 27103**

Cutting direction **(L) (L)**

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 8.120 | GT108.2367.010.17.70.L | 7.00 | 0.10 | 23 | 8 | 3.95 | 6.70 | 0.50 | 17.00 | 42.00 | 8.00 |
| 8.140 | GT108.2367.010.27.70.L | 7.00 | 0.10 | 23 | 8 | 3.95 | 6.70 | 0.50 | 27.00 | 52.00 | 8.00 |
| 8.160 | GT108.2367.010.37.70.L | 7.00 | 0.10 | 23 | 8 | 3.95 | 6.70 | 0.50 | 37.00 | 62.00 | 8.00 |
| 8.170 | GT108.2367.010.42.70.L | 7.00 | 0.10 | 23 | 8 | 3.95 | 6.70 | 0.50 | 42.00 | 67.00 | 8.00 |
| 8.180 | GT108.2367.010.47.70.L | 7.00 | 0.10 | 23 | 8 | 3.95 | 6.70 | 0.50 | 47.00 | 72.00 | 8.00 |
| 8.190 | GT108.2367.010.52.70.L | 7.00 | 0.10 | 23 | 8 | 3.95 | 6.70 | 0.50 | 52.00 | 77.00 | 8.00 |
| 8.320 | GT108.2367.020.17.70.L | 7.00 | 0.20 | 23 | 8 | 3.95 | 6.70 | 0.50 | 17.00 | 42.00 | 8.00 |
| 8.340 | GT108.2367.020.27.70.L | 7.00 | 0.20 | 23 | 8 | 3.95 | 6.70 | 0.50 | 27.00 | 52.00 | 8.00 |
| 8.360 | GT108.2367.020.37.70.L | 7.00 | 0.20 | 23 | 8 | 3.95 | 6.70 | 0.50 | 37.00 | 62.00 | 8.00 |
| 8.370 | GT108.2367.020.42.70.L | 7.00 | 0.20 | 23 | 8 | 3.95 | 6.70 | 0.50 | 42.00 | 67.00 | 8.00 |
| 8.380 | GT108.2367.020.47.70.L | 7.00 | 0.20 | 23 | 8 | 3.95 | 6.70 | 0.50 | 47.00 | 72.00 | 8.00 |
| 8.390 | GT108.2367.020.52.70.L | 7.00 | 0.20 | 23 | 8 | 3.95 | 6.70 | 0.50 | 52.00 | 77.00 | 8.00 |



Cutting insert for boring out and profiling



• radial free 23°

Tool material **Solid carbide**

Type GT 108 GT 108

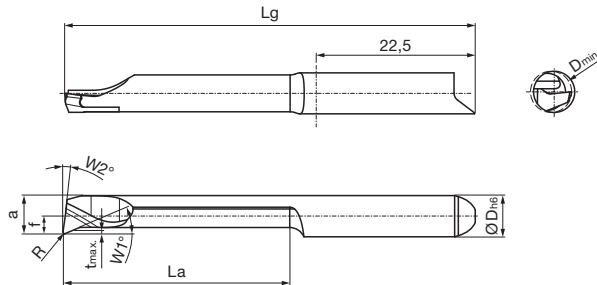
Surface **a** ○

TiAlN-nanoA bright

for tool holders type GH108/GB108 see from page 124

GUHRING NAVIGATOR

Cutting data page 184



System 108

Right hand version shown
Left hand version mirror image

Article no. **27200** **27202**

Cutting direction **R** **R**

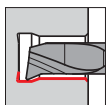
| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 8.120 | GT108.2377.010.17.80.R | 8.00 | 0.10 | 23 | 8 | 3.70 | 7.70 | 0.60 | 17.00 | 42.00 | 8.00 |
| 8.140 | GT108.2377.010.27.80.R | 8.00 | 0.10 | 23 | 8 | 3.70 | 7.70 | 0.60 | 27.00 | 52.00 | 8.00 |
| 8.160 | GT108.2377.010.37.80.R | 8.00 | 0.10 | 23 | 8 | 3.70 | 7.70 | 0.60 | 37.00 | 62.00 | 8.00 |
| 8.170 | GT108.2377.010.42.80.R | 8.00 | 0.10 | 23 | 8 | 3.70 | 7.70 | 0.60 | 42.00 | 67.00 | 8.00 |
| 8.180 | GT108.2377.010.47.80.R | 8.00 | 0.10 | 23 | 8 | 3.70 | 7.70 | 0.60 | 47.00 | 72.00 | 8.00 |
| 8.190 | GT108.2377.010.52.80.R | 8.00 | 0.10 | 23 | 8 | 3.70 | 7.70 | 0.60 | 52.00 | 77.00 | 8.00 |
| 8.320 | GT108.2377.020.17.80.R | 8.00 | 0.20 | 23 | 8 | 3.70 | 7.70 | 0.60 | 17.00 | 42.00 | 8.00 |
| 8.340 | GT108.2377.020.27.80.R | 8.00 | 0.20 | 23 | 8 | 3.70 | 7.70 | 0.60 | 27.00 | 52.00 | 8.00 |
| 8.360 | GT108.2377.020.37.80.R | 8.00 | 0.20 | 23 | 8 | 3.70 | 7.70 | 0.60 | 37.00 | 62.00 | 8.00 |
| 8.370 | GT108.2377.020.42.80.R | 8.00 | 0.20 | 23 | 8 | 3.70 | 7.70 | 0.60 | 42.00 | 67.00 | 8.00 |
| 8.380 | GT108.2377.020.47.80.R | 8.00 | 0.20 | 23 | 8 | 3.70 | 7.70 | 0.60 | 47.00 | 72.00 | 8.00 |
| 8.390 | GT108.2377.020.52.80.R | 8.00 | 0.20 | 23 | 8 | 3.70 | 7.70 | 0.60 | 52.00 | 77.00 | 8.00 |

Article no. **27201** **27203**

Cutting direction **L** **L**

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 8.120 | GT108.2377.010.17.80.L | 8.00 | 0.10 | 23 | 8 | 3.70 | 7.70 | 0.60 | 17.00 | 42.00 | 8.00 |
| 8.140 | GT108.2377.010.27.80.L | 8.00 | 0.10 | 23 | 8 | 3.70 | 7.70 | 0.60 | 27.00 | 52.00 | 8.00 |
| 8.160 | GT108.2377.010.37.80.L | 8.00 | 0.10 | 23 | 8 | 3.70 | 7.70 | 0.60 | 37.00 | 62.00 | 8.00 |
| 8.170 | GT108.2377.010.42.80.L | 8.00 | 0.10 | 23 | 8 | 3.70 | 7.70 | 0.60 | 42.00 | 67.00 | 8.00 |
| 8.180 | GT108.2377.010.47.80.L | 8.00 | 0.10 | 23 | 8 | 3.70 | 7.70 | 0.60 | 47.00 | 72.00 | 8.00 |
| 8.190 | GT108.2377.010.52.80.L | 8.00 | 0.10 | 23 | 8 | 3.70 | 7.70 | 0.60 | 52.00 | 77.00 | 8.00 |
| 8.320 | GT108.2377.020.17.80.L | 8.00 | 0.20 | 23 | 8 | 3.70 | 7.70 | 0.60 | 17.00 | 42.00 | 8.00 |
| 8.340 | GT108.2377.020.27.80.L | 8.00 | 0.20 | 23 | 8 | 3.70 | 7.70 | 0.60 | 27.00 | 52.00 | 8.00 |
| 8.360 | GT108.2377.020.37.80.L | 8.00 | 0.20 | 23 | 8 | 3.70 | 7.70 | 0.60 | 37.00 | 62.00 | 8.00 |
| 8.370 | GT108.2377.020.42.80.L | 8.00 | 0.20 | 23 | 8 | 3.70 | 7.70 | 0.60 | 42.00 | 67.00 | 8.00 |
| 8.380 | GT108.2377.020.47.80.L | 8.00 | 0.20 | 23 | 8 | 3.70 | 7.70 | 0.60 | 47.00 | 72.00 | 8.00 |
| 8.390 | GT108.2377.020.52.80.L | 8.00 | 0.20 | 23 | 8 | 3.70 | 7.70 | 0.60 | 52.00 | 77.00 | 8.00 |

Cutting insert for boring out and profiling



- radial free 47°, tmax 0.8

for tool holders type GH108/GB108 see from page 124

GUHRING NAVIGATOR

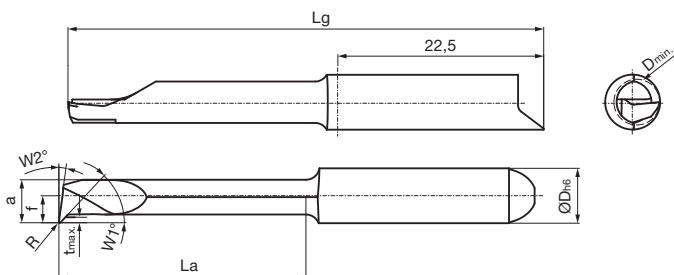
Cutting data page 184

Tool material **Solid carbide**

Type GT 108 GT 108

Surface **a** ○
TiAlN-nanoA bright

System 108



Right hand version shown
Left hand version mirror image

Article no. **27104** **27106**

Cutting direction **R** **R**

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 8.120 | GT108.4767.010.17.70.R | 7.00 | 0.10 | 47 | 8 | 3.95 | 6.70 | 0.80 | 17.00 | 42.00 | 8.00 |
| 8.140 | GT108.4767.010.27.70.R | 7.00 | 0.10 | 47 | 8 | 3.95 | 6.70 | 0.80 | 27.00 | 52.00 | 8.00 |
| 8.160 | GT108.4767.010.37.70.R | 7.00 | 0.10 | 47 | 8 | 3.95 | 6.70 | 0.80 | 37.00 | 62.00 | 8.00 |
| 8.170 | GT108.4767.010.42.70.R | 7.00 | 0.10 | 47 | 8 | 3.95 | 6.70 | 0.80 | 42.00 | 67.00 | 8.00 |
| 8.180 | GT108.4767.010.47.70.R | 7.00 | 0.10 | 47 | 8 | 3.95 | 6.70 | 0.80 | 47.00 | 72.00 | 8.00 |
| 8.320 | GT108.4767.020.17.70.R | 7.00 | 0.20 | 47 | 8 | 3.95 | 6.70 | 0.80 | 17.00 | 42.00 | 8.00 |
| 8.340 | GT108.4767.020.27.70.R | 7.00 | 0.20 | 47 | 8 | 3.95 | 6.70 | 0.80 | 27.00 | 52.00 | 8.00 |
| 8.360 | GT108.4767.020.37.70.R | 7.00 | 0.20 | 47 | 8 | 3.95 | 6.70 | 0.80 | 37.00 | 62.00 | 8.00 |
| 8.370 | GT108.4767.020.42.70.R | 7.00 | 0.20 | 47 | 8 | 3.95 | 6.70 | 0.80 | 42.00 | 67.00 | 8.00 |
| 8.380 | GT108.4767.020.47.70.R | 7.00 | 0.20 | 47 | 8 | 3.95 | 6.70 | 0.80 | 47.00 | 72.00 | 8.00 |

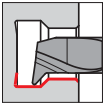
Article no. **27105** **27107**

Cutting direction **L** **L**

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 8.120 | GT108.4767.010.17.70.L | 7.00 | 0.10 | 47 | 8 | 3.95 | 6.70 | 0.80 | 17.00 | 42.00 | 8.00 |
| 8.140 | GT108.4767.010.27.70.L | 7.00 | 0.10 | 47 | 8 | 3.95 | 6.70 | 0.80 | 27.00 | 52.00 | 8.00 |
| 8.160 | GT108.4767.010.37.70.L | 7.00 | 0.10 | 47 | 8 | 3.95 | 6.70 | 0.80 | 37.00 | 62.00 | 8.00 |
| 8.170 | GT108.4767.010.42.70.L | 7.00 | 0.10 | 47 | 8 | 3.95 | 6.70 | 0.80 | 42.00 | 67.00 | 8.00 |
| 8.180 | GT108.4767.010.47.70.L | 7.00 | 0.10 | 47 | 8 | 3.95 | 6.70 | 0.80 | 47.00 | 72.00 | 8.00 |
| 8.320 | GT108.4767.020.17.70.L | 7.00 | 0.20 | 47 | 8 | 3.95 | 6.70 | 0.80 | 17.00 | 42.00 | 8.00 |
| 8.340 | GT108.4767.020.27.70.L | 7.00 | 0.20 | 47 | 8 | 3.95 | 6.70 | 0.80 | 27.00 | 52.00 | 8.00 |
| 8.360 | GT108.4767.020.37.70.L | 7.00 | 0.20 | 47 | 8 | 3.95 | 6.70 | 0.80 | 37.00 | 62.00 | 8.00 |
| 8.370 | GT108.4767.020.42.70.L | 7.00 | 0.20 | 47 | 8 | 3.95 | 6.70 | 0.80 | 42.00 | 67.00 | 8.00 |
| 8.380 | GT108.4767.020.47.70.L | 7.00 | 0.20 | 47 | 8 | 3.95 | 6.70 | 0.80 | 47.00 | 72.00 | 8.00 |



Cutting insert for boring out and profiling



• radial free 47°, tmax 1

Tool material **Solid carbide**

Type GT 108 GT 108

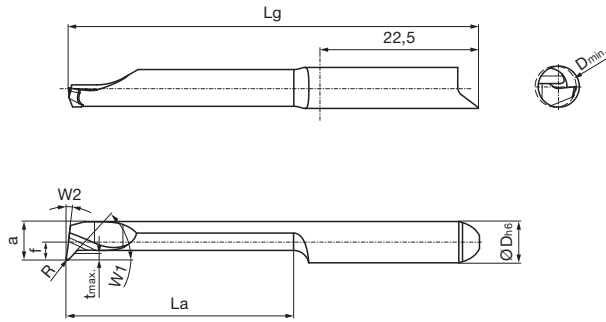
Surface **a** ○

TiAlN-nanoA bright

for tool holders type GH108/GB108 see from page 124

GUHRING NAVIGATOR

Cutting data page 184



Right hand version shown
Left hand version mirror image



System 108

Article no. **27204** **27206**

Cutting direction **R** **R**

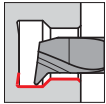
| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 8.029 | GT108.4777.010.17.80.R | 8.00 | 0.10 | 47 | 8 | 3.70 | 7.70 | 1.00 | 17.00 | 42.00 | 8.00 |
| 8.031 | GT108.4777.010.27.80.R | 8.00 | 0.10 | 47 | 8 | 3.70 | 7.70 | 1.00 | 27.00 | 52.00 | 8.00 |
| 8.033 | GT108.4777.010.37.80.R | 8.00 | 0.10 | 47 | 8 | 3.70 | 7.70 | 1.00 | 37.00 | 62.00 | 8.00 |
| 8.034 | GT108.4777.010.42.80.R | 8.00 | 0.10 | 47 | 8 | 3.70 | 7.70 | 1.00 | 42.00 | 67.00 | 8.00 |
| 8.035 | GT108.4777.010.47.80.R | 8.00 | 0.10 | 47 | 8 | 3.70 | 7.70 | 1.00 | 47.00 | 72.00 | 8.00 |
| 8.038 | GT108.4777.020.17.80.R | 8.00 | 0.20 | 47 | 8 | 3.70 | 7.70 | 1.00 | 17.00 | 42.00 | 8.00 |
| 8.040 | GT108.4777.020.27.80.R | 8.00 | 0.20 | 47 | 8 | 3.70 | 7.70 | 1.00 | 27.00 | 52.00 | 8.00 |
| 8.042 | GT108.4777.020.37.80.R | 8.00 | 0.20 | 47 | 8 | 3.70 | 7.70 | 1.00 | 37.00 | 62.00 | 8.00 |
| 8.043 | GT108.4777.020.42.80.R | 8.00 | 0.20 | 47 | 8 | 3.70 | 7.70 | 1.00 | 42.00 | 67.00 | 8.00 |
| 8.044 | GT108.4777.020.47.80.R | 8.00 | 0.20 | 47 | 8 | 3.70 | 7.70 | 1.00 | 47.00 | 72.00 | 8.00 |

Article no. **27205** **27207**

Cutting direction **L** **L**

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 8.029 | GT108.4777.010.17.80.L | 8.00 | 0.10 | 47 | 8 | 3.70 | 7.70 | 1.00 | 17.00 | 42.00 | 8.00 |
| 8.031 | GT108.4777.010.27.80.L | 8.00 | 0.10 | 47 | 8 | 3.70 | 7.70 | 1.00 | 27.00 | 52.00 | 8.00 |
| 8.033 | GT108.4777.010.37.80.L | 8.00 | 0.10 | 47 | 8 | 3.70 | 7.70 | 1.00 | 37.00 | 62.00 | 8.00 |
| 8.034 | GT108.4777.010.42.80.L | 8.00 | 0.10 | 47 | 8 | 3.70 | 7.70 | 1.00 | 42.00 | 67.00 | 8.00 |
| 8.035 | GT108.4777.010.47.80.L | 8.00 | 0.10 | 47 | 8 | 3.70 | 7.70 | 1.00 | 47.00 | 72.00 | 8.00 |
| 8.038 | GT108.4777.020.17.80.L | 8.00 | 0.20 | 47 | 8 | 3.70 | 7.70 | 1.00 | 17.00 | 42.00 | 8.00 |
| 8.040 | GT108.4777.020.27.80.L | 8.00 | 0.20 | 47 | 8 | 3.70 | 7.70 | 1.00 | 27.00 | 52.00 | 8.00 |
| 8.042 | GT108.4777.020.37.80.L | 8.00 | 0.20 | 47 | 8 | 3.70 | 7.70 | 1.00 | 37.00 | 62.00 | 8.00 |
| 8.043 | GT108.4777.020.42.80.L | 8.00 | 0.20 | 47 | 8 | 3.70 | 7.70 | 1.00 | 42.00 | 67.00 | 8.00 |
| 8.044 | GT108.4777.020.47.80.L | 8.00 | 0.20 | 47 | 8 | 3.70 | 7.70 | 1.00 | 47.00 | 72.00 | 8.00 |

Cutting insert for boring out and profiling



• radial free 47°, tmax 2

Tool material **Solid carbide**

Type GT 108 GT 108

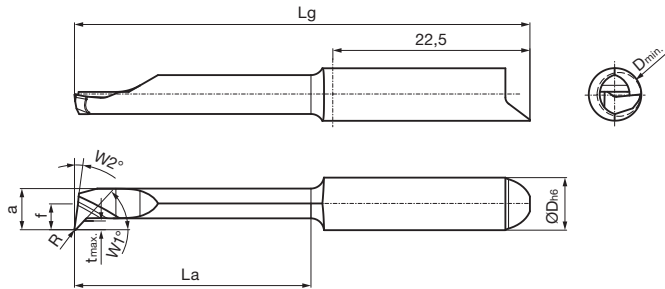
Surface **a** ○

TiAlN-nanoA bright

for tool holders type GH108/GB108 see from page 124

GUHRING NAVIGATOR

Cutting data page 184



Right hand version shown
Left hand version mirror image

Article no. **27108** **27110**

Cutting direction **R** **R**

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 8.120 | GT108.4767.010.17.70.R | 7.00 | 0.10 | 47 | 8 | 3.95 | 6.70 | 2.00 | 17.00 | 42.00 | 8.00 |
| 8.140 | GT108.4767.010.27.70.R | 7.00 | 0.10 | 47 | 8 | 3.95 | 6.70 | 2.00 | 27.00 | 52.00 | 8.00 |
| 8.160 | GT108.4767.010.37.70.R | 7.00 | 0.10 | 47 | 8 | 3.95 | 6.70 | 2.00 | 37.00 | 62.00 | 8.00 |
| 8.170 | GT108.4767.010.42.70.R | 7.00 | 0.10 | 47 | 8 | 3.95 | 6.70 | 2.00 | 42.00 | 67.00 | 8.00 |
| 8.320 | GT108.4767.020.17.70.R | 7.00 | 0.20 | 47 | 8 | 3.95 | 6.70 | 2.00 | 17.00 | 42.00 | 8.00 |
| 8.340 | GT108.4767.020.27.70.R | 7.00 | 0.20 | 47 | 8 | 3.95 | 6.70 | 2.00 | 27.00 | 52.00 | 8.00 |
| 8.360 | GT108.4767.020.37.70.R | 7.00 | 0.20 | 47 | 8 | 3.95 | 6.70 | 2.00 | 37.00 | 62.00 | 8.00 |
| 8.370 | GT108.4767.020.42.70.R | 7.00 | 0.20 | 47 | 8 | 3.95 | 6.70 | 2.00 | 42.00 | 67.00 | 8.00 |

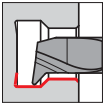
Article no. **27109** **27111**

Cutting direction **L** **L**

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 8.120 | GT108.4767.010.17.70.L | 7.00 | 0.10 | 47 | 8 | 3.95 | 6.70 | 2.00 | 17.00 | 42.00 | 8.00 |
| 8.140 | GT108.4767.010.27.70.L | 7.00 | 0.10 | 47 | 8 | 3.95 | 6.70 | 2.00 | 27.00 | 52.00 | 8.00 |
| 8.160 | GT108.4767.010.37.70.L | 7.00 | 0.10 | 47 | 8 | 3.95 | 6.70 | 2.00 | 37.00 | 62.00 | 8.00 |
| 8.170 | GT108.4767.010.42.70.L | 7.00 | 0.10 | 47 | 8 | 3.95 | 6.70 | 2.00 | 42.00 | 67.00 | 8.00 |
| 8.320 | GT108.4767.020.17.70.L | 7.00 | 0.20 | 47 | 8 | 3.95 | 6.70 | 2.00 | 17.00 | 42.00 | 8.00 |
| 8.340 | GT108.4767.020.27.70.L | 7.00 | 0.20 | 47 | 8 | 3.95 | 6.70 | 2.00 | 27.00 | 52.00 | 8.00 |
| 8.360 | GT108.4767.020.37.70.L | 7.00 | 0.20 | 47 | 8 | 3.95 | 6.70 | 2.00 | 37.00 | 62.00 | 8.00 |
| 8.370 | GT108.4767.020.42.70.L | 7.00 | 0.20 | 47 | 8 | 3.95 | 6.70 | 2.00 | 42.00 | 67.00 | 8.00 |



Cutting insert for boring out and profiling



- radial free 47°, tmax 2.5

Tool material **Solid carbide**

Type GT 108 GT 108

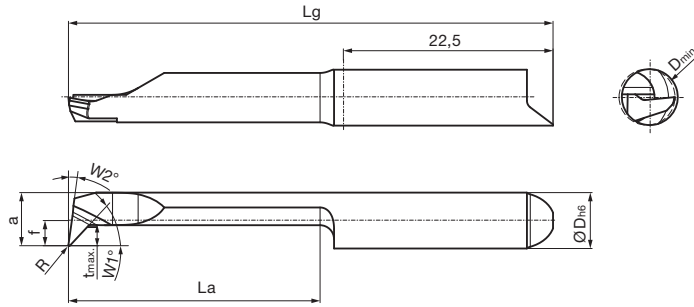
Surface **a** ○

TiAlN-nanoA bright

for tool holders type GH108/GB108 see from page 124

GUHRING NAVIGATOR

Cutting data page 184



Right hand version shown
Left hand version mirror image



System 108

Article no. **27208** **27210**

Cutting direction **R** **R**

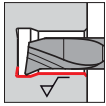
| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 8.120 | GT108.4777.010.17.80.R | 8.00 | 0.10 | 47 | 8 | 3.70 | 7.70 | 2.50 | 17.00 | 42.00 | 8.00 |
| 8.140 | GT108.4777.010.27.80.R | 8.00 | 0.10 | 47 | 8 | 3.70 | 7.70 | 2.50 | 27.00 | 52.00 | 8.00 |
| 8.160 | GT108.4777.010.37.80.R | 8.00 | 0.10 | 47 | 8 | 3.70 | 7.70 | 2.50 | 37.00 | 62.00 | 8.00 |
| 8.170 | GT108.4777.010.42.80.R | 8.00 | 0.10 | 47 | 8 | 3.70 | 7.70 | 2.50 | 42.00 | 72.00 | 8.00 |
| 8.320 | GT108.4777.020.17.80.R | 8.00 | 0.20 | 47 | 8 | 3.70 | 7.70 | 2.50 | 17.00 | 42.00 | 8.00 |
| 8.340 | GT108.4777.020.27.80.R | 8.00 | 0.20 | 47 | 8 | 3.70 | 7.70 | 2.50 | 27.00 | 52.00 | 8.00 |
| 8.360 | GT108.4777.020.37.80.R | 8.00 | 0.20 | 47 | 8 | 3.70 | 7.70 | 2.50 | 37.00 | 62.00 | 8.00 |
| 8.370 | GT108.4777.020.42.80.R | 8.00 | 0.20 | 47 | 8 | 3.70 | 7.70 | 2.50 | 42.00 | 72.00 | 8.00 |

Article no. **27209** **27211**

Cutting direction **L** **L**

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 8.120 | GT108.4777.010.17.80.L | 8.00 | 0.10 | 47 | 8 | 3.70 | 7.70 | 2.50 | 17.00 | 42.00 | 8.00 |
| 8.140 | GT108.4777.010.27.80.L | 8.00 | 0.10 | 47 | 8 | 3.70 | 7.70 | 2.50 | 27.00 | 52.00 | 8.00 |
| 8.160 | GT108.4777.010.37.80.L | 8.00 | 0.10 | 47 | 8 | 3.70 | 7.70 | 2.50 | 37.00 | 62.00 | 8.00 |
| 8.170 | GT108.4777.010.42.80.L | 8.00 | 0.10 | 47 | 8 | 3.70 | 7.70 | 2.50 | 42.00 | 72.00 | 8.00 |
| 8.320 | GT108.4777.020.17.80.L | 8.00 | 0.20 | 47 | 8 | 3.70 | 7.70 | 2.50 | 17.00 | 42.00 | 8.00 |
| 8.340 | GT108.4777.020.27.80.L | 8.00 | 0.20 | 47 | 8 | 3.70 | 7.70 | 2.50 | 27.00 | 52.00 | 8.00 |
| 8.360 | GT108.4777.020.37.80.L | 8.00 | 0.20 | 47 | 8 | 3.70 | 7.70 | 2.50 | 37.00 | 62.00 | 8.00 |
| 8.370 | GT108.4777.020.42.80.L | 8.00 | 0.20 | 47 | 8 | 3.70 | 7.70 | 2.50 | 42.00 | 72.00 | 8.00 |

Cutting insert for boring out and profiling



• WIPER-geometry

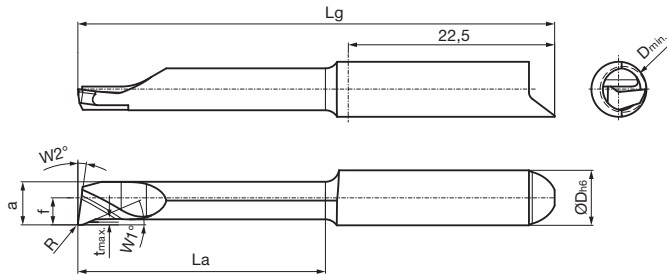
for tool holders type GH108/GB108 see from page 124

GUHRING NAVIGATOR

Cutting data page 184

| | | |
|---------------|---------------|--------|
| Tool material | Solid carbide | |
| Type | GJ 108 | GJ 108 |
| Surface | | |
| | TiAlN-nanoA | bright |

System 108



Right hand version shown
Left hand version mirror image

| | | |
|-------------------|--------------|--------------|
| Article no. | 27116 | 27118 |
| Cutting direction | | |

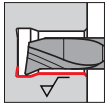
| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 8.120 | GJ108.2367.010.17.70.R | 7.00 | 0.10 | 23 | 8 | 3.95 | 6.70 | 0.50 | 17.00 | 42.00 | 8.00 |
| 8.140 | GJ108.2367.010.27.70.R | 7.00 | 0.10 | 23 | 8 | 3.95 | 6.70 | 0.50 | 27.00 | 52.00 | 8.00 |
| 8.160 | GJ108.2367.010.37.70.R | 7.00 | 0.10 | 23 | 8 | 3.95 | 6.70 | 0.50 | 37.00 | 62.00 | 8.00 |
| 8.170 | GJ108.2367.010.42.70.R | 7.00 | 0.10 | 23 | 8 | 3.95 | 6.70 | 0.50 | 42.00 | 67.00 | 8.00 |
| 8.180 | GJ108.2367.010.47.70.R | 7.00 | 0.10 | 23 | 8 | 3.95 | 6.70 | 0.50 | 47.00 | 72.00 | 8.00 |
| 8.190 | GJ108.2367.010.52.70.R | 7.00 | 0.10 | 23 | 8 | 3.95 | 6.70 | 0.50 | 52.00 | 77.00 | 8.00 |
| 8.320 | GJ108.2367.020.17.70.R | 7.00 | 0.20 | 23 | 8 | 3.95 | 6.70 | 0.50 | 17.00 | 42.00 | 8.00 |
| 8.340 | GJ108.2367.020.27.70.R | 7.00 | 0.20 | 23 | 8 | 3.95 | 6.70 | 0.50 | 27.00 | 52.00 | 8.00 |
| 8.360 | GJ108.2367.020.37.70.R | 7.00 | 0.20 | 23 | 8 | 3.95 | 6.70 | 0.50 | 37.00 | 62.00 | 8.00 |
| 8.370 | GJ108.2367.020.42.70.R | 7.00 | 0.20 | 23 | 8 | 3.95 | 6.70 | 0.50 | 42.00 | 67.00 | 8.00 |
| 8.380 | GJ108.2367.020.47.70.R | 7.00 | 0.20 | 23 | 8 | 3.95 | 6.70 | 0.50 | 47.00 | 72.00 | 8.00 |
| 8.390 | GJ108.2367.020.52.70.R | 7.00 | 0.20 | 23 | 8 | 3.95 | 6.70 | 0.50 | 52.00 | 77.00 | 8.00 |

| | | |
|-------------------|--------------|--------------|
| Article no. | 27117 | 27119 |
| Cutting direction | | |

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 8.120 | GJ108.2367.010.17.70.L | 7.00 | 0.10 | 23 | 8 | 3.95 | 6.70 | 0.50 | 17.00 | 42.00 | 8.00 |
| 8.140 | GJ108.2367.010.27.70.L | 7.00 | 0.10 | 23 | 8 | 3.95 | 6.70 | 0.50 | 27.00 | 52.00 | 8.00 |
| 8.160 | GJ108.2367.010.37.70.L | 7.00 | 0.10 | 23 | 8 | 3.95 | 6.70 | 0.50 | 37.00 | 62.00 | 8.00 |
| 8.170 | GJ108.2367.010.42.70.L | 7.00 | 0.10 | 23 | 8 | 3.95 | 6.70 | 0.50 | 42.00 | 67.00 | 8.00 |
| 8.180 | GJ108.2367.010.47.70.L | 7.00 | 0.10 | 23 | 8 | 3.95 | 6.70 | 0.50 | 47.00 | 72.00 | 8.00 |
| 8.190 | GJ108.2367.010.52.70.L | 7.00 | 0.10 | 23 | 8 | 3.95 | 6.70 | 0.50 | 52.00 | 77.00 | 8.00 |
| 8.320 | GJ108.2367.020.17.70.L | 7.00 | 0.20 | 23 | 8 | 3.95 | 6.70 | 0.50 | 17.00 | 42.00 | 8.00 |
| 8.340 | GJ108.2367.020.27.70.L | 7.00 | 0.20 | 23 | 8 | 3.95 | 6.70 | 0.50 | 27.00 | 52.00 | 8.00 |
| 8.360 | GJ108.2367.020.37.70.L | 7.00 | 0.20 | 23 | 8 | 3.95 | 6.70 | 0.50 | 37.00 | 62.00 | 8.00 |
| 8.370 | GJ108.2367.020.42.70.L | 7.00 | 0.20 | 23 | 8 | 3.95 | 6.70 | 0.50 | 42.00 | 67.00 | 8.00 |
| 8.380 | GJ108.2367.020.47.70.L | 7.00 | 0.20 | 23 | 8 | 3.95 | 6.70 | 0.50 | 47.00 | 72.00 | 8.00 |
| 8.390 | GJ108.2367.020.52.70.L | 7.00 | 0.20 | 23 | 8 | 3.95 | 6.70 | 0.50 | 52.00 | 77.00 | 8.00 |



Cutting insert for boring out and profiling



• WIPER-geometry

Tool material **Solid carbide**

Type GJ 108 GJ 108

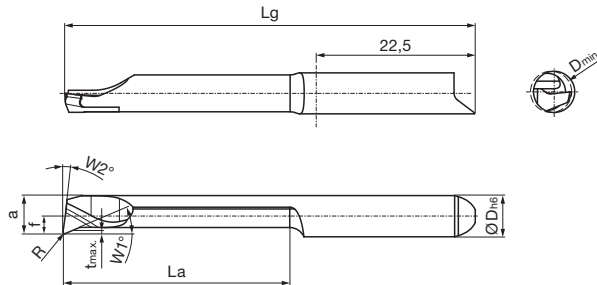
Surface **a** ○

TiAlN-nanoA bright

for tool holders type GH108/GB108 see from page 124

GUHRING NAVIGATOR

Cutting data page 184



System 108

Right hand version shown
Left hand version mirror image

Article no. **27216** **27218**

Cutting direction **R** **R**

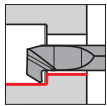
| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 8.120 | GJ108.2377.010.17.80.R | 8.00 | 0.10 | 23 | 8 | 3.70 | 7.70 | 0.60 | 17.00 | 42.00 | 8.00 |
| 8.140 | GJ108.2377.010.27.80.R | 8.00 | 0.10 | 23 | 8 | 3.70 | 7.70 | 0.60 | 27.00 | 52.00 | 8.00 |
| 8.160 | GJ108.2377.010.37.80.R | 8.00 | 0.10 | 23 | 8 | 3.70 | 7.70 | 0.60 | 37.00 | 62.00 | 8.00 |
| 8.170 | GJ108.2377.010.42.80.R | 8.00 | 0.10 | 23 | 8 | 3.70 | 7.70 | 0.60 | 42.00 | 67.00 | 8.00 |
| 8.180 | GJ108.2377.010.47.80.R | 8.00 | 0.10 | 23 | 8 | 3.70 | 7.70 | 0.60 | 47.00 | 72.00 | 8.00 |
| 8.190 | GJ108.2377.010.52.80.R | 8.00 | 0.10 | 23 | 8 | 3.70 | 7.70 | 0.60 | 52.00 | 77.00 | 8.00 |
| 8.320 | GJ108.2377.020.17.80.R | 8.00 | 0.20 | 23 | 8 | 3.70 | 7.70 | 0.60 | 17.00 | 42.00 | 8.00 |
| 8.340 | GJ108.2377.020.27.80.R | 8.00 | 0.20 | 23 | 8 | 3.70 | 7.70 | 0.60 | 27.00 | 52.00 | 8.00 |
| 8.360 | GJ108.2377.020.37.80.R | 8.00 | 0.20 | 23 | 8 | 3.70 | 7.70 | 0.60 | 37.00 | 62.00 | 8.00 |
| 8.370 | GJ108.2377.020.42.80.R | 8.00 | 0.20 | 23 | 8 | 3.70 | 7.70 | 0.60 | 42.00 | 67.00 | 8.00 |
| 8.380 | GJ108.2377.020.47.80.R | 8.00 | 0.20 | 23 | 8 | 3.70 | 7.70 | 0.60 | 47.00 | 72.00 | 8.00 |
| 8.390 | GJ108.2377.020.52.80.R | 8.00 | 0.20 | 23 | 8 | 3.70 | 7.70 | 0.60 | 52.00 | 77.00 | 8.00 |

Article no. **27217** **27219**

Cutting direction **L** **L**

| Code no. | Description | D min | R | W1 | W2 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | ° | mm | mm | mm | mm | mm | mm |
| 8.120 | GJ108.2377.010.17.80.L | 8.00 | 0.10 | 23 | 8 | 3.70 | 7.70 | 0.60 | 17.00 | 42.00 | 8.00 |
| 8.140 | GJ108.2377.010.27.80.L | 8.00 | 0.10 | 23 | 8 | 3.70 | 7.70 | 0.60 | 27.00 | 52.00 | 8.00 |
| 8.160 | GJ108.2377.010.37.80.L | 8.00 | 0.10 | 23 | 8 | 3.70 | 7.70 | 0.60 | 37.00 | 62.00 | 8.00 |
| 8.170 | GJ108.2377.010.42.80.L | 8.00 | 0.10 | 23 | 8 | 3.70 | 7.70 | 0.60 | 42.00 | 67.00 | 8.00 |
| 8.180 | GJ108.2377.010.47.80.L | 8.00 | 0.10 | 23 | 8 | 3.70 | 7.70 | 0.60 | 47.00 | 72.00 | 8.00 |
| 8.190 | GJ108.2377.010.52.80.L | 8.00 | 0.10 | 23 | 8 | 3.70 | 7.70 | 0.60 | 52.00 | 77.00 | 8.00 |
| 8.320 | GJ108.2377.020.17.80.L | 8.00 | 0.20 | 23 | 8 | 3.70 | 7.70 | 0.60 | 17.00 | 42.00 | 8.00 |
| 8.340 | GJ108.2377.020.27.80.L | 8.00 | 0.20 | 23 | 8 | 3.70 | 7.70 | 0.60 | 27.00 | 52.00 | 8.00 |
| 8.360 | GJ108.2377.020.37.80.L | 8.00 | 0.20 | 23 | 8 | 3.70 | 7.70 | 0.60 | 37.00 | 62.00 | 8.00 |
| 8.370 | GJ108.2377.020.42.80.L | 8.00 | 0.20 | 23 | 8 | 3.70 | 7.70 | 0.60 | 42.00 | 67.00 | 8.00 |
| 8.380 | GJ108.2377.020.47.80.L | 8.00 | 0.20 | 23 | 8 | 3.70 | 7.70 | 0.60 | 47.00 | 72.00 | 8.00 |
| 8.390 | GJ108.2377.020.52.80.L | 8.00 | 0.20 | 23 | 8 | 3.70 | 7.70 | 0.60 | 52.00 | 77.00 | 8.00 |

Cutting insert for back boring and profiling



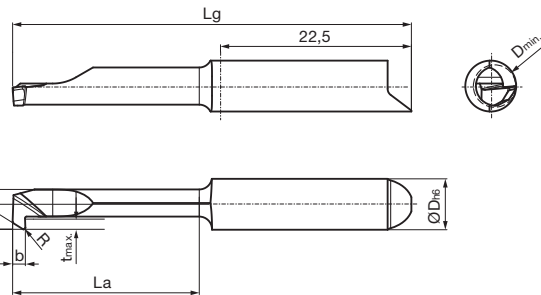
• radial free 32°

for tool holders type GH108/GB108 see from page 124

GUHRING NAVIGATOR

Cutting data page 184

| | | |
|---------------|---------------|--------|
| Tool material | Solid carbide | |
| Type | GT 108 | GT 108 |
| Surface | | |
| | TiAlN-nanoA | bright |



Right hand version shown
Left hand version mirror image

| | | |
|-------------------|--------------|--------------|
| Article no. | 27120 | 27122 |
| Cutting direction | | |

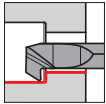
| Code no. | Description | D min | R | W1 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | mm | mm | mm | mm | mm | mm |
| 8.010 | GT108.3267.020.17.70.R | 7.00 | 0.20 | 32 | 3.95 | 6.70 | 1.80 | 17.00 | 42.00 | 8.00 |
| 8.020 | GT108.3267.020.27.70.R | 7.00 | 0.20 | 32 | 3.95 | 6.70 | 1.80 | 27.00 | 52.00 | 8.00 |
| 8.030 | GT108.3267.020.37.70.R | 7.00 | 0.20 | 32 | 3.95 | 6.70 | 1.80 | 37.00 | 62.00 | 8.00 |
| 8.040 | GT108.3267.020.42.70.R | 7.00 | 0.20 | 32 | 3.95 | 6.70 | 1.80 | 42.00 | 67.00 | 8.00 |
| 8.050 | GT108.3267.020.47.70.R | 7.00 | 0.20 | 32 | 3.95 | 6.70 | 1.80 | 47.00 | 72.00 | 8.00 |
| 8.060 | GT108.3267.020.52.70.R | 7.00 | 0.20 | 32 | 3.95 | 6.70 | 1.80 | 52.00 | 77.00 | 8.00 |

| | | |
|-------------------|--------------|--------------|
| Article no. | 27121 | 27123 |
| Cutting direction | | |

| Code no. | Description | D min | R | W1 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | mm | mm | mm | mm | mm | mm |
| 8.010 | GT108.3267.020.17.70.L | 7.00 | 0.20 | 32 | 3.95 | 6.70 | 1.80 | 17.00 | 42.00 | 8.00 |
| 8.020 | GT108.3267.020.27.70.L | 7.00 | 0.20 | 32 | 3.95 | 6.70 | 1.80 | 27.00 | 52.00 | 8.00 |
| 8.030 | GT108.3267.020.37.70.L | 7.00 | 0.20 | 32 | 3.95 | 6.70 | 1.80 | 37.00 | 62.00 | 8.00 |
| 8.040 | GT108.3267.020.42.70.L | 7.00 | 0.20 | 32 | 3.95 | 6.70 | 1.80 | 42.00 | 67.00 | 8.00 |
| 8.050 | GT108.3267.020.47.70.L | 7.00 | 0.20 | 32 | 3.95 | 6.70 | 1.80 | 47.00 | 72.00 | 8.00 |
| 8.060 | GT108.3267.020.52.70.L | 7.00 | 0.20 | 32 | 3.95 | 6.70 | 1.80 | 52.00 | 77.00 | 8.00 |



Cutting insert for back boring and profiling



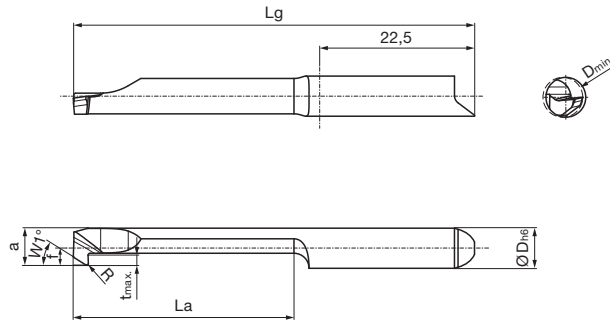
• radial free 32°

for tool holders type GH108/GB108 see from page 124

GUHRING NAVIGATOR

Cutting data page 184

| | | |
|---------------|---------------|--------|
| Tool material | Solid carbide | |
| Type | GT 108 | GT 108 |
| Surface | | |
| | TiAlN-nanoA | bright |



Right hand version shown
Left hand version mirror image



System 108

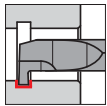
| | | |
|-------------------|--------------|--------------|
| Article no. | 27220 | 27222 |
| Cutting direction | | |

| Code no. | Description | D min | R | W1 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | mm | mm | mm | mm | mm | mm |
| 8.010 | GT108.3277.020.17.80.R | 8.00 | 0.20 | 32 | 3.70 | 7.70 | 2.20 | 17.00 | 42.00 | 8.00 |
| 8.020 | GT108.3277.020.27.80.R | 8.00 | 0.20 | 32 | 3.70 | 7.70 | 2.20 | 27.00 | 52.00 | 8.00 |
| 8.030 | GT108.3277.020.37.80.R | 8.00 | 0.20 | 32 | 3.70 | 7.70 | 2.20 | 37.00 | 62.00 | 8.00 |
| 8.040 | GT108.3277.020.42.80.R | 8.00 | 0.20 | 32 | 3.70 | 7.70 | 2.20 | 42.00 | 67.00 | 8.00 |
| 8.050 | GT108.3277.020.47.80.R | 8.00 | 0.20 | 32 | 3.70 | 7.70 | 2.20 | 47.00 | 72.00 | 8.00 |
| 8.060 | GT108.3277.020.52.80.R | 8.00 | 0.20 | 32 | 3.70 | 7.70 | 2.20 | 52.00 | 77.00 | 8.00 |

| | | |
|-------------------|--------------|--------------|
| Article no. | 27221 | 27223 |
| Cutting direction | | |

| Code no. | Description | D min | R | W1 | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|----|------|------|-------|-------|-------|------|
| | | mm | mm | ° | mm | mm | mm | mm | mm | mm |
| 8.010 | GT108.3277.020.17.80.L | 8.00 | 0.20 | 32 | 3.70 | 7.70 | 2.20 | 17.00 | 42.00 | 8.00 |
| 8.020 | GT108.3277.020.27.80.L | 8.00 | 0.20 | 32 | 3.70 | 7.70 | 2.20 | 27.00 | 52.00 | 8.00 |
| 8.030 | GT108.3277.020.37.80.L | 8.00 | 0.20 | 32 | 3.70 | 7.70 | 2.20 | 37.00 | 62.00 | 8.00 |
| 8.040 | GT108.3277.020.42.80.L | 8.00 | 0.20 | 32 | 3.70 | 7.70 | 2.20 | 42.00 | 67.00 | 8.00 |
| 8.050 | GT108.3277.020.47.80.L | 8.00 | 0.20 | 32 | 3.70 | 7.70 | 2.20 | 47.00 | 72.00 | 8.00 |
| 8.060 | GT108.3277.020.52.80.L | 8.00 | 0.20 | 32 | 3.70 | 7.70 | 2.20 | 52.00 | 77.00 | 8.00 |

Cutting insert for internal grooving, straight slots



- grooving depth up to 2.5 mm

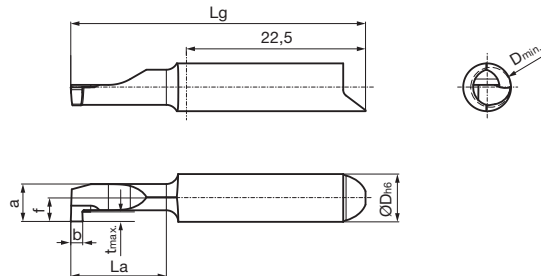
for tool holders type GH108/GB108 see from page 124

GUHRING NAVIGATOR

Cutting data page 184

| | | |
|---------------|---------------|--------|
| Tool material | Solid carbide | |
| Type | GE 108 | GE 108 |
| Surface | | |
| | TiAlN-nanoA | bright |

System 108



Right hand version shown
Left hand version mirror image

| | | |
|-------------------|--------------|--------------|
| Article no. | 27124 | 27126 |
| Cutting direction | | |

| Code no. | Description | D min | b | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm |
| 8.010 | GE108.0150.000.17.70.R | 7.00 | 1.50 | 3.95 | 6.70 | 2.50 | 17.00 | 42.00 | 8.00 |
| 8.020 | GE108.0150.000.27.70.R | 7.00 | 1.50 | 3.95 | 6.70 | 2.50 | 27.00 | 52.00 | 8.00 |
| 8.030 | GE108.0150.000.37.70.R | 7.00 | 1.50 | 3.95 | 6.70 | 2.50 | 37.00 | 62.00 | 8.00 |
| 8.040 | GE108.0150.000.42.70.R | 7.00 | 1.50 | 3.95 | 6.70 | 2.50 | 42.00 | 67.00 | 8.00 |
| 8.050 | GE108.0150.000.47.70.R | 7.00 | 1.50 | 3.95 | 6.70 | 2.50 | 47.00 | 72.00 | 8.00 |
| 8.110 | GE108.0200.000.17.70.R | 7.00 | 2.00 | 3.95 | 6.70 | 2.50 | 17.00 | 42.00 | 8.00 |
| 8.120 | GE108.0200.000.27.70.R | 7.00 | 2.00 | 3.95 | 6.70 | 2.50 | 27.00 | 52.00 | 8.00 |
| 8.130 | GE108.0200.000.37.70.R | 7.00 | 2.00 | 3.95 | 6.70 | 2.50 | 37.00 | 62.00 | 8.00 |
| 8.140 | GE108.0200.000.42.70.R | 7.00 | 2.00 | 3.95 | 6.70 | 2.50 | 42.00 | 67.00 | 8.00 |
| 8.150 | GE108.0200.000.47.70.R | 7.00 | 2.00 | 3.95 | 6.70 | 2.50 | 47.00 | 72.00 | 8.00 |
| 8.210 | GE108.0250.000.17.70.R | 7.00 | 2.50 | 3.95 | 6.70 | 2.50 | 17.00 | 42.00 | 8.00 |
| 8.220 | GE108.0250.000.27.70.R | 7.00 | 2.50 | 3.95 | 6.70 | 2.50 | 27.00 | 52.00 | 8.00 |
| 8.230 | GE108.0250.000.37.70.R | 7.00 | 2.50 | 3.95 | 6.70 | 2.50 | 37.00 | 62.00 | 8.00 |
| 8.240 | GE108.0250.000.42.70.R | 7.00 | 2.50 | 3.95 | 6.70 | 2.50 | 42.00 | 67.00 | 8.00 |
| 8.250 | GE108.0250.000.47.70.R | 7.00 | 2.50 | 3.95 | 6.70 | 2.50 | 47.00 | 72.00 | 8.00 |
| 8.310 | GE108.0300.000.17.70.R | 7.00 | 3.00 | 3.95 | 6.70 | 2.50 | 17.00 | 42.00 | 8.00 |
| 8.320 | GE108.0300.000.27.70.R | 7.00 | 3.00 | 3.95 | 6.70 | 2.50 | 27.00 | 52.00 | 8.00 |
| 8.330 | GE108.0300.000.37.70.R | 7.00 | 3.00 | 3.95 | 6.70 | 2.50 | 37.00 | 62.00 | 8.00 |
| 8.340 | GE108.0300.000.42.70.R | 7.00 | 3.00 | 3.95 | 6.70 | 2.50 | 42.00 | 67.00 | 8.00 |
| 8.350 | GE108.0300.000.47.70.R | 7.00 | 3.00 | 3.95 | 6.70 | 2.50 | 47.00 | 72.00 | 8.00 |

| | | |
|-------------------|--------------|--------------|
| Article no. | 27125 | 27127 |
| Cutting direction | | |

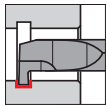
| Code no. | Description | D min | b | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm |
| 8.010 | GE108.0150.000.17.70.L | 7.00 | 1.50 | 3.95 | 6.70 | 2.50 | 17.00 | 42.00 | 8.00 |
| 8.020 | GE108.0150.000.27.70.L | 7.00 | 1.50 | 3.95 | 6.70 | 2.50 | 27.00 | 52.00 | 8.00 |
| 8.030 | GE108.0150.000.37.70.L | 7.00 | 1.50 | 3.95 | 6.70 | 2.50 | 37.00 | 62.00 | 8.00 |
| 8.040 | GE108.0150.000.42.70.L | 7.00 | 1.50 | 3.95 | 6.70 | 2.50 | 42.00 | 67.00 | 8.00 |
| 8.050 | GE108.0150.000.47.70.L | 7.00 | 1.50 | 3.95 | 6.70 | 2.50 | 47.00 | 72.00 | 8.00 |
| 8.110 | GE108.0200.000.17.70.L | 7.00 | 2.00 | 3.95 | 6.70 | 2.50 | 17.00 | 42.00 | 8.00 |

Article no. **27125** **27127**Cutting direction  

| Code no. | Description | D min | b | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm |
| 8.120 | GE108.0200.000.27.70.L | 7.00 | 2.00 | 3.95 | 6.70 | 2.50 | 27.00 | 52.00 | 8.00 |
| 8.130 | GE108.0200.000.37.70.L | 7.00 | 2.00 | 3.95 | 6.70 | 2.50 | 37.00 | 62.00 | 8.00 |
| 8.140 | GE108.0200.000.42.70.L | 7.00 | 2.00 | 3.95 | 6.70 | 2.50 | 42.00 | 67.00 | 8.00 |
| 8.150 | GE108.0200.000.47.70.L | 7.00 | 2.00 | 3.95 | 6.70 | 2.50 | 47.00 | 72.00 | 8.00 |
| 8.210 | GE108.0250.000.17.70.L | 7.00 | 2.50 | 3.95 | 6.70 | 2.50 | 17.00 | 42.00 | 8.00 |
| 8.220 | GE108.0250.000.27.70.L | 7.00 | 2.50 | 3.95 | 6.70 | 2.50 | 27.00 | 52.00 | 8.00 |
| 8.230 | GE108.0250.000.37.70.L | 7.00 | 2.50 | 3.95 | 6.70 | 2.50 | 37.00 | 62.00 | 8.00 |
| 8.240 | GE108.0250.000.42.70.L | 7.00 | 2.50 | 3.95 | 6.70 | 2.50 | 42.00 | 67.00 | 8.00 |
| 8.250 | GE108.0250.000.47.70.L | 7.00 | 2.50 | 3.95 | 6.70 | 2.50 | 47.00 | 72.00 | 8.00 |
| 8.310 | GE108.0300.000.17.70.L | 7.00 | 3.00 | 3.95 | 6.70 | 2.50 | 17.00 | 42.00 | 8.00 |
| 8.320 | GE108.0300.000.27.70.L | 7.00 | 3.00 | 3.95 | 6.70 | 2.50 | 27.00 | 52.00 | 8.00 |
| 8.330 | GE108.0300.000.37.70.L | 7.00 | 3.00 | 3.95 | 6.70 | 2.50 | 37.00 | 62.00 | 8.00 |
| 8.340 | GE108.0300.000.42.70.L | 7.00 | 3.00 | 3.95 | 6.70 | 2.50 | 42.00 | 67.00 | 8.00 |
| 8.350 | GE108.0300.000.47.70.L | 7.00 | 3.00 | 3.95 | 6.70 | 2.50 | 47.00 | 72.00 | 8.00 |

System 108

Cutting insert for internal grooving, straight slots



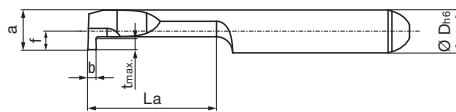
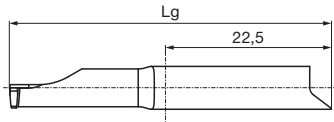
- grooving depth up to 3 mm

for tool holders type GH108/GB108 see from page 124

GUHRING NAVIGATOR

Cutting data page 184

| | | |
|---------------|---------------|--------|
| Tool material | Solid carbide | |
| Type | GE 108 | GE 108 |
| Surface | | |
| | TiAlN-nanoA | bright |



Right hand version shown
Left hand version mirror image

| | | |
|-------------------|--------------|--------------|
| Article no. | 27224 | 27225 |
| Cutting direction | | |

| Code no. | Description | D min | b | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm |
| 8.010 | GE108.0150.000.17.80.R | 8.00 | 1.50 | 3.70 | 7.70 | 3.00 | 17.00 | 42.00 | 8.00 |
| 8.020 | GE108.0150.000.27.80.R | 8.00 | 1.50 | 3.70 | 7.70 | 3.00 | 27.00 | 52.00 | 8.00 |
| 8.030 | GE108.0150.000.37.80.R | 8.00 | 1.50 | 3.70 | 7.70 | 3.00 | 37.00 | 62.00 | 8.00 |
| 8.040 | GE108.0150.000.42.80.R | 8.00 | 1.50 | 3.70 | 7.70 | 3.00 | 42.00 | 67.00 | 8.00 |
| 8.050 | GE108.0150.000.47.80.R | 8.00 | 1.50 | 3.70 | 7.70 | 3.00 | 47.00 | 72.00 | 8.00 |
| 8.110 | GE108.0200.000.17.80.R | 8.00 | 2.00 | 3.70 | 7.70 | 3.00 | 17.00 | 42.00 | 8.00 |
| 8.120 | GE108.0200.000.27.80.R | 8.00 | 2.00 | 3.70 | 7.70 | 3.00 | 27.00 | 52.00 | 8.00 |
| 8.130 | GE108.0200.000.37.80.R | 8.00 | 2.00 | 3.70 | 7.70 | 3.00 | 37.00 | 62.00 | 8.00 |
| 8.140 | GE108.0200.000.42.80.R | 8.00 | 2.00 | 3.70 | 7.70 | 3.00 | 42.00 | 67.00 | 8.00 |
| 8.150 | GE108.0200.000.47.80.R | 8.00 | 2.00 | 3.70 | 7.70 | 3.00 | 47.00 | 72.00 | 8.00 |
| 8.210 | GE108.0250.000.17.80.R | 8.00 | 2.50 | 3.70 | 7.70 | 3.00 | 17.00 | 42.00 | 8.00 |
| 8.220 | GE108.0250.000.27.80.R | 8.00 | 2.50 | 3.70 | 7.70 | 3.00 | 27.00 | 52.00 | 8.00 |
| 8.230 | GE108.0250.000.37.80.R | 8.00 | 2.50 | 3.70 | 7.70 | 3.00 | 37.00 | 62.00 | 8.00 |
| 8.240 | GE108.0250.000.42.80.R | 8.00 | 2.50 | 3.70 | 7.70 | 3.00 | 42.00 | 67.00 | 8.00 |
| 8.250 | GE108.0250.000.47.80.R | 8.00 | 2.50 | 3.70 | 7.70 | 3.00 | 47.00 | 72.00 | 8.00 |
| 8.310 | GE108.0300.000.17.80.R | 8.00 | 3.00 | 3.70 | 7.70 | 3.00 | 17.00 | 42.00 | 8.00 |
| 8.320 | GE108.0300.000.27.80.R | 8.00 | 3.00 | 3.70 | 7.70 | 3.00 | 27.00 | 52.00 | 8.00 |
| 8.330 | GE108.0300.000.37.80.R | 8.00 | 3.00 | 3.70 | 7.70 | 3.00 | 37.00 | 62.00 | 8.00 |
| 8.340 | GE108.0300.000.42.80.R | 8.00 | 3.00 | 3.70 | 7.70 | 3.00 | 42.00 | 67.00 | 8.00 |
| 8.350 | GE108.0300.000.47.80.R | 8.00 | 3.00 | 3.70 | 7.70 | 3.00 | 47.00 | 72.00 | 8.00 |

| | | |
|-------------------|--------------|--------------|
| Article no. | 27226 | 27227 |
| Cutting direction | | |

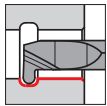
| Code no. | Description | D min | b | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm |
| 8.010 | GE108.0150.000.17.80.L | 8.00 | 1.50 | 3.70 | 7.70 | 3.00 | 17.00 | 42.00 | 8.00 |
| 8.020 | GE108.0150.000.27.80.L | 8.00 | 1.50 | 3.70 | 7.70 | 3.00 | 27.00 | 52.00 | 8.00 |
| 8.030 | GE108.0150.000.37.80.L | 8.00 | 1.50 | 3.70 | 7.70 | 3.00 | 37.00 | 62.00 | 8.00 |
| 8.040 | GE108.0150.000.42.80.L | 8.00 | 1.50 | 3.70 | 7.70 | 3.00 | 42.00 | 67.00 | 8.00 |
| 8.050 | GE108.0150.000.47.80.L | 8.00 | 1.50 | 3.70 | 7.70 | 3.00 | 47.00 | 72.00 | 8.00 |
| 8.110 | GE108.0200.000.17.80.L | 8.00 | 2.00 | 3.70 | 7.70 | 3.00 | 17.00 | 42.00 | 8.00 |

Article no. **27226** **27227**Cutting direction  

| Code no. | Description | D min | b | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm |
| 8.120 | GE108.0200.000.27.80.L | 8.00 | 2.00 | 3.70 | 7.70 | 3.00 | 27.00 | 52.00 | 8.00 |
| 8.130 | GE108.0200.000.37.80.L | 8.00 | 2.00 | 3.70 | 7.70 | 3.00 | 37.00 | 62.00 | 8.00 |
| 8.140 | GE108.0200.000.42.80.L | 8.00 | 2.00 | 3.70 | 7.70 | 3.00 | 42.00 | 67.00 | 8.00 |
| 8.150 | GE108.0200.000.47.80.L | 8.00 | 2.00 | 3.70 | 7.70 | 3.00 | 47.00 | 72.00 | 8.00 |
| 8.210 | GE108.0250.000.17.80.L | 8.00 | 2.50 | 3.70 | 7.70 | 3.00 | 17.00 | 42.00 | 8.00 |
| 8.220 | GE108.0250.000.27.80.L | 8.00 | 2.50 | 3.70 | 7.70 | 3.00 | 27.00 | 52.00 | 8.00 |
| 8.230 | GE108.0250.000.37.80.L | 8.00 | 2.50 | 3.70 | 7.70 | 3.00 | 37.00 | 62.00 | 8.00 |
| 8.240 | GE108.0250.000.42.80.L | 8.00 | 2.50 | 3.70 | 7.70 | 3.00 | 42.00 | 67.00 | 8.00 |
| 8.250 | GE108.0250.000.47.80.L | 8.00 | 2.50 | 3.70 | 7.70 | 3.00 | 47.00 | 72.00 | 8.00 |
| 8.310 | GE108.0300.000.17.80.L | 8.00 | 3.00 | 3.70 | 7.70 | 3.00 | 17.00 | 42.00 | 8.00 |
| 8.320 | GE108.0300.000.27.80.L | 8.00 | 3.00 | 3.70 | 7.70 | 3.00 | 27.00 | 52.00 | 8.00 |
| 8.330 | GE108.0300.000.37.80.L | 8.00 | 3.00 | 3.70 | 7.70 | 3.00 | 37.00 | 62.00 | 8.00 |
| 8.340 | GE108.0300.000.42.80.L | 8.00 | 3.00 | 3.70 | 7.70 | 3.00 | 42.00 | 67.00 | 8.00 |
| 8.350 | GE108.0300.000.47.80.L | 8.00 | 3.00 | 3.70 | 7.70 | 3.00 | 47.00 | 72.00 | 8.00 |

System 108

Cutting insert for internal grooving, full radius slots



• full radius R0.75-R1.5

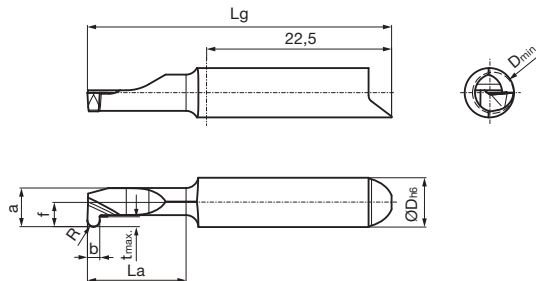
for tool holders type GH108/GB108 see from page 124

GUHRING NAVIGATOR

Cutting data page 184

| | | |
|---------------|---------------|--------|
| Tool material | Solid carbide | |
| Type | GE 108 | GE 108 |
| Surface | | |
| | TiAlN-nanoA | bright |

System 108





Right hand version shown
Left hand version mirror image

| | | |
|-------------------|--------------|--------------|
| Article no. | 27128 | 27130 |
| Cutting direction | | |

| Code no. | Description | D min | b | R | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm | mm |
| 8.010 | GE108.0150.075.17.70.R | 7.00 | 1.50 | 0.75 | 3.95 | 6.70 | 2.50 | 17.00 | 42.00 | 8.00 |
| 8.020 | GE108.0150.075.27.70.R | 7.00 | 1.50 | 0.75 | 3.95 | 6.70 | 2.50 | 27.00 | 52.00 | 8.00 |
| 8.030 | GE108.0150.075.37.70.R | 7.00 | 1.50 | 0.75 | 3.95 | 6.70 | 2.50 | 37.00 | 62.00 | 8.00 |
| 8.040 | GE108.0150.075.42.70.R | 7.00 | 1.50 | 0.75 | 3.95 | 6.70 | 2.50 | 42.00 | 67.00 | 8.00 |
| 8.050 | GE108.0150.075.47.70.R | 7.00 | 1.50 | 0.75 | 3.95 | 6.70 | 2.50 | 47.00 | 72.00 | 8.00 |
| 8.110 | GE108.0200.100.17.70.R | 7.00 | 2.00 | 1.00 | 3.95 | 6.70 | 2.50 | 17.00 | 42.00 | 8.00 |
| 8.120 | GE108.0200.100.27.70.R | 7.00 | 2.00 | 1.00 | 3.95 | 6.70 | 2.50 | 27.00 | 52.00 | 8.00 |
| 8.130 | GE108.0200.100.37.70.R | 7.00 | 2.00 | 1.00 | 3.95 | 6.70 | 2.50 | 37.00 | 62.00 | 8.00 |
| 8.140 | GE108.0200.100.42.70.R | 7.00 | 2.00 | 1.00 | 3.95 | 6.70 | 2.50 | 42.00 | 67.00 | 8.00 |
| 8.150 | GE108.0200.100.47.70.R | 7.00 | 2.00 | 1.00 | 3.95 | 6.70 | 2.50 | 47.00 | 72.00 | 8.00 |
| 8.210 | GE108.0250.125.17.70.R | 7.00 | 2.50 | 1.25 | 3.95 | 6.70 | 2.50 | 17.00 | 42.00 | 8.00 |
| 8.220 | GE108.0250.125.27.70.R | 7.00 | 2.50 | 1.25 | 3.95 | 6.70 | 2.50 | 27.00 | 52.00 | 8.00 |
| 8.230 | GE108.0250.125.37.70.R | 7.00 | 2.50 | 1.25 | 3.95 | 6.70 | 2.50 | 37.00 | 62.00 | 8.00 |
| 8.240 | GE108.0250.125.42.70.R | 7.00 | 2.50 | 1.25 | 3.95 | 6.70 | 2.50 | 42.00 | 67.00 | 8.00 |
| 8.250 | GE108.0250.125.47.70.R | 7.00 | 2.50 | 1.25 | 3.95 | 6.70 | 2.50 | 47.00 | 72.00 | 8.00 |
| 8.310 | GE108.0300.150.17.70.R | 7.00 | 3.00 | 1.50 | 3.95 | 6.70 | 2.50 | 17.00 | 42.00 | 8.00 |
| 8.320 | GE108.0300.150.27.70.R | 7.00 | 3.00 | 1.50 | 3.95 | 6.70 | 2.50 | 27.00 | 52.00 | 8.00 |
| 8.330 | GE108.0300.150.37.70.R | 7.00 | 3.00 | 1.50 | 3.95 | 6.70 | 2.50 | 37.00 | 62.00 | 8.00 |
| 8.340 | GE108.0300.150.42.70.R | 7.00 | 3.00 | 1.50 | 3.95 | 6.70 | 2.50 | 42.00 | 67.00 | 8.00 |
| 8.350 | GE108.0300.150.47.70.R | 7.00 | 3.00 | 1.50 | 3.95 | 6.70 | 2.50 | 47.00 | 72.00 | 8.00 |

| | | |
|-------------------|--------------|--------------|
| Article no. | 27129 | 27131 |
| Cutting direction | | |

| Code no. | Description | D min | b | R | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm | mm |
| 8.010 | GE108.0150.075.17.70.L | 7.00 | 1.50 | 0.75 | 3.95 | 6.70 | 2.50 | 17.00 | 42.00 | 8.00 |
| 8.020 | GE108.0150.075.27.70.L | 7.00 | 1.50 | 0.75 | 3.95 | 6.70 | 2.50 | 27.00 | 52.00 | 8.00 |
| 8.030 | GE108.0150.075.37.70.L | 7.00 | 1.50 | 0.75 | 3.95 | 6.70 | 2.50 | 37.00 | 62.00 | 8.00 |
| 8.040 | GE108.0150.075.42.70.L | 7.00 | 1.50 | 0.75 | 3.95 | 6.70 | 2.50 | 42.00 | 67.00 | 8.00 |
| 8.050 | GE108.0150.075.47.70.L | 7.00 | 1.50 | 0.75 | 3.95 | 6.70 | 2.50 | 47.00 | 72.00 | 8.00 |
| 8.110 | GE108.0200.100.17.70.L | 7.00 | 2.00 | 1.00 | 3.95 | 6.70 | 2.50 | 17.00 | 42.00 | 8.00 |

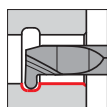
Article no. **27129** **27131**Cutting direction  

| Code no. | Description | D min | b | R | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm | mm |
| 8.120 | GE108.0200.100.27.70.L | 7.00 | 2.00 | 1.00 | 3.95 | 6.70 | 2.50 | 27.00 | 52.00 | 8.00 |
| 8.130 | GE108.0200.100.37.70.L | 7.00 | 2.00 | 1.00 | 3.95 | 6.70 | 2.50 | 37.00 | 62.00 | 8.00 |
| 8.140 | GE108.0200.100.42.70.L | 7.00 | 2.00 | 1.00 | 3.95 | 6.70 | 2.50 | 42.00 | 67.00 | 8.00 |
| 8.150 | GE108.0200.100.47.70.L | 7.00 | 2.00 | 1.00 | 3.95 | 6.70 | 2.50 | 47.00 | 72.00 | 8.00 |
| 8.210 | GE108.0250.125.17.70.L | 7.00 | 2.50 | 1.25 | 3.95 | 6.70 | 2.50 | 17.00 | 42.00 | 8.00 |
| 8.220 | GE108.0250.125.27.70.L | 7.00 | 2.50 | 1.25 | 3.95 | 6.70 | 2.50 | 27.00 | 52.00 | 8.00 |
| 8.230 | GE108.0250.125.37.70.L | 7.00 | 2.50 | 1.25 | 3.95 | 6.70 | 2.50 | 37.00 | 62.00 | 8.00 |
| 8.240 | GE108.0250.125.42.70.L | 7.00 | 2.50 | 1.25 | 3.95 | 6.70 | 2.50 | 42.00 | 67.00 | 8.00 |
| 8.250 | GE108.0250.125.47.70.L | 7.00 | 2.50 | 1.25 | 3.95 | 6.70 | 2.50 | 47.00 | 72.00 | 8.00 |
| 8.310 | GE108.0300.150.17.70.L | 7.00 | 3.00 | 1.50 | 3.95 | 6.70 | 2.50 | 17.00 | 42.00 | 8.00 |
| 8.320 | GE108.0300.150.27.70.L | 7.00 | 3.00 | 1.50 | 3.95 | 6.70 | 2.50 | 27.00 | 52.00 | 8.00 |
| 8.330 | GE108.0300.150.37.70.L | 7.00 | 3.00 | 1.50 | 3.95 | 6.70 | 2.50 | 37.00 | 62.00 | 8.00 |
| 8.340 | GE108.0300.150.42.70.L | 7.00 | 3.00 | 1.50 | 3.95 | 6.70 | 2.50 | 42.00 | 67.00 | 8.00 |
| 8.350 | GE108.0300.150.47.70.L | 7.00 | 3.00 | 1.50 | 3.95 | 6.70 | 2.50 | 47.00 | 72.00 | 8.00 |

System 108



Cutting insert for internal grooving, full radius slots



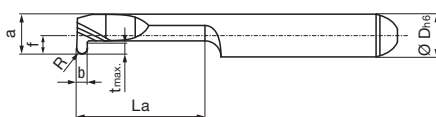
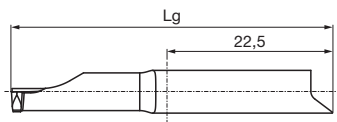
• full radius R0.75-R1.5

for tool holders type GH108/GB108 see from page 124

GUHRING NAVIGATOR

Cutting data page 184

| | | |
|---------------|---------------|--------|
| Tool material | Solid carbide | |
| Type | GE 108 | GE 108 |
| Surface | | |
| | TiAlN-nanoA | bright |





Right hand version shown
Left hand version mirror image

| | | |
|-------------------|--------------|--------------|
| Article no. | 27228 | 27230 |
| Cutting direction | | |

| Code no. | Description | D min | b | R | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm | mm |
| 8.010 | GE108.0150.075.17.80.R | 8.00 | 1.50 | 0.75 | 3.70 | 7.70 | 3.00 | 17.00 | 42.00 | 8.00 |
| 8.020 | GE108.0150.075.27.80.R | 8.00 | 1.50 | 0.75 | 3.70 | 7.70 | 3.00 | 27.00 | 52.00 | 8.00 |
| 8.030 | GE108.0150.075.37.80.R | 8.00 | 1.50 | 0.75 | 3.70 | 7.70 | 3.00 | 37.00 | 62.00 | 8.00 |
| 8.040 | GE108.0150.075.42.80.R | 8.00 | 1.50 | 0.75 | 3.70 | 7.70 | 3.00 | 42.00 | 67.00 | 8.00 |
| 8.050 | GE108.0150.075.47.80.R | 8.00 | 1.50 | 0.75 | 3.70 | 7.70 | 3.00 | 47.00 | 72.00 | 8.00 |
| 8.110 | GE108.0200.100.17.80.R | 8.00 | 2.00 | 1.00 | 3.70 | 7.70 | 3.00 | 17.00 | 42.00 | 8.00 |
| 8.120 | GE108.0200.100.27.80.R | 8.00 | 2.00 | 1.00 | 3.70 | 7.70 | 3.00 | 27.00 | 52.00 | 8.00 |
| 8.130 | GE108.0200.100.37.80.R | 8.00 | 2.00 | 1.00 | 3.70 | 7.70 | 3.00 | 37.00 | 62.00 | 8.00 |
| 8.140 | GE108.0200.100.42.80.R | 8.00 | 2.00 | 1.00 | 3.70 | 7.70 | 3.00 | 42.00 | 67.00 | 8.00 |
| 8.150 | GE108.0200.100.47.80.R | 8.00 | 2.00 | 1.00 | 3.70 | 7.70 | 3.00 | 47.00 | 72.00 | 8.00 |
| 8.210 | GE108.0250.125.17.80.R | 8.00 | 2.50 | 1.25 | 3.70 | 7.70 | 3.00 | 17.00 | 42.00 | 8.00 |
| 8.220 | GE108.0250.125.27.80.R | 8.00 | 2.50 | 1.25 | 3.70 | 7.70 | 3.00 | 27.00 | 52.00 | 8.00 |
| 8.230 | GE108.0250.125.37.80.R | 8.00 | 2.50 | 1.25 | 3.70 | 7.70 | 3.00 | 37.00 | 62.00 | 8.00 |
| 8.240 | GE108.0250.125.42.80.R | 8.00 | 2.50 | 1.25 | 3.70 | 7.70 | 3.00 | 42.00 | 67.00 | 8.00 |
| 8.250 | GE108.0250.125.47.80.R | 8.00 | 2.50 | 1.25 | 3.70 | 7.70 | 3.00 | 47.00 | 72.00 | 8.00 |
| 8.310 | GE108.0300.150.17.80.R | 8.00 | 3.00 | 1.50 | 3.70 | 7.70 | 3.00 | 17.00 | 42.00 | 8.00 |
| 8.320 | GE108.0300.150.27.80.R | 8.00 | 3.00 | 1.50 | 3.70 | 7.70 | 3.00 | 27.00 | 52.00 | 8.00 |
| 8.330 | GE108.0300.150.37.80.R | 8.00 | 3.00 | 1.50 | 3.70 | 7.70 | 3.00 | 37.00 | 62.00 | 8.00 |
| 8.340 | GE108.0300.150.42.80.R | 8.00 | 3.00 | 1.50 | 3.70 | 7.70 | 3.00 | 42.00 | 67.00 | 8.00 |
| 8.350 | GE108.0300.150.47.70.R | 8.00 | 3.00 | 1.50 | 3.70 | 7.70 | 3.00 | 47.00 | 72.00 | 8.00 |

| | | |
|-------------------|--------------|--------------|
| Article no. | 27229 | 27231 |
| Cutting direction | | |

| Code no. | Description | D min | b | R | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm | mm |
| 8.010 | GE108.0150.075.17.80.L | 8.00 | 1.50 | 0.75 | 3.70 | 7.70 | 3.00 | 17.00 | 42.00 | 8.00 |
| 8.020 | GE108.0150.075.27.80.L | 8.00 | 1.50 | 0.75 | 3.70 | 7.70 | 3.00 | 27.00 | 52.00 | 8.00 |
| 8.030 | GE108.0150.075.37.80.L | 8.00 | 1.50 | 0.75 | 3.70 | 7.70 | 3.00 | 37.00 | 62.00 | 8.00 |
| 8.040 | GE108.0150.075.42.80.L | 8.00 | 1.50 | 0.75 | 3.70 | 7.70 | 3.00 | 42.00 | 67.00 | 8.00 |
| 8.050 | GE108.0150.075.47.80.L | 8.00 | 1.50 | 0.75 | 3.70 | 7.70 | 3.00 | 47.00 | 72.00 | 8.00 |
| 8.110 | GE108.0200.100.17.80.L | 8.00 | 2.00 | 1.00 | 3.70 | 7.70 | 3.00 | 17.00 | 42.00 | 8.00 |

Article no. **27229** **27231**Cutting direction  

| Code no. | Description | D min | b | R | f | a | t max | La | Lg | D h6 |
|----------|------------------------|-------|------|------|------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm | mm |
| 8.120 | GE108.0200.100.27.80.L | 8.00 | 2.00 | 1.00 | 3.70 | 7.70 | 3.00 | 27.00 | 52.00 | 8.00 |
| 8.130 | GE108.0200.100.37.80.L | 8.00 | 2.00 | 1.00 | 3.70 | 7.70 | 3.00 | 37.00 | 62.00 | 8.00 |
| 8.140 | GE108.0200.100.42.80.L | 8.00 | 2.00 | 1.00 | 3.70 | 7.70 | 3.00 | 42.00 | 67.00 | 8.00 |
| 8.150 | GE108.0200.100.47.80.L | 8.00 | 2.00 | 1.00 | 3.70 | 7.70 | 3.00 | 47.00 | 72.00 | 8.00 |
| 8.210 | GE108.0250.125.17.80.L | 8.00 | 2.50 | 1.25 | 3.70 | 7.70 | 3.00 | 17.00 | 42.00 | 8.00 |
| 8.220 | GE108.0250.125.27.80.L | 8.00 | 2.50 | 1.25 | 3.70 | 7.70 | 3.00 | 27.00 | 52.00 | 8.00 |
| 8.230 | GE108.0250.125.37.80.L | 8.00 | 2.50 | 1.25 | 3.70 | 7.70 | 3.00 | 37.00 | 62.00 | 8.00 |
| 8.240 | GE108.0250.125.42.80.L | 8.00 | 2.50 | 1.25 | 3.70 | 7.70 | 3.00 | 42.00 | 67.00 | 8.00 |
| 8.250 | GE108.0250.125.47.80.L | 8.00 | 2.50 | 1.25 | 3.70 | 7.70 | 3.00 | 47.00 | 72.00 | 8.00 |
| 8.310 | GE108.0300.150.17.80.L | 8.00 | 3.00 | 1.50 | 3.70 | 7.70 | 3.00 | 17.00 | 42.00 | 8.00 |
| 8.320 | GE108.0300.150.27.80.L | 8.00 | 3.00 | 1.50 | 3.70 | 7.70 | 3.00 | 27.00 | 52.00 | 8.00 |
| 8.330 | GE108.0300.150.37.80.L | 8.00 | 3.00 | 1.50 | 3.70 | 7.70 | 3.00 | 37.00 | 62.00 | 8.00 |
| 8.340 | GE108.0300.150.42.80.L | 8.00 | 3.00 | 1.50 | 3.70 | 7.70 | 3.00 | 42.00 | 67.00 | 8.00 |
| 8.350 | GE108.0300.150.47.70.L | 8.00 | 3.00 | 1.50 | 3.70 | 7.70 | 3.00 | 47.00 | 72.00 | 8.00 |

System 108

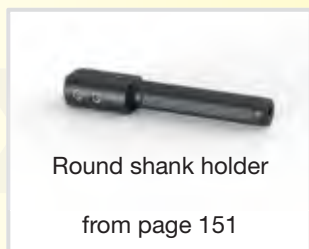
110





SYSTEM 110

MICRO-PRECISION TOOLS



Tool holder

System 110

110

SPECIAL SOLUTIONS

When designing custom-made special tools, Guhring can tap into decades of experience and its substantial tool expertise in advising customers.

The 110 tool system offers a stable special solution in such cases. We keep blanks with a shank diameter of 10 mm up to a total length of 112 mm available at the factory in order to be able to offer the best possible solution for most difficult applications. We are happy to inspect the design of even longer tools for you.

The shank diameter of 10 mm offers great stability in challenging cases. Whether long overhangs, large recessing widths or large machining depths for recesses, the 110 tool system offers a myriad of options.

The 110 tool system is being launched on the market with a standard range of round shaft holders.

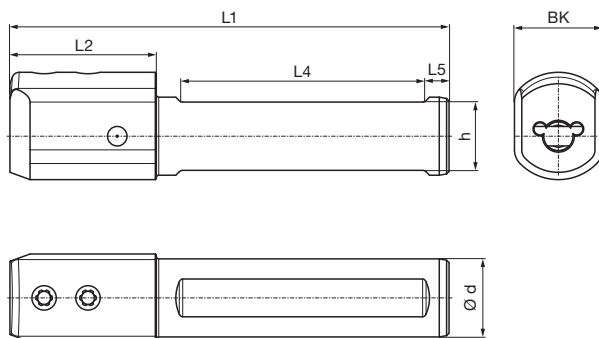




Round shank holder, clamping screw top

- for inserts type 110
- with internal coolant supply

Type GB 110



Article no. 27050

System 110

| Code no. | Description | d | h | L1 | L2 | L4 | L5 | BK |
|----------|---------------------------|-------|-------|--------|-------|-------|------|------|
| | | mm | mm | mm | mm | mm | mm | mm |
| 10.001 | GB110.0010.090.00.22.N.IK | 10.00 | 9.00 | 90.00 | 30.00 | 50.00 | 5.00 | 20.0 |
| 10.002 | GB110.0012.090.00.22.N.IK | 12.00 | 11.00 | 90.00 | 30.00 | 50.00 | 5.00 | 20.0 |
| 10.015 | GB110.0500.354.00.22.N.IK | 12.70 | 11.00 | 89.92 | 26.67 | 54.86 | 5.00 | 20.0 |
| 10.016 | GB110.0625.354.00.22.N.IK | 15.87 | 14.00 | 89.92 | 26.67 | 54.86 | 5.00 | 20.0 |
| 10.003 | GB110.0016.090.00.22.N.IK | 16.00 | 14.00 | 90.00 | 30.00 | 50.00 | 5.00 | 20.0 |
| 10.017 | GB110.0750.415.00.22.N.IK | 19.05 | 17.00 | 105.41 | 26.67 | 69.85 | 5.00 | 20.5 |
| 10.004 | GB110.0020.095.00.22.N.IK | 20.00 | 18.00 | 95.00 | 30.00 | 55.00 | 5.00 | 20.5 |
| 10.005 | GB110.0022.095.00.22.N.IK | 22.00 | 20.00 | 95.00 | 30.00 | 55.00 | 5.00 | |
| 10.006 | GB110.0025.100.00.22.N.IK | 25.00 | 23.00 | 100.00 | | 55.00 | 5.00 | |
| 10.018 | GB110.1000.415.00.22.N.IK | 25.40 | 23.40 | 105.41 | | 69.85 | 5.00 | |

Spare parts

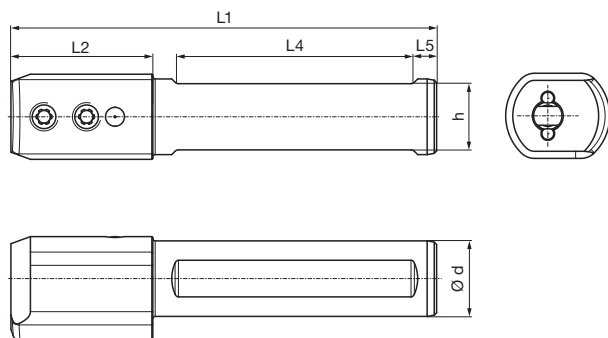
| Article no. | Clamping screw | Tightening torque |
|-------------|----------------|-------------------|
| 25900 | | Nm |
| Code 6.000 | M6x7.5x15IP | 4-4.5 |

| Article no. | Torx-Plus Wrench |
|-------------|------------------|
| 25904 | |
| Code 15.000 | T15IP T-handle |

Round shank holder, clamping screw lateral

- for inserts type 110
- with internal coolant supply

Type GB 110



Article no. 27051

| Code no. | Description | d | h | L1 | L2 | L4 | L5 |
|----------|-----------------------------|-------|-------|--------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm |
| 10.001 | GB110.0010.090.00.22.N.IK90 | 10.00 | 9.00 | 90.00 | 30.00 | 50.00 | 5.00 |
| 10.002 | GB110.0012.090.00.22.N.IK90 | 12.00 | 11.00 | 90.00 | 30.00 | 50.00 | 5.00 |
| 10.015 | GB110.0500.354.00.22.N.IK90 | 12.70 | 11.00 | 89.92 | 26.67 | 54.86 | 5.00 |
| 10.016 | GB110.0625.354.00.22.N.IK90 | 15.87 | 14.00 | 89.92 | 26.67 | 54.86 | 5.00 |
| 10.003 | GB110.0016.090.00.22.N.IK90 | 16.00 | 14.00 | 90.00 | 30.00 | 50.00 | 5.00 |
| 10.017 | GB110.0750.415.00.22.N.IK90 | 19.05 | 17.00 | 105.41 | 26.67 | 69.85 | 5.00 |
| 10.004 | GB110.0020.095.00.22.N.IK90 | 20.00 | 18.00 | 95.00 | 30.00 | 55.00 | 5.00 |
| 10.005 | GB110.0022.095.00.22.N.IK90 | 22.00 | 20.00 | 95.00 | 30.00 | 55.00 | 5.00 |
| 10.006 | GB110.0025.100.00.22.N.IK90 | 25.00 | 23.00 | 100.00 | | 55.00 | 5.00 |
| 10.018 | GB110.1000.415.00.22.N.IK90 | 25.40 | 23.40 | 105.41 | | 69.85 | 5.00 |

Spare parts

| Article no. | Clamping screw | Tightening torque |
|-------------|----------------|-------------------|
| 25900 | | Nm |
| Code 6.000 | M6x7.5x15IP | 4-4.5 |

| Article no. | Torx-Plus Wrench |
|-------------|------------------|
| 25904 | |
| Code 15.000 | T15IP T-handle |

MICRO-PRECISION TOOLS

Guhring's micro-precision tools range from micro-precision drills with a radius of 0.05 mm to special solutions in larger sizes and from HSS to solid carbide. The micro-precision tool range comprises 75 types in over 2,400 sizes and therefore offers stocked tool solutions for a variety of applications. Specially adapted geometries, substrates and surfaces guarantee optimum performance and processing safety for drilling, milling, reaming and threading in micro applications.



305



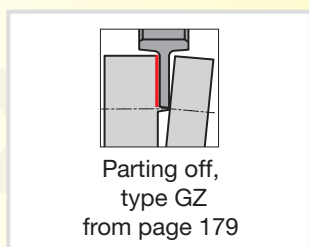
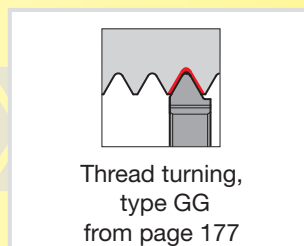
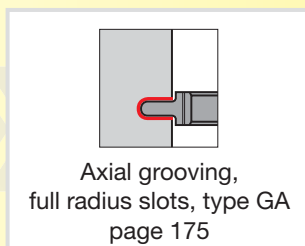
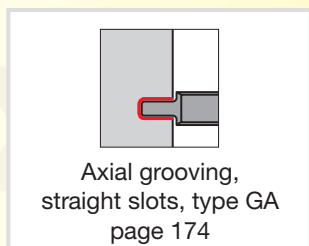
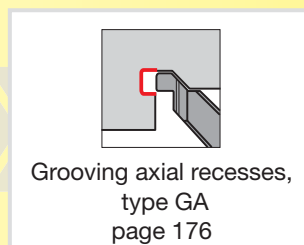
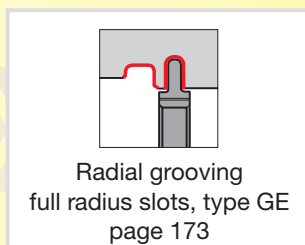
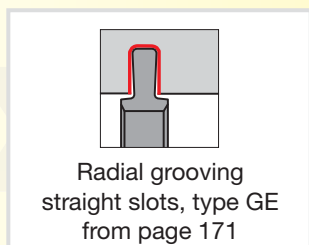


SYSTEM 305

GROOVING AND PARTING OFF



Tool holder



Indexable inserts

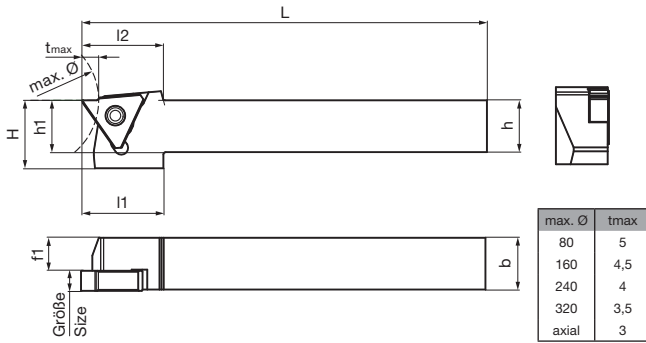
System 305

Square shank holder straight, external machining, without IC

- grooving depth up to 5 mm
- without internal coolant supply

Type GH 305

for indexable inserts type 305 see from page 171



Right hand version shown
Left hand version mirror image

Article no. **25350**

version right-hand

System 305

| Code no. | Description | t max | h | b | L | h1 | H | l1 | l2 | f1 | Size |
|----------|------------------------|-------|-------|-------|--------|-------|-------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm | mm | |
| 12.013 | GH305.1010.125.00.04.R | 5.00 | 10.00 | 10.00 | 125.00 | 10.00 | 20.00 | 24.00 | 25.00 | 8.20 | 04 |
| 12.014 | GH305.1212.125.00.04.R | 5.00 | 12.00 | 12.00 | 125.00 | 12.00 | 20.00 | 24.00 | 25.00 | 8.20 | 04 |
| 12.021 | GH305.0625.500.00.04.R | 5.00 | 15.87 | 15.87 | 127.00 | 15.87 | 20.87 | 25.40 | 25.40 | 12.07 | 04 |
| 12.001 | GH305.1616.125.00.04.R | 5.00 | 16.00 | 16.00 | 125.00 | 16.00 | 21.00 | 25.00 | 25.00 | 12.20 | 04 |
| 12.022 | GH305.0750.500.00.04.R | 5.00 | 19.05 | 19.05 | 127.00 | 19.05 | 24.05 | 25.40 | 25.40 | 15.25 | 04 |
| 12.002 | GH305.2020.125.00.04.R | 5.00 | 20.00 | 20.00 | 125.00 | 20.00 | 25.00 | 25.00 | 25.00 | 16.20 | 04 |
| 12.003 | GH305.2525.150.00.04.R | 5.00 | 25.00 | 25.00 | 150.00 | 25.00 | 30.00 | 25.00 | 25.00 | 21.20 | 04 |
| 12.023 | GH305.1000.600.00.04.R | 5.00 | 25.40 | 25.40 | 152.40 | 25.40 | 30.40 | 25.40 | 25.40 | 21.60 | 04 |
| 12.015 | GH305.1010.125.00.06.R | 5.00 | 10.00 | 10.00 | 125.00 | 10.00 | 20.00 | 24.00 | 25.00 | 8.20 | 06 |
| 12.016 | GH305.1212.125.00.06.R | 5.00 | 12.00 | 12.00 | 125.00 | 12.00 | 20.00 | 24.00 | 25.00 | 8.20 | 06 |
| 12.024 | GH305.0625.500.00.06.R | 5.00 | 15.87 | 15.87 | 127.00 | 15.87 | 20.87 | 25.40 | 25.40 | 10.07 | 06 |
| 12.004 | GH305.1616.125.00.06.R | 5.00 | 16.00 | 16.00 | 125.00 | 16.00 | 21.00 | 25.00 | 25.00 | 10.20 | 06 |
| 12.025 | GH305.0750.500.00.06.R | 5.00 | 19.05 | 19.05 | 127.00 | 19.05 | 24.05 | 25.40 | 25.40 | 13.25 | 06 |
| 12.005 | GH305.2020.125.00.06.R | 5.00 | 20.00 | 20.00 | 125.00 | 20.00 | 25.00 | 25.00 | 25.00 | 14.20 | 06 |
| 12.006 | GH305.2525.150.00.06.R | 5.00 | 25.00 | 25.00 | 150.00 | 25.00 | 30.00 | 25.00 | 25.00 | 19.20 | 06 |
| 12.026 | GH305.1000.600.00.06.R | 5.00 | 25.40 | 25.40 | 152.40 | 25.40 | 30.40 | 25.40 | 25.40 | 19.60 | 06 |
| 12.017 | GH305.1010.125.00.08.R | 5.00 | 10.00 | 10.00 | 125.00 | 10.00 | 20.00 | 24.00 | 25.00 | 8.20 | 08 |
| 12.018 | GH305.1212.125.00.08.R | 5.00 | 12.00 | 12.00 | 125.00 | 12.00 | 20.00 | 24.00 | 25.00 | 8.20 | 08 |
| 12.027 | GH305.0625.500.00.08.R | 5.00 | 15.87 | 15.87 | 127.00 | 15.87 | 20.87 | 25.40 | 25.40 | 8.07 | 08 |
| 12.007 | GH305.1616.125.00.08.R | 5.00 | 16.00 | 16.00 | 125.00 | 16.00 | 21.00 | 25.00 | 25.00 | 8.20 | 08 |
| 12.028 | GH305.0750.500.00.08.R | 5.00 | 19.05 | 19.05 | 127.00 | 19.05 | 24.05 | 25.40 | 25.40 | 11.25 | 08 |
| 12.008 | GH305.2020.125.00.08.R | 5.00 | 20.00 | 20.00 | 125.00 | 20.00 | 25.00 | 25.00 | 25.00 | 12.20 | 08 |
| 12.009 | GH305.2525.150.00.08.R | 5.00 | 25.00 | 25.00 | 150.00 | 25.00 | 30.00 | 25.00 | 25.00 | 17.20 | 08 |
| 12.029 | GH305.1000.600.00.08.R | 5.00 | 25.40 | 25.40 | 152.40 | 25.40 | 30.40 | 25.40 | 25.40 | 17.60 | 08 |
| 12.019 | GH305.1010.125.00.12.R | 5.00 | 10.00 | 10.00 | 125.00 | 10.00 | 20.00 | 24.00 | 25.00 | 8.20 | 12 |
| 12.020 | GH305.1212.125.00.12.R | 5.00 | 12.00 | 12.00 | 125.00 | 12.00 | 20.00 | 24.00 | 25.00 | 8.20 | 12 |
| 12.030 | GH305.0625.500.00.12.R | 5.00 | 15.87 | 15.87 | 127.00 | 15.87 | 20.87 | 24.40 | 25.40 | 8.27 | 12 |
| 12.010 | GH305.1616.125.00.12.R | 5.00 | 16.00 | 16.00 | 125.00 | 16.00 | 21.00 | 24.00 | 25.00 | 8.60 | 12 |
| 12.031 | GH305.0750.500.00.12.R | 5.00 | 19.05 | 19.05 | 127.00 | 19.05 | 24.05 | 25.40 | 25.40 | 7.25 | 12 |
| 12.011 | GH305.2020.125.00.12.R | 5.00 | 20.00 | 20.00 | 125.00 | 20.00 | 25.00 | 25.00 | 25.00 | 8.20 | 12 |
| 12.012 | GH305.2525.150.00.12.R | 5.00 | 25.00 | 25.00 | 150.00 | 25.00 | 30.00 | 25.00 | 25.00 | 13.20 | 12 |
| 12.032 | GH305.1000.600.00.12.R | 5.00 | 25.40 | 25.40 | 152.40 | 25.40 | 30.40 | 25.40 | 25.40 | 13.60 | 12 |

Article no. **25351**

version left-hand

| Code no. | Description | t max | h | b | L | h1 | H | l1 | l2 | f1 | Size |
|----------|------------------------|-------|-------|-------|--------|-------|-------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm | mm | |
| 12.013 | GH305.1010.125.00.04.L | 5.00 | 10.00 | 10.00 | 125.00 | 10.00 | 20.00 | 24.00 | 25.00 | 8.20 | 04 |
| 12.014 | GH305.1212.125.00.04.L | 5.00 | 12.00 | 12.00 | 125.00 | 12.00 | 20.00 | 24.00 | 25.00 | 8.20 | 04 |
| 12.021 | GH305.0625.500.00.04.L | 5.00 | 15.87 | 15.87 | 127.00 | 15.87 | 20.87 | 25.40 | 25.40 | 12.07 | 04 |
| 12.001 | GH305.1616.125.00.04.L | 5.00 | 16.00 | 16.00 | 125.00 | 16.00 | 21.00 | 25.00 | 25.00 | 12.20 | 04 |
| 12.022 | GH305.0750.500.00.04.L | 5.00 | 19.05 | 19.05 | 127.00 | 19.05 | 24.05 | 25.40 | 25.40 | 15.25 | 04 |
| 12.002 | GH305.2020.125.00.04.L | 5.00 | 20.00 | 20.00 | 125.00 | 20.00 | 25.00 | 25.00 | 25.00 | 16.20 | 04 |
| 12.003 | GH305.2525.150.00.04.L | 5.00 | 25.00 | 25.00 | 150.00 | 25.00 | 30.00 | 25.00 | 25.00 | 21.20 | 04 |
| 12.023 | GH305.1000.600.00.04.L | 5.00 | 25.40 | 25.40 | 152.40 | 25.40 | 30.40 | 25.40 | 25.40 | 21.60 | 04 |
| 12.015 | GH305.1010.125.00.06.L | 5.00 | 10.00 | 10.00 | 125.00 | 10.00 | 20.00 | 24.00 | 25.00 | 8.20 | 06 |
| 12.016 | GH305.1212.125.00.06.L | 5.00 | 12.00 | 12.00 | 125.00 | 12.00 | 20.00 | 24.00 | 25.00 | 8.20 | 06 |
| 12.024 | GH305.0625.500.00.06.L | 5.00 | 15.87 | 15.87 | 127.00 | 15.87 | 20.87 | 25.40 | 25.40 | 10.07 | 06 |
| 12.004 | GH305.1616.125.00.06.L | 5.00 | 16.00 | 16.00 | 125.00 | 16.00 | 21.00 | 25.00 | 25.00 | 10.20 | 06 |
| 12.025 | GH305.0750.500.00.06.L | 5.00 | 19.05 | 19.05 | 127.00 | 19.05 | 24.05 | 25.40 | 25.40 | 13.25 | 06 |
| 12.005 | GH305.2020.125.00.06.L | 5.00 | 20.00 | 20.00 | 125.00 | 20.00 | 25.00 | 25.00 | 25.00 | 14.20 | 06 |
| 12.006 | GH305.2525.150.00.06.L | 5.00 | 25.00 | 25.00 | 150.00 | 25.00 | 30.00 | 25.00 | 25.00 | 19.20 | 06 |
| 12.026 | GH305.1000.600.00.06.L | 5.00 | 25.40 | 25.40 | 152.40 | 25.40 | 30.40 | 25.40 | 25.40 | 19.60 | 06 |
| 12.017 | GH305.1010.125.00.08.L | 5.00 | 10.00 | 10.00 | 125.00 | 10.00 | 20.00 | 24.00 | 25.00 | 8.20 | 08 |
| 12.018 | GH305.1212.125.00.08.L | 5.00 | 12.00 | 12.00 | 125.00 | 12.00 | 20.00 | 24.00 | 25.00 | 8.20 | 08 |
| 12.027 | GH305.0625.500.00.08.L | 5.00 | 15.87 | 15.87 | 127.00 | 15.87 | 20.87 | 25.40 | 25.40 | 8.07 | 08 |
| 12.007 | GH305.1616.125.00.08.L | 5.00 | 16.00 | 16.00 | 125.00 | 16.00 | 21.00 | 25.00 | 25.00 | 8.20 | 08 |
| 12.028 | GH305.0750.500.00.08.L | 5.00 | 19.05 | 19.05 | 127.00 | 19.05 | 24.05 | 25.40 | 25.40 | 11.25 | 08 |
| 12.008 | GH305.2020.125.00.08.L | 5.00 | 20.00 | 20.00 | 125.00 | 20.00 | 25.00 | 25.00 | 25.00 | 12.20 | 08 |
| 12.009 | GH305.2525.150.00.08.L | 5.00 | 25.00 | 25.00 | 150.00 | 25.00 | 30.00 | 25.00 | 25.00 | 17.20 | 08 |
| 12.029 | GH305.1000.600.00.08.L | 5.00 | 25.40 | 25.40 | 152.40 | 25.40 | 30.40 | 25.40 | 25.40 | 17.60 | 08 |
| 12.019 | GH305.1010.125.00.12.L | 5.00 | 10.00 | 10.00 | 125.00 | 10.00 | 20.00 | 24.00 | 25.00 | 8.20 | 12 |
| 12.020 | GH305.1212.125.00.12.L | 5.00 | 12.00 | 12.00 | 125.00 | 12.00 | 20.00 | 24.00 | 25.00 | 8.20 | 12 |
| 12.030 | GH305.0625.500.00.12.L | 5.00 | 15.87 | 15.87 | 127.00 | 15.87 | 20.87 | 24.40 | 25.40 | 8.27 | 12 |
| 12.010 | GH305.1616.125.00.12.L | 5.00 | 16.00 | 16.00 | 125.00 | 16.00 | 21.00 | 24.00 | 25.00 | 8.60 | 12 |
| 12.031 | GH305.0750.500.00.12.L | 5.00 | 19.05 | 19.05 | 127.00 | 19.05 | 24.05 | 25.40 | 25.40 | 7.25 | 12 |
| 12.011 | GH305.2020.125.00.12.L | 5.00 | 20.00 | 20.00 | 125.00 | 20.00 | 25.00 | 25.00 | 25.00 | 8.20 | 12 |
| 12.012 | GH305.2525.150.00.12.L | 5.00 | 25.00 | 25.00 | 150.00 | 25.00 | 30.00 | 25.00 | 25.00 | 13.20 | 12 |
| 12.032 | GH305.1000.600.00.12.L | 5.00 | 25.40 | 25.40 | 152.40 | 25.40 | 30.40 | 25.40 | 25.40 | 13.60 | 12 |

System 305

Spare parts

| Article no. | Clamping screw | Tightening torque | Size | Description |
|-------------|----------------|-------------------|-------|---------------------------------------|
| 25901 | | Nm | | |
| Code 4.002 | M4x11x15IP | 4-4.5 | 04-06 | GH305.1010.125....; GH305.1212.125... |
| Code 4.000 | M4x15x15IP | 4-4.5 | 04-06 | GH305.0625.500....; GH305.0750.500... |
| Code 4.000 | M4x15x15IP | 4-4.5 | 04-06 | GH305.1616.125....; GH305.1000.600... |
| Code 4.000 | M4x15x15IP | 4-4.5 | 04-06 | GH305.2020.125....; GH305.2525.150... |
| Code 4.000 | M4x15x15IP | 4-4.5 | 08 | GH305.... |
| Code 4.003 | M4x17x15IP | 4-4.5 | 12 | GH305.... |

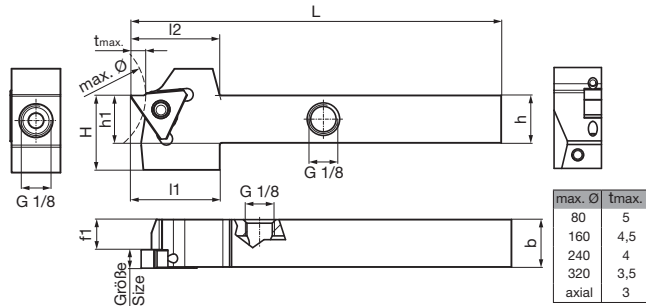
| Article no. | Torx-Plus Wrench |
|-------------|------------------|
| 25904 | |
| Code 15.000 | T15IP T-handle |

Square shank holder straight, external machining, with IC

- grooving depth up to 5 mm
- with internal coolant supply from above and below

Type GH 305

for indexable inserts type 305 see from page 171



Right hand version shown
Left hand version mirror image

Article no. **25352**
version right-hand

System 305

| Code no. | Description | t max | h | b | L | h1 | H | l1 | l2 | f1 | Size |
|----------|---------------------------|-------|-------|-------|--------|-------|-------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm | mm | |
| 12.014 | GH305.1212.125.00.04.R.IK | 5.00 | 12.00 | 12.00 | 125.00 | 12.00 | 21.00 | 30.00 | 30.00 | 8.20 | 04 |
| 12.021 | GH305.0625.500.00.04.R.IK | 5.00 | 15.87 | 15.87 | 127.00 | 15.87 | 24.87 | 30.48 | 30.48 | 12.07 | 04 |
| 12.001 | GH305.1616.125.00.04.R.IK | 5.00 | 16.00 | 16.00 | 125.00 | 16.00 | 25.00 | 30.00 | 30.00 | 12.20 | 04 |
| 12.022 | GH305.0750.500.00.04.R.IK | 5.00 | 19.05 | 19.05 | 127.00 | 19.05 | 24.05 | 30.48 | 30.48 | 15.25 | 04 |
| 12.002 | GH305.2020.125.00.04.R.IK | 5.00 | 20.00 | 20.00 | 125.00 | 20.00 | 25.00 | 30.00 | 30.00 | 16.20 | 04 |
| 12.003 | GH305.2525.150.00.04.R.IK | 5.00 | 25.00 | 25.00 | 150.00 | 25.00 | 30.00 | 30.00 | 30.00 | 21.20 | 04 |
| 12.023 | GH305.1000.600.00.04.R.IK | 5.00 | 25.40 | 25.40 | 152.40 | 25.40 | 30.40 | 30.48 | 30.48 | 21.60 | 04 |
| 12.016 | GH305.1212.125.00.06.R.IK | 5.00 | 12.00 | 12.00 | 125.00 | 12.00 | 21.00 | 30.00 | 30.00 | 6.20 | 06 |
| 12.024 | GH305.0625.500.00.06.R.IK | 5.00 | 15.87 | 15.87 | 127.00 | 15.87 | 24.87 | 30.48 | 30.48 | 10.07 | 06 |
| 12.004 | GH305.1616.125.00.06.R.IK | 5.00 | 16.00 | 16.00 | 125.00 | 16.00 | 25.00 | 30.00 | 30.00 | 10.20 | 06 |
| 12.025 | GH305.0750.500.00.06.R.IK | 5.00 | 19.05 | 19.05 | 127.00 | 19.05 | 24.05 | 30.48 | 30.48 | 13.25 | 06 |
| 12.005 | GH305.2020.125.00.06.R.IK | 5.00 | 20.00 | 20.00 | 125.00 | 20.00 | 25.00 | 30.00 | 30.00 | 14.20 | 06 |
| 12.006 | GH305.2525.150.00.06.R.IK | 5.00 | 25.00 | 25.00 | 150.00 | 25.00 | 30.00 | 30.00 | 30.00 | 19.20 | 06 |
| 12.026 | GH305.1000.600.00.06.R.IK | 5.00 | 25.40 | 25.40 | 152.40 | 25.40 | 30.40 | 30.48 | 30.48 | 19.60 | 06 |
| 12.018 | GH305.1212.125.00.08.R.IK | 5.00 | 12.00 | 12.00 | 125.00 | 12.00 | 21.00 | 30.00 | 30.00 | 4.20 | 08 |
| 12.027 | GH305.0625.500.00.08.R.IK | 5.00 | 15.87 | 15.87 | 127.00 | 15.87 | 24.87 | 30.48 | 30.48 | 8.07 | 08 |
| 12.007 | GH305.1616.125.00.08.R.IK | 5.00 | 16.00 | 16.00 | 125.00 | 16.00 | 25.00 | 30.00 | 30.00 | 8.20 | 08 |
| 12.028 | GH305.0750.500.00.08.R.IK | 5.00 | 19.05 | 19.05 | 127.00 | 19.05 | 24.05 | 30.48 | 30.48 | 11.25 | 08 |
| 12.008 | GH305.2020.125.00.08.R.IK | 5.00 | 20.00 | 20.00 | 125.00 | 20.00 | 25.00 | 30.00 | 30.00 | 12.20 | 08 |
| 12.009 | GH305.2525.150.00.08.R.IK | 5.00 | 25.00 | 25.00 | 150.00 | 25.00 | 30.00 | 30.00 | 30.00 | 17.20 | 08 |
| 12.029 | GH305.1000.600.00.08.R.IK | 5.00 | 25.40 | 25.40 | 152.40 | 25.40 | 30.40 | 30.48 | 30.48 | 17.60 | 08 |
| 12.020 | GH305.1212.125.00.12.R.IK | 5.00 | 12.00 | 12.00 | 125.00 | 12.00 | 25.00 | 30.00 | 30.00 | 0.20 | 12 |
| 12.030 | GH305.0625.500.00.12.R.IK | 5.00 | 15.87 | 15.87 | 127.00 | 15.87 | 24.87 | 30.48 | 30.48 | 4.07 | 12 |
| 12.010 | GH305.1616.125.00.12.R.IK | 5.00 | 16.00 | 16.00 | 125.00 | 16.00 | 25.00 | 30.00 | 30.00 | 4.20 | 12 |
| 12.031 | GH305.0750.500.00.12.R.IK | 5.00 | 19.05 | 19.05 | 127.00 | 19.05 | 24.05 | 30.48 | 30.48 | 7.25 | 12 |
| 12.011 | GH305.2020.125.00.12.R.IK | 5.00 | 20.00 | 20.00 | 125.00 | 20.00 | 25.00 | 30.00 | 30.00 | 8.20 | 12 |
| 12.012 | GH305.2525.150.00.12.R.IK | 5.00 | 25.00 | 25.00 | 150.00 | 25.00 | 30.00 | 30.00 | 30.00 | 13.20 | 12 |
| 12.032 | GH305.1000.600.00.12.R.IK | 5.00 | 25.40 | 25.40 | 152.40 | 25.40 | 30.40 | 30.48 | 30.48 | 13.60 | 12 |

Article no. **25353**

version left-hand

| Code no. | Description | t max | h | b | L | h1 | H | l1 | l2 | f1 | Size |
|----------|---------------------------|-------|-------|-------|--------|-------|-------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm | mm | |
| 12.014 | GH305.1212.125.00.04.L.IK | 5.00 | 12.00 | 12.00 | 125.00 | 12.00 | 21.00 | 30.00 | 30.00 | 8.20 | 04 |
| 12.021 | GH305.0625.500.00.04.L.IK | 5.00 | 15.87 | 15.87 | 127.00 | 15.87 | 24.87 | 30.48 | 30.48 | 12.07 | 04 |
| 12.001 | GH305.1616.125.00.04.L.IK | 5.00 | 16.00 | 16.00 | 125.00 | 16.00 | 25.00 | 30.00 | 30.00 | 12.20 | 04 |
| 12.022 | GH305.0750.500.00.04.L.IK | 5.00 | 19.05 | 19.05 | 127.00 | 19.05 | 24.05 | 30.48 | 30.48 | 15.25 | 04 |
| 12.002 | GH305.2020.125.00.04.L.IK | 5.00 | 20.00 | 20.00 | 125.00 | 20.00 | 25.00 | 30.00 | 30.00 | 16.20 | 04 |
| 12.003 | GH305.2525.150.00.04.L.IK | 5.00 | 25.00 | 25.00 | 150.00 | 25.00 | 30.00 | 30.00 | 30.00 | 21.20 | 04 |
| 12.023 | GH305.1000.600.00.04.L.IK | 5.00 | 25.40 | 25.40 | 152.40 | 25.40 | 30.40 | 30.48 | 30.48 | 21.60 | 04 |
| 12.016 | GH305.1212.125.00.06.L.IK | 5.00 | 12.00 | 12.00 | 125.00 | 12.00 | 21.00 | 30.00 | 30.00 | 6.20 | 06 |
| 12.024 | GH305.0625.500.00.06.L.IK | 5.00 | 15.87 | 15.87 | 127.00 | 15.87 | 24.87 | 30.48 | 30.48 | 10.07 | 06 |
| 12.004 | GH305.1616.125.00.04.L.IK | 5.00 | 16.00 | 16.00 | 125.00 | 16.00 | 25.00 | 30.00 | 30.00 | 10.20 | 06 |
| 12.025 | GH305.0750.500.00.06.L.IK | 5.00 | 19.05 | 19.05 | 127.00 | 19.05 | 24.05 | 30.48 | 30.48 | 13.25 | 06 |
| 12.005 | GH305.2020.125.00.06.L.IK | 5.00 | 20.00 | 20.00 | 125.00 | 20.00 | 25.00 | 30.00 | 30.00 | 14.20 | 06 |
| 12.006 | GH305.2525.150.00.06.L.IK | 5.00 | 25.00 | 25.00 | 150.00 | 25.00 | 30.00 | 30.00 | 30.00 | 19.20 | 06 |
| 12.026 | GH305.1000.600.00.06.L.IK | 5.00 | 25.40 | 25.40 | 152.40 | 25.40 | 30.40 | 30.48 | 30.48 | 19.60 | 06 |
| 12.018 | GH305.1212.125.00.08.L.IK | 5.00 | 12.00 | 12.00 | 125.00 | 12.00 | 21.00 | 30.00 | 30.00 | 4.20 | 08 |
| 12.027 | GH305.0625.500.00.08.L.IK | 5.00 | 15.87 | 15.87 | 127.00 | 15.87 | 24.87 | 30.48 | 30.48 | 8.07 | 08 |
| 12.007 | GH305.1616.125.00.08.L.IK | 5.00 | 16.00 | 16.00 | 125.00 | 16.00 | 25.00 | 30.00 | 30.00 | 8.20 | 08 |
| 12.028 | GH305.0750.500.00.08.L.IK | 5.00 | 19.05 | 19.05 | 127.00 | 19.05 | 24.05 | 30.48 | 30.48 | 11.25 | 08 |
| 12.008 | GH305.2020.125.00.08.L.IK | 5.00 | 20.00 | 20.00 | 125.00 | 20.00 | 25.00 | 30.00 | 30.00 | 12.20 | 08 |
| 12.009 | GH305.2525.150.00.08.L.IK | 5.00 | 25.00 | 25.00 | 150.00 | 25.00 | 30.00 | 30.00 | 30.00 | 17.20 | 08 |
| 12.029 | GH305.1000.600.00.08.L.IK | 5.00 | 25.40 | 25.40 | 152.40 | 25.40 | 30.40 | 30.48 | 30.48 | 17.60 | 08 |
| 12.020 | GH305.1212.125.00.12.L.IK | 5.00 | 12.00 | 12.00 | 125.00 | 12.00 | 25.00 | 30.00 | 30.00 | 0.20 | 12 |
| 12.030 | GH305.0625.500.00.12.L.IK | 5.00 | 15.87 | 15.87 | 127.00 | 15.87 | 24.87 | 30.48 | 30.48 | 4.07 | 12 |
| 12.010 | GH305.1616.125.00.12.L.IK | 5.00 | 16.00 | 16.00 | 125.00 | 16.00 | 25.00 | 30.00 | 30.00 | 4.20 | 12 |
| 12.031 | GH305.0750.500.00.12.L.IK | 5.00 | 19.05 | 19.05 | 127.00 | 19.05 | 24.05 | 30.48 | 30.48 | 7.25 | 12 |
| 12.011 | GH305.2020.125.00.12.L.IK | 5.00 | 20.00 | 20.00 | 125.00 | 20.00 | 25.00 | 30.00 | 30.00 | 8.20 | 12 |
| 12.012 | GH305.2525.150.00.12.L.IK | 5.00 | 25.00 | 25.00 | 150.00 | 25.00 | 30.00 | 30.00 | 30.00 | 13.20 | 12 |
| 12.032 | GH305.1000.600.00.12.L.IK | 5.00 | 25.40 | 25.40 | 152.40 | 25.40 | 30.40 | 30.48 | 30.48 | 13.60 | 12 |

System 305

Spare parts

| Article no. | Clamping screw | Tightening torque | Size | Description |
|-------------|----------------|-------------------|-------|---------------------------------------|
| 25901 | | Nm | | |
| Code 4.002 | M4x11x15IP | 4-4.5 | 04-06 | GH305.1010.125....; GH305.1212.125... |
| Code 4.000 | M4x15x15IP | 4-4.5 | 04-06 | GH305.0625.500....; GH305.0750.500... |
| Code 4.000 | M4x15x15IP | 4-4.5 | 04-06 | GH305.1616.125....; GH305.1000.600... |
| Code 4.000 | M4x15x15IP | 4-4.5 | 04-06 | GH305.2020.125....; GH305.2525.150... |
| Code 4.000 | M4x15x15IP | 4-4.5 | 08 | GH305.... |
| Code 4.003 | M4x17x15IP | 4-4.5 | 12 | GH305.... |

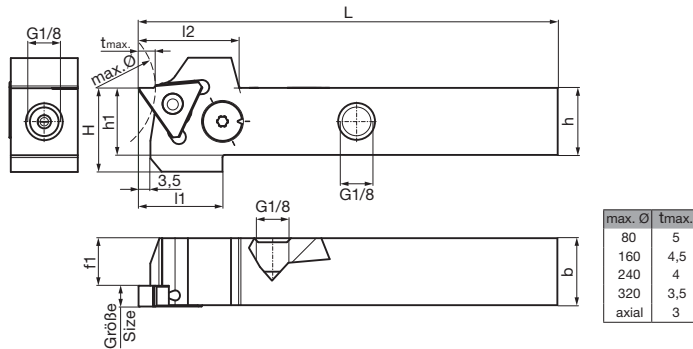
| | |
|-------------|------------------|
| Article no. | Torx-Plus Wrench |
| 25904 | |
| Code 15.000 | T15IP T-handle |

Square shank holder straight, external machining, IC adjustable

- grooving depth up to 5 mm
- with internal coolant supply

Type GH 305

for indexable inserts type 305 see from page 171



Right hand version shown
Left hand version mirror image

Article no. **25372**

version right-hand

| Code no. | Description | t max | h | b | L | h1 | H | l1 | l2 | f1 | Size |
|----------|-------------------------------|-------|-------|-------|--------|-------|-------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm | mm | |
| 12.002 | GH305.2020.125.00.04.R.IK.EST | 5.00 | 20.00 | 20.00 | 125.00 | 20.00 | 25.00 | 30.00 | 30.00 | 16.20 | 04 |
| 12.003 | GH305.2525.150.00.04.R.IK.EST | 5.00 | 25.00 | 25.00 | 150.00 | 25.00 | 30.00 | 30.00 | 30.00 | 21.20 | 04 |
| 12.005 | GH305.2020.125.00.06.R.IK.EST | 5.00 | 20.00 | 20.00 | 125.00 | 20.00 | 25.00 | 30.00 | 30.00 | 14.20 | 06 |
| 12.006 | GH305.2525.150.00.06.R.IK.EST | 5.00 | 25.00 | 25.00 | 150.00 | 25.00 | 30.00 | 30.00 | 30.00 | 19.20 | 06 |

Article no. **25373**

version left-hand

| Code no. | Description | t max | h | b | L | h1 | H | l1 | l2 | f1 | Size |
|----------|-------------------------------|-------|-------|-------|--------|-------|-------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm | mm | |
| 12.002 | GH305.2020.125.00.04.L.IK.EST | 5.00 | 20.00 | 20.00 | 125.00 | 20.00 | 25.00 | 30.00 | 30.00 | 16.20 | 04 |
| 12.003 | GH305.2525.150.00.04.L.IK.EST | 5.00 | 25.00 | 25.00 | 150.00 | 25.00 | 30.00 | 30.00 | 30.00 | 21.20 | 04 |
| 12.005 | GH305.2020.125.00.06.L.IK.EST | 5.00 | 20.00 | 20.00 | 125.00 | 20.00 | 25.00 | 30.00 | 30.00 | 14.20 | 06 |
| 12.006 | GH305.2525.150.00.06.L.IK.EST | 5.00 | 25.00 | 25.00 | 150.00 | 25.00 | 30.00 | 30.00 | 30.00 | 19.20 | 06 |

Spare parts

| Article no. | Clamping screw | Tightening torque | Size | Description |
|-------------|----------------|-------------------|-------|---------------------------------------|
| 25901 | | Nm | | |
| Code 4.002 | M4x11x15IP | 4-4.5 | 04-06 | GH305.1010.125....; GH305.1212.125... |
| Code 4.000 | M4x15x15IP | 4-4.5 | 04-06 | GH305.0625.500....; GH305.0750.500... |
| Code 4.000 | M4x15x15IP | 4-4.5 | 04-06 | GH305.1616.125....; GH305.1000.600... |
| Code 4.000 | M4x15x15IP | 4-4.5 | 04-06 | GH305.2020.125....; GH305.2525.150... |
| Code 4.000 | M4x15x15IP | 4-4.5 | 08 | GH305.... |
| Code 4.003 | M4x17x15IP | 4-4.5 | 12 | GH305.... |

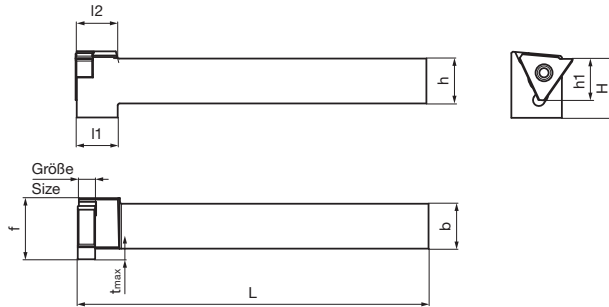
| Article no. | Torx-Plus Wrench |
|-------------|------------------|
| 25904 | |
| Code 15.000 | T15IP T-handle |


Square shank holder 90° offset, external machining, without IC

- grooving depth up to 3.5 mm
- without internal coolant supply

Type GH 305

for indexable inserts type 305 see from page 171


 Right hand version shown
 Left hand version mirror image

 Article no. **25356**
 version right-hand

| Code no. | Description | t max | h | b | L | h1 | H | l1 | l2 | f | Size |
|----------|------------------------|-------|-------|-------|--------|-------|-------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm | mm | mm |
| 12.013 | GH305.1010.125.90.04.R | 3.50 | 10.00 | 10.00 | 125.00 | 10.00 | 19.00 | 14.60 | 14.60 | 13.80 | 04 |
| 12.014 | GH305.1212.125.90.04.R | 3.50 | 12.00 | 12.00 | 125.00 | 12.00 | 21.00 | 14.60 | 14.60 | 15.80 | 04 |
| 12.021 | GH305.0625.500.90.04.R | 3.50 | 15.87 | 15.87 | 127.00 | 15.87 | 20.87 | 14.84 | 14.84 | 19.67 | 04 |
| 12.001 | GH305.1616.125.90.04.R | 3.50 | 16.00 | 16.00 | 125.00 | 16.00 | 21.00 | 14.60 | 14.60 | 19.80 | 04 |
| 12.022 | GH305.0750.500.90.04.R | 3.50 | 19.05 | 19.05 | 127.00 | 19.05 | 24.05 | 14.84 | 14.84 | 22.85 | 04 |
| 12.002 | GH305.2020.125.90.04.R | 3.50 | 20.00 | 20.00 | 125.00 | 20.00 | 25.00 | 14.60 | 14.60 | 23.80 | 04 |
| 12.003 | GH305.2525.150.90.04.R | 3.50 | 25.00 | 25.00 | 150.00 | 25.00 | 30.00 | 14.60 | 14.60 | 28.80 | 04 |
| 12.023 | GH305.1000.600.90.04.R | 3.50 | 25.40 | 25.40 | 152.40 | 25.40 | 30.40 | 14.84 | 14.84 | 29.20 | 04 |
| 12.015 | GH305.1010.125.90.06.R | 3.50 | 10.00 | 10.00 | 125.00 | 10.00 | 19.00 | 14.60 | 14.60 | 13.80 | 06 |
| 12.016 | GH305.1212.125.90.06.R | 3.50 | 12.00 | 12.00 | 125.00 | 12.00 | 21.00 | 14.60 | 14.60 | 15.80 | 06 |
| 12.024 | GH305.0625.500.90.06.R | 3.50 | 15.87 | 15.87 | 127.00 | 15.87 | 20.87 | 14.84 | 14.84 | 19.67 | 06 |
| 12.004 | GH305.1616.125.90.06.R | 3.50 | 16.00 | 16.00 | 125.00 | 16.00 | 21.00 | 14.60 | 14.60 | 19.80 | 06 |
| 12.025 | GH305.0750.500.90.06.R | 3.50 | 19.05 | 19.05 | 127.00 | 19.05 | 24.05 | 14.84 | 14.84 | 22.85 | 06 |
| 12.005 | GH305.2020.125.90.06.R | 3.50 | 20.00 | 20.00 | 125.00 | 20.00 | 25.00 | 14.60 | 14.60 | 23.80 | 06 |
| 12.006 | GH305.2525.150.90.06.R | 3.50 | 25.00 | 25.00 | 150.00 | 25.00 | 30.00 | 14.60 | 14.60 | 28.80 | 06 |
| 12.026 | GH305.1000.600.90.06.R | 3.50 | 25.40 | 25.40 | 152.40 | 25.40 | 30.40 | 14.84 | 14.84 | 29.20 | 06 |
| 12.017 | GH305.1010.125.90.08.R | 3.50 | 10.00 | 10.00 | 125.00 | 10.00 | 19.00 | 16.60 | 16.60 | 13.80 | 08 |
| 12.018 | GH305.1212.125.90.08.R | 3.50 | 12.00 | 12.00 | 125.00 | 12.00 | 21.00 | 16.60 | 16.60 | 15.80 | 08 |
| 12.027 | GH305.0625.500.90.08.R | 3.50 | 15.87 | 15.87 | 127.00 | 15.87 | 20.87 | 16.84 | 16.84 | 19.67 | 08 |
| 12.007 | GH305.1616.125.90.08.R | 3.50 | 16.00 | 16.00 | 125.00 | 16.00 | 21.00 | 16.60 | 16.60 | 19.80 | 08 |
| 12.028 | GH305.0750.500.90.08.R | 3.50 | 19.05 | 19.05 | 127.00 | 19.05 | 24.05 | 16.84 | 16.84 | 22.85 | 08 |
| 12.008 | GH305.2020.125.90.08.R | 3.50 | 20.00 | 20.00 | 125.00 | 20.00 | 25.00 | 16.60 | 16.60 | 23.80 | 08 |
| 12.009 | GH305.2525.150.90.08.R | 3.50 | 25.00 | 25.00 | 150.00 | 25.00 | 30.00 | 16.60 | 16.60 | 28.80 | 08 |
| 12.029 | GH305.1000.600.90.08.R | 3.50 | 25.40 | 25.40 | 152.40 | 25.40 | 30.40 | 16.84 | 16.84 | 29.20 | 08 |
| 12.019 | GH305.1010.125.90.12.R | 3.50 | 10.00 | 10.00 | 125.00 | 10.00 | 19.00 | 16.60 | 20.60 | 13.80 | 12 |
| 12.020 | GH305.1212.125.90.12.R | 3.50 | 12.00 | 12.00 | 125.00 | 12.00 | 21.00 | 20.60 | 20.60 | 15.80 | 12 |
| 12.030 | GH305.0625.500.90.12.R | 3.50 | 15.87 | 15.87 | 127.00 | 15.87 | 20.87 | 20.84 | 20.84 | 19.67 | 12 |
| 12.010 | GH305.1616.125.90.12.R | 3.50 | 16.00 | 16.00 | 125.00 | 16.00 | 21.00 | 20.60 | 20.60 | 19.80 | 12 |
| 12.031 | GH305.0750.500.90.12.R | 3.50 | 19.05 | 19.05 | 127.00 | 19.05 | 24.05 | 20.84 | 20.84 | 22.85 | 12 |
| 12.011 | GH305.2020.125.90.12.R | 3.50 | 20.00 | 20.00 | 125.00 | 20.00 | 25.00 | 20.60 | 20.60 | 23.80 | 12 |
| 12.012 | GH305.2525.150.90.12.R | 3.50 | 25.00 | 25.00 | 150.00 | 25.00 | 30.00 | 20.60 | 20.60 | 28.80 | 12 |
| 12.032 | GH305.1000.600.90.12.R | 3.50 | 25.40 | 25.40 | 152.40 | 25.40 | 30.40 | 20.84 | 20.84 | 29.20 | 12 |

| Code no. | Description | t max | h | b | L | h1 | H | l1 | l2 | f | Size |
|----------|------------------------|-------|-------|-------|--------|-------|-------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm | mm | |
| 12.013 | GH305.1010.125.90.04.L | 3.50 | 10.00 | 10.00 | 125.00 | 10.00 | 19.00 | 14.60 | 14.60 | 13.80 | 04 |
| 12.014 | GH305.1212.125.90.04.L | 3.50 | 12.00 | 12.00 | 125.00 | 12.00 | 21.00 | 14.60 | 14.60 | 15.80 | 04 |
| 12.021 | GH305.0625.500.90.04.L | 3.50 | 15.87 | 15.87 | 127.00 | 15.87 | 20.87 | 14.84 | 14.84 | 19.67 | 04 |
| 12.001 | GH305.1616.125.90.04.L | 3.50 | 16.00 | 16.00 | 125.00 | 16.00 | 21.00 | 14.60 | 14.60 | 19.80 | 04 |
| 12.022 | GH305.0750.500.90.04.L | 3.50 | 19.05 | 19.05 | 127.00 | 19.05 | 24.05 | 14.84 | 14.84 | 22.85 | 04 |
| 12.002 | GH305.2020.125.90.04.L | 3.50 | 20.00 | 20.00 | 125.00 | 20.00 | 25.00 | 14.60 | 14.60 | 23.80 | 04 |
| 12.003 | GH305.2525.150.90.04.L | 3.50 | 25.00 | 25.00 | 150.00 | 25.00 | 30.00 | 14.60 | 14.60 | 28.80 | 04 |
| 12.023 | GH305.1000.600.90.04.L | 3.50 | 25.40 | 25.40 | 152.40 | 25.40 | 30.40 | 14.84 | 14.84 | 29.20 | 04 |
| 12.015 | GH305.1010.125.90.06.L | 3.50 | 10.00 | 10.00 | 125.00 | 10.00 | 19.00 | 14.60 | 14.60 | 13.80 | 06 |
| 12.016 | GH305.1212.125.90.06.L | 3.50 | 12.00 | 12.00 | 125.00 | 12.00 | 21.00 | 14.60 | 14.60 | 15.80 | 06 |
| 12.024 | GH305.0625.500.90.06.L | 3.50 | 15.87 | 15.87 | 127.00 | 15.87 | 20.87 | 14.84 | 14.84 | 19.67 | 06 |
| 12.004 | GH305.1616.125.90.06.L | 3.50 | 16.00 | 16.00 | 125.00 | 16.00 | 21.00 | 14.60 | 14.60 | 19.80 | 06 |
| 12.025 | GH305.0750.500.90.06.L | 3.50 | 19.05 | 19.05 | 127.00 | 19.05 | 24.05 | 14.84 | 14.84 | 22.85 | 06 |
| 12.005 | GH305.2020.125.90.06.L | 3.50 | 20.00 | 20.00 | 125.00 | 20.00 | 25.00 | 14.60 | 14.60 | 23.80 | 06 |
| 12.006 | GH305.2525.150.90.06.L | 3.50 | 25.00 | 25.00 | 150.00 | 25.00 | 30.00 | 14.60 | 14.60 | 28.80 | 06 |
| 12.026 | GH305.1000.600.90.06.L | 3.50 | 25.40 | 25.40 | 152.40 | 25.40 | 30.40 | 14.84 | 14.84 | 29.20 | 06 |
| 12.017 | GH305.1010.125.90.08.L | 3.50 | 10.00 | 10.00 | 125.00 | 10.00 | 19.00 | 16.60 | 16.60 | 13.80 | 08 |
| 12.018 | GH305.1212.125.90.08.L | 3.50 | 12.00 | 12.00 | 125.00 | 12.00 | 21.00 | 16.60 | 16.60 | 15.80 | 08 |
| 12.027 | GH305.0625.500.90.08.L | 3.50 | 15.87 | 15.87 | 127.00 | 15.87 | 20.87 | 16.84 | 16.84 | 19.67 | 08 |
| 12.007 | GH305.1616.125.90.08.L | 3.50 | 16.00 | 16.00 | 125.00 | 16.00 | 21.00 | 16.60 | 16.60 | 19.80 | 08 |
| 12.028 | GH305.0750.500.90.08.L | 3.50 | 19.05 | 19.05 | 127.00 | 19.05 | 24.05 | 16.84 | 16.84 | 22.85 | 08 |
| 12.008 | GH305.2020.125.90.08.L | 3.50 | 20.00 | 20.00 | 125.00 | 20.00 | 25.00 | 16.60 | 16.60 | 23.80 | 08 |
| 12.009 | GH305.2525.150.90.08.L | 3.50 | 25.00 | 25.00 | 150.00 | 25.00 | 30.00 | 16.60 | 16.60 | 28.80 | 08 |
| 12.029 | GH305.1000.600.90.08.L | 3.50 | 25.40 | 25.40 | 152.40 | 25.40 | 30.40 | 16.84 | 16.84 | 29.20 | 08 |
| 12.019 | GH305.1010.125.90.12.L | 3.50 | 10.00 | 10.00 | 125.00 | 10.00 | 19.00 | 16.60 | 20.60 | 13.80 | 12 |
| 12.020 | GH305.1212.125.90.12.L | 3.50 | 12.00 | 12.00 | 125.00 | 12.00 | 21.00 | 20.60 | 20.60 | 15.80 | 12 |
| 12.030 | GH305.0625.500.90.12.L | 3.50 | 15.87 | 15.87 | 127.00 | 15.87 | 20.87 | 20.84 | 20.84 | 19.67 | 12 |
| 12.010 | GH305.1616.125.90.12.L | 3.50 | 16.00 | 16.00 | 125.00 | 16.00 | 21.00 | 20.60 | 20.60 | 19.80 | 12 |
| 12.031 | GH305.0750.500.90.12.L | 3.50 | 19.05 | 19.05 | 127.00 | 19.05 | 24.05 | 20.84 | 20.84 | 22.85 | 12 |
| 12.011 | GH305.2020.125.90.12.L | 3.50 | 20.00 | 20.00 | 125.00 | 20.00 | 25.00 | 20.60 | 20.60 | 23.80 | 12 |
| 12.012 | GH305.2525.150.90.12.L | 3.50 | 25.00 | 25.00 | 150.00 | 25.00 | 30.00 | 20.60 | 20.60 | 28.80 | 12 |
| 12.032 | GH305.1000.600.90.12.L | 3.50 | 25.40 | 25.40 | 152.40 | 25.40 | 30.40 | 20.84 | 20.84 | 29.20 | 12 |

System 305

Spare parts

| Article no. | Clamping screw | Tightening torque | Size |
|-------------|----------------|-------------------|-------|
| 25901 | | Nm | |
| Code 4.000 | M4x15x15IP | 4-4.5 | 04-08 |
| Code 4.003 | M4x17x15IP | 4-4.5 | 12 |

| Article no. | Torx-Plus Wrench |
|-------------|------------------|
| 25904 | |
| Code 15.000 | T15IP T-handle |

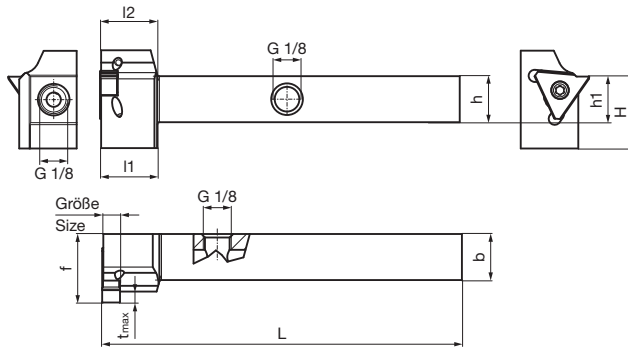


Square shank holder 90° offset, external machining, with IC

- grooving depth up to 3.5 mm
- with internal coolant supply from above and below

Type GH 305

for indexable inserts type 305 see from page 171



Right hand version shown
Left hand version mirror image



Article no. **25358**

version right-hand

| Code no. | Description | t max | h | b | L | h1 | H | l1 | l2 | f | Size |
|----------|---------------------------|-------|-------|-------|--------|-------|-------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm | mm | |
| 12.014 | GH305.1212.125.90.04.R.IK | 3.50 | 12.00 | 12.00 | 125.00 | 12.00 | 21.00 | 21.60 | 21.60 | 23.80 | 04 |
| 12.021 | GH305.0625.500.90.04.R.IK | 3.50 | 15.87 | 15.87 | 127.00 | 15.87 | 24.87 | 19.92 | 19.92 | 24.12 | 04 |
| 12.001 | GH305.1616.125.90.04.R.IK | 3.50 | 16.00 | 16.00 | 125.00 | 16.00 | 25.00 | 19.60 | 19.60 | 23.80 | 04 |
| 12.022 | GH305.0750.500.90.04.R.IK | 3.50 | 19.05 | 19.05 | 127.00 | 19.05 | 24.05 | 19.92 | 19.92 | 22.85 | 04 |
| 12.002 | GH305.2020.125.90.04.R.IK | 3.50 | 20.00 | 20.00 | 125.00 | 20.00 | 25.00 | 19.60 | 19.60 | 23.80 | 04 |
| 12.003 | GH305.2525.150.90.04.R.IK | 3.50 | 25.00 | 25.00 | 150.00 | 25.00 | 30.00 | 19.60 | 19.60 | 28.80 | 04 |
| 12.023 | GH305.1000.600.90.04.R.IK | 3.50 | 25.40 | 25.40 | 152.40 | 25.40 | 30.40 | 19.92 | 19.92 | 29.20 | 04 |
| 12.016 | GH305.1212.125.90.06.R.IK | 3.50 | 12.00 | 12.00 | 125.00 | 12.00 | 21.00 | 21.60 | 21.60 | 23.80 | 06 |
| 12.024 | GH305.0625.500.90.06.R.IK | 3.50 | 15.87 | 15.87 | 127.00 | 15.87 | 24.87 | 19.92 | 19.92 | 24.12 | 06 |
| 12.004 | GH305.1616.125.90.06.R.IK | 3.50 | 16.00 | 16.00 | 125.00 | 16.00 | 25.00 | 19.60 | 19.60 | 23.80 | 06 |
| 12.025 | GH305.0750.500.90.06.R.IK | 3.50 | 19.05 | 19.05 | 127.00 | 19.05 | 24.05 | 19.92 | 19.92 | 22.85 | 06 |
| 12.005 | GH305.2020.125.90.06.R.IK | 3.50 | 20.00 | 20.00 | 125.00 | 20.00 | 25.00 | 19.60 | 19.60 | 23.80 | 06 |
| 12.006 | GH305.2525.150.90.06.R.IK | 3.50 | 25.00 | 25.00 | 150.00 | 25.00 | 30.00 | 19.60 | 19.60 | 28.80 | 06 |
| 12.026 | GH305.1000.600.90.06.R.IK | 3.50 | 25.40 | 25.40 | 152.40 | 25.40 | 30.40 | 19.92 | 19.92 | 29.20 | 06 |
| 12.018 | GH305.1212.125.90.08.R.IK | 3.50 | 12.00 | 12.00 | 125.00 | 12.00 | 21.00 | 23.60 | 23.60 | 23.80 | 08 |
| 12.027 | GH305.0625.500.90.08.R.IK | 3.50 | 15.87 | 15.87 | 127.00 | 15.87 | 24.87 | 21.92 | 21.92 | 24.12 | 08 |
| 12.007 | GH305.1616.125.90.08.R.IK | 3.50 | 16.00 | 16.00 | 125.00 | 16.00 | 25.00 | 19.60 | 19.60 | 23.80 | 08 |
| 12.028 | GH305.0750.500.90.08.R.IK | 3.50 | 19.05 | 19.05 | 127.00 | 19.05 | 24.05 | 19.92 | 19.92 | 22.85 | 08 |
| 12.008 | GH305.2020.125.90.08.R.IK | 3.50 | 20.00 | 20.00 | 125.00 | 20.00 | 25.00 | 19.60 | 19.60 | 23.80 | 08 |
| 12.009 | GH305.2525.150.90.08.R.IK | 3.50 | 25.00 | 25.00 | 150.00 | 25.00 | 30.00 | 19.60 | 19.60 | 28.80 | 08 |
| 12.029 | GH305.1000.600.90.08.R.IK | 3.50 | 25.40 | 25.40 | 152.40 | 25.40 | 30.40 | 19.92 | 19.92 | 29.20 | 08 |
| 12.020 | GH305.1212.125.90.12.R.IK | 3.50 | 12.00 | 12.00 | 125.00 | 12.00 | 21.00 | 27.60 | 27.60 | 23.80 | 12 |
| 12.030 | GH305.0625.500.90.12.R.IK | 3.50 | 15.87 | 15.87 | 127.00 | 15.87 | 24.87 | 25.92 | 25.92 | 24.12 | 12 |
| 12.010 | GH305.1616.125.90.12.R.IK | 3.50 | 16.00 | 16.00 | 125.00 | 16.00 | 25.00 | 27.60 | 27.60 | 23.80 | 12 |
| 12.031 | GH305.0750.500.90.12.R.IK | 3.50 | 19.05 | 19.05 | 127.00 | 19.05 | 24.05 | 25.92 | 25.92 | 24.12 | 12 |
| 12.011 | GH305.2020.125.90.12.R.IK | 3.50 | 20.00 | 20.00 | 125.00 | 20.00 | 25.00 | 27.60 | 27.60 | 23.80 | 12 |
| 12.012 | GH305.2525.150.90.12.R.IK | 3.50 | 25.00 | 25.00 | 150.00 | 25.00 | 30.00 | 27.60 | 27.60 | 28.80 | 12 |
| 12.032 | GH305.1000.600.90.12.R.IK | 3.50 | 25.40 | 25.40 | 152.40 | 25.40 | 30.40 | 25.92 | 25.92 | 29.20 | 12 |

System 305

| Code no. | Description | t max | h | b | L | h1 | H | l1 | l2 | f | Size |
|----------|---------------------------|-------|-------|-------|--------|-------|-------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm | mm | |
| 12.014 | GH305.1212.125.90.04.L.IK | 3.50 | 12.00 | 12.00 | 125.00 | 12.00 | 21.00 | 21.60 | 21.60 | 23.80 | 04 |
| 12.021 | GH305.0625.500.90.04.L.IK | 3.50 | 15.87 | 15.87 | 127.00 | 15.87 | 24.87 | 19.92 | 19.92 | 24.12 | 04 |
| 12.001 | GH305.1616.125.90.04.L.IK | 3.50 | 16.00 | 16.00 | 125.00 | 16.00 | 25.00 | 19.60 | 19.60 | 23.80 | 04 |
| 12.022 | GH305.0750.500.90.04.L.IK | 3.50 | 19.05 | 19.05 | 127.00 | 19.05 | 24.05 | 19.92 | 19.92 | 22.85 | 04 |
| 12.002 | GH305.2020.125.90.04.L.IK | 3.50 | 20.00 | 20.00 | 125.00 | 20.00 | 25.00 | 19.60 | 19.60 | 23.80 | 04 |
| 12.003 | GH305.2525.150.90.04.L.IK | 3.50 | 25.00 | 25.00 | 150.00 | 25.00 | 30.00 | 19.60 | 19.60 | 28.80 | 04 |
| 12.023 | GH305.1000.600.90.04.L.IK | 3.50 | 25.40 | 25.40 | 152.40 | 25.40 | 30.40 | 19.92 | 19.92 | 29.20 | 04 |
| 12.016 | GH305.1212.125.90.06.L.IK | 3.50 | 12.00 | 12.00 | 125.00 | 12.00 | 21.00 | 21.60 | 21.60 | 23.80 | 06 |
| 12.024 | GH305.0625.500.90.06.L.IK | 3.50 | 15.87 | 15.87 | 127.00 | 15.87 | 24.87 | 19.92 | 19.92 | 24.12 | 06 |
| 12.004 | GH305.1616.125.90.06.L.IK | 3.50 | 16.00 | 16.00 | 125.00 | 16.00 | 25.00 | 19.60 | 19.60 | 23.80 | 06 |
| 12.025 | GH305.0750.500.90.06.L.IK | 3.50 | 19.05 | 19.05 | 127.00 | 19.05 | 24.05 | 19.92 | 19.92 | 22.85 | 06 |
| 12.005 | GH305.2020.125.90.06.L.IK | 3.50 | 20.00 | 20.00 | 125.00 | 20.00 | 25.00 | 19.60 | 19.60 | 23.80 | 06 |
| 12.006 | GH305.2525.150.90.06.L.IK | 3.50 | 25.00 | 25.00 | 150.00 | 25.00 | 30.00 | 19.60 | 19.60 | 28.80 | 06 |
| 12.026 | GH305.1000.600.90.06.L.IK | 3.50 | 25.40 | 25.40 | 152.40 | 25.40 | 30.40 | 19.92 | 19.92 | 29.20 | 06 |
| 12.018 | GH305.1212.125.90.08.L.IK | 3.50 | 12.00 | 12.00 | 125.00 | 12.00 | 21.00 | 23.60 | 23.60 | 23.80 | 08 |
| 12.027 | GH305.0625.500.90.08.L.IK | 3.50 | 15.87 | 15.87 | 127.00 | 15.87 | 24.87 | 21.92 | 21.92 | 24.12 | 08 |
| 12.007 | GH305.1616.125.90.08.L.IK | 3.50 | 16.00 | 16.00 | 125.00 | 16.00 | 25.00 | 19.60 | 19.60 | 23.80 | 08 |
| 12.028 | GH305.0750.500.90.08.L.IK | 3.50 | 19.05 | 19.05 | 127.00 | 19.05 | 24.05 | 19.92 | 19.92 | 22.85 | 08 |
| 12.008 | GH305.2020.125.90.08.L.IK | 3.50 | 20.00 | 20.00 | 125.00 | 20.00 | 25.00 | 19.60 | 19.60 | 23.80 | 08 |
| 12.009 | GH305.2525.150.90.08.L.IK | 3.50 | 25.00 | 25.00 | 150.00 | 25.00 | 30.00 | 19.60 | 19.60 | 28.80 | 08 |
| 12.029 | GH305.1000.600.90.08.L.IK | 3.50 | 25.40 | 25.40 | 152.40 | 25.40 | 30.40 | 19.92 | 19.92 | 29.20 | 08 |
| 12.020 | GH305.1212.125.90.12.L.IK | 3.50 | 12.00 | 12.00 | 125.00 | 12.00 | 21.00 | 27.60 | 27.60 | 23.80 | 12 |
| 12.030 | GH305.0625.500.90.12.L.IK | 3.50 | 15.87 | 15.87 | 127.00 | 15.87 | 24.87 | 25.92 | 25.92 | 24.12 | 12 |
| 12.010 | GH305.1616.125.90.12.L.IK | 3.50 | 16.00 | 16.00 | 125.00 | 16.00 | 25.00 | 27.60 | 27.60 | 23.80 | 12 |
| 12.031 | GH305.0750.500.90.12.L.IK | 3.50 | 19.05 | 19.05 | 127.00 | 19.05 | 24.05 | 25.92 | 25.92 | 24.12 | 12 |
| 12.011 | GH305.2020.125.90.12.L.IK | 3.50 | 20.00 | 20.00 | 125.00 | 20.00 | 25.00 | 27.60 | 27.60 | 23.80 | 12 |
| 12.012 | GH305.2525.150.90.12.L.IK | 3.50 | 25.00 | 25.00 | 150.00 | 25.00 | 30.00 | 27.60 | 27.60 | 28.80 | 12 |
| 12.032 | GH305.1000.600.90.12.L.IK | 3.50 | 25.40 | 25.40 | 152.40 | 25.40 | 30.40 | 25.92 | 25.92 | 29.20 | 12 |

System 305

Spare parts

| Article no. | Clamping screw | Tightening torque | Size |
|-------------|----------------|-------------------|-------|
| 25901 | | Nm | |
| Code 4.000 | M4x15x15IP | 4-4.5 | 04-08 |
| Code 4.003 | M4x17x15IP | 4-4.5 | 12 |

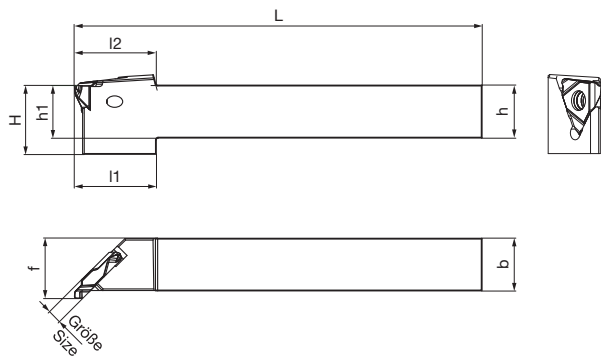
| Article no. | Torx-Plus Wrench |
|-------------|------------------|
| 25904 | |
| Code 15.000 | T15IP T-handle |


Square shank holder 45° offset, external machining, without IC

- grooving depth up to 2 mm
- without internal coolant supply

Type GH 305

for indexable inserts type 305 see page 176


 Right hand version shown
 Left hand version mirror image

 Article no. **25362**

version right-hand

| Code no. | Description | h | b | L | h1 | H | l1 | l2 | f | Size |
|----------|------------------------|-------|-------|--------|-------|-------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm | |
| 12.004 | GH305.1010.125.45.04.R | 10.00 | 10.00 | 125.00 | 10.00 | 21.00 | 25.66 | 25.66 | 12.56 | 04 |
| 12.005 | GH305.1212.125.45.04.R | 12.00 | 12.00 | 125.00 | 12.00 | 21.00 | 25.66 | 25.66 | 14.56 | 04 |
| 12.021 | GH305.0625.500.45.04.R | 15.87 | 15.87 | 127.00 | 15.87 | 20.87 | 26.06 | 26.06 | 18.44 | 04 |
| 12.001 | GH305.1616.125.45.04.R | 16.00 | 16.00 | 125.00 | 16.00 | 21.00 | 25.66 | 25.66 | 18.56 | 04 |
| 12.022 | GH305.0750.500.45.04.R | 19.05 | 19.05 | 127.00 | 19.05 | 24.05 | 26.06 | 26.06 | 21.61 | 04 |
| 12.002 | GH305.2020.125.45.04.R | 20.00 | 20.00 | 125.00 | 20.00 | 25.00 | 25.66 | 25.66 | 22.56 | 04 |
| 12.003 | GH305.2525.150.45.04.R | 25.00 | 25.00 | 150.00 | 25.00 | 30.00 | 30.66 | 30.66 | 27.56 | 04 |
| 12.023 | GH305.1000.600.45.04.R | 25.40 | 25.40 | 152.40 | 25.40 | 30.40 | 31.14 | 31.14 | 27.96 | 04 |

 Article no. **25363**

version left-hand

| Code no. | Description | h | b | L | h1 | H | l1 | l2 | f | Size |
|----------|------------------------|-------|-------|--------|-------|-------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm | |
| 12.004 | GH305.1010.125.45.04.L | 10.00 | 10.00 | 125.00 | 10.00 | 21.00 | 25.66 | 25.66 | 12.56 | 04 |
| 12.005 | GH305.1212.125.45.04.L | 12.00 | 12.00 | 125.00 | 12.00 | 21.00 | 25.66 | 25.66 | 14.56 | 04 |
| 12.021 | GH305.0625.500.45.04.L | 15.87 | 15.87 | 127.00 | 15.87 | 20.87 | 26.06 | 26.06 | 18.44 | 04 |
| 12.001 | GH305.1616.125.45.04.L | 16.00 | 16.00 | 125.00 | 16.00 | 21.00 | 25.66 | 25.66 | 18.56 | 04 |
| 12.022 | GH305.0750.500.45.04.L | 19.05 | 19.05 | 127.00 | 19.05 | 24.05 | 26.06 | 26.06 | 21.61 | 04 |
| 12.002 | GH305.2020.125.45.04.L | 20.00 | 20.00 | 125.00 | 20.00 | 25.00 | 25.66 | 25.66 | 22.56 | 04 |
| 12.003 | GH305.2525.150.45.04.L | 25.00 | 25.00 | 150.00 | 25.00 | 30.00 | 30.66 | 30.66 | 27.56 | 04 |
| 12.023 | GH305.1000.600.45.04.L | 25.40 | 25.40 | 152.40 | 25.40 | 30.40 | 31.14 | 31.14 | 27.96 | 04 |

Spare parts

| Article no. | Clamping screw | Tightening torque |
|-------------|----------------|-------------------|
| 25902 | | Nm |
| Code 4.001 | M4x0.5x7x15IP | 4-4.5 |

| Article no. | Torx-Plus Wrench |
|-------------|------------------|
| 25904 | |
| Code 15.000 | T15IP T-handle |

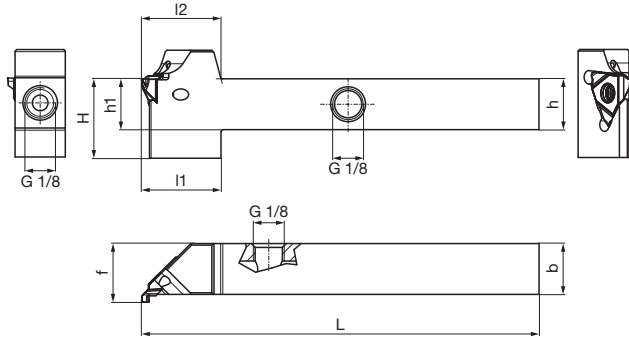
System 305

Square shank holder 45° offset, external machining, with IC

- grooving depth up to 2 mm
- with internal coolant supply from above

Type GH 305

for indexable inserts type 305 see page 176



Right hand version shown
Left hand version mirror image



Article no. **25364**

version right-hand

| Code no. | Description | h | b | L | h1 | H | l1 | l2 | f | Size |
|----------|---------------------------|-------|-------|--------|-------|-------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm | |
| 12.005 | GH305.1212.125.45.04.R.IK | 12.00 | 12.00 | 125.00 | 12.00 | 25.00 | 25.66 | 25.66 | 14.56 | 04 |
| 12.021 | GH305.0625.500.45.04.R.IK | 15.87 | 15.87 | 127.00 | 15.87 | 24.87 | 26.06 | 26.06 | 18.44 | 04 |
| 12.001 | GH305.1616.125.45.04.R.IK | 16.00 | 16.00 | 125.00 | 16.00 | 25.00 | 25.66 | 25.66 | 18.56 | 04 |
| 12.022 | GH305.0750.500.45.04.R.IK | 19.05 | 19.05 | 127.00 | 19.05 | 24.05 | 26.06 | 26.06 | 21.61 | 04 |
| 12.002 | GH305.2020.125.45.04.R.IK | 20.00 | 20.00 | 125.00 | 20.00 | 25.00 | 25.66 | 25.66 | 22.56 | 04 |
| 12.003 | GH305.2525.150.45.04.R.IK | 25.00 | 25.00 | 150.00 | 25.00 | 30.00 | 30.66 | 30.66 | 27.56 | 04 |
| 12.023 | GH305.1000.600.45.04.R.IK | 25.40 | 25.40 | 152.40 | 25.40 | 30.40 | 31.14 | 31.14 | 27.96 | 04 |

Article no. **25365**

version left-hand

| Code no. | Description | h | b | L | h1 | H | l1 | l2 | f | Size |
|----------|---------------------------|-------|-------|--------|-------|-------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm | |
| 12.005 | GH305.1212.125.45.04.L.IK | 12.00 | 12.00 | 125.00 | 12.00 | 25.00 | 25.66 | 25.66 | 14.56 | 04 |
| 12.021 | GH305.0625.500.45.04.L.IK | 15.87 | 15.87 | 127.00 | 15.87 | 24.87 | 26.06 | 26.06 | 18.44 | 04 |
| 12.001 | GH305.1616.125.45.04.L.IK | 16.00 | 16.00 | 125.00 | 16.00 | 25.00 | 25.66 | 25.66 | 18.56 | 04 |
| 12.022 | GH305.0750.500.45.04.L.IK | 19.05 | 19.05 | 127.00 | 19.05 | 24.05 | 26.06 | 26.06 | 21.61 | 04 |
| 12.002 | GH305.2020.125.45.04.L.IK | 20.00 | 20.00 | 125.00 | 20.00 | 25.00 | 25.66 | 25.66 | 22.56 | 04 |
| 12.003 | GH305.2525.150.45.04.L.IK | 25.00 | 25.00 | 150.00 | 25.00 | 30.00 | 30.66 | 30.66 | 27.56 | 04 |
| 12.023 | GH305.1000.600.45.04.L.IK | 25.40 | 25.40 | 152.40 | 25.40 | 30.40 | 31.14 | 31.14 | 27.96 | 04 |

Spare parts

| Article no. | Clamping screw | Tightening torque |
|-------------|----------------|-------------------|
| 25902 | | Nm |
| Code 4.001 | M4x0.5x7x15IP | 4-4.5 |

| Article no. | Torx-Plus Wrench |
|-------------|------------------|
| 25904 | |
| Code 15.000 | T15IP T-handle |

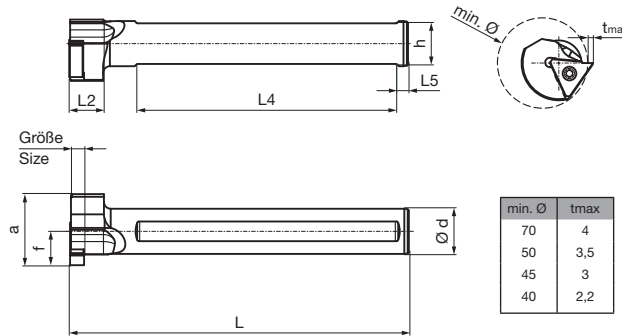


Round shank holder, internal machining, without IC

- grooving depth up to 4 mm
- without internal coolant supply

Type GB 305

for indexable inserts type 305 see from page 171



Right hand version shown
Left hand version mirror image

Article no. **25368**

version right-hand

| Code no. | Description | d | L | L2 | L4 | L5 | h | f | a | Size |
|----------|------------------------|-------|--------|-------|--------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm | |
| 12.021 | GB305.0750.600.90.04.R | 19.05 | 152.40 | 14.60 | 116.84 | 5.08 | 17.04 | 14.48 | 30.48 | 04 |
| 12.001 | GB305.0020.150.90.04.R | 20.00 | 150.00 | 14.60 | 115.00 | 5.00 | 18.00 | 15.00 | 31.50 | 04 |
| 12.002 | GB305.0025.170.90.04.R | 25.00 | 170.00 | 14.60 | 130.00 | 5.00 | 23.00 | 17.50 | 34.50 | 04 |
| 12.022 | GB305.1000.670.90.04.R | 25.40 | 170.18 | 14.60 | 129.54 | 5.08 | 23.39 | 17.78 | 34.54 | 04 |
| 12.023 | GB305.1250.800.90.04.R | 31.75 | 205.20 | 14.60 | 162.56 | 5.08 | 29.74 | 21.08 | 39.37 | 04 |
| 12.003 | GB305.0032.200.90.04.R | 32.00 | 200.00 | 14.60 | 160.00 | 5.00 | 30.00 | 21.00 | 39.25 | 04 |
| 12.024 | GB305.0750.600.90.06.R | 19.05 | 152.40 | 14.60 | 116.84 | 5.08 | 17.04 | 14.48 | 30.48 | 06 |
| 12.004 | GB305.0020.150.90.06.R | 20.00 | 150.00 | 14.60 | 115.00 | 5.00 | 18.00 | 15.00 | 31.50 | 06 |
| 12.005 | GB305.0025.170.90.06.R | 25.00 | 170.00 | 14.60 | 130.00 | 5.00 | 23.00 | 17.50 | 34.50 | 06 |
| 12.025 | GB305.1000.670.90.06.R | 25.40 | 170.18 | 14.60 | 129.54 | 5.08 | 23.39 | 17.78 | 34.54 | 06 |
| 12.026 | GB305.1250.800.90.06.R | 31.75 | 203.20 | 14.60 | 162.56 | 5.08 | 29.74 | 21.08 | 39.37 | 06 |
| 12.006 | GB305.0032.200.90.06.R | 32.00 | 200.00 | 14.60 | 160.00 | 5.00 | 30.00 | 21.00 | 39.25 | 06 |
| 12.027 | GB305.0750.600.90.08.R | 19.05 | 152.40 | 14.60 | 116.84 | 5.08 | 17.04 | 14.48 | 30.48 | 08 |
| 12.007 | GB305.0020.150.90.08.R | 20.00 | 150.00 | 14.60 | 115.00 | 5.00 | 18.00 | 15.00 | 31.50 | 08 |
| 12.008 | GB305.0025.170.90.08.R | 25.00 | 170.00 | 14.60 | 130.00 | 5.00 | 23.00 | 17.50 | 34.50 | 08 |
| 12.028 | GB305.1000.670.90.08.R | 25.40 | 170.18 | 14.60 | 129.54 | 5.08 | 23.39 | 17.78 | 34.54 | 08 |
| 12.029 | GB305.1250.800.90.08.R | 31.75 | 203.20 | 14.60 | 162.56 | 5.08 | 29.74 | 21.08 | 39.37 | 08 |
| 12.009 | GB305.0032.200.90.08.R | 32.00 | 200.00 | 14.60 | 160.00 | 5.00 | 30.00 | 21.00 | 39.25 | 08 |
| 12.030 | GB305.0750.600.90.12.R | 19.05 | 152.40 | 19.60 | 116.84 | 5.08 | 17.04 | 14.48 | 30.48 | 12 |
| 12.010 | GB305.0020.150.90.12.R | 20.00 | 150.00 | 19.60 | 115.00 | 5.00 | 18.00 | 15.00 | 31.50 | 12 |
| 12.011 | GB305.0025.170.90.12.R | 25.00 | 170.00 | 19.60 | 130.00 | 5.00 | 23.00 | 17.50 | 34.50 | 12 |
| 12.031 | GB305.1000.670.90.12.R | 25.40 | 170.18 | 19.60 | 129.54 | 5.08 | 23.39 | 17.78 | 34.54 | 12 |
| 12.032 | GB305.1250.800.90.12.R | 31.75 | 203.20 | 19.60 | 162.56 | 5.08 | 29.74 | 21.08 | 39.37 | 12 |
| 12.012 | GB305.0032.200.90.12.R | 32.00 | 200.00 | 19.60 | 160.00 | 5.00 | 30.00 | 21.00 | 39.25 | 12 |

Article no. **25369**

version left-hand

| Code no. | Description | d | L | L2 | L4 | L5 | h | f | a | Size |
|----------|------------------------|-------|--------|-------|--------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm | |
| 12.021 | GB305.0750.600.90.04.L | 19.05 | 152.40 | 14.60 | 116.84 | 5.08 | 17.04 | 14.48 | 30.48 | 04 |
| 12.001 | GB305.0020.150.90.04.L | 20.00 | 150.00 | 14.60 | 115.00 | 5.00 | 18.00 | 15.00 | 31.50 | 04 |
| 12.002 | GB305.0025.170.90.04.L | 25.00 | 170.00 | 14.60 | 130.00 | 5.00 | 23.00 | 17.50 | 34.50 | 04 |
| 12.022 | GB305.1000.670.90.04.L | 25.40 | 170.18 | 14.60 | 129.54 | 5.08 | 23.39 | 17.78 | 34.54 | 04 |
| 12.023 | GB305.1250.800.90.04.L | 31.75 | 205.20 | 14.60 | 162.56 | 5.08 | 29.74 | 21.08 | 39.37 | 04 |
| 12.003 | GB305.0032.200.90.04.L | 32.00 | 200.00 | 14.60 | 160.00 | 5.00 | 30.00 | 21.00 | 39.25 | 04 |

System 305

| Code no. | Description | d | L | L2 | L4 | L5 | h | f | a | Size |
|----------|------------------------|-------|--------|-------|--------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm | |
| 12.024 | GB305.0750.600.90.06.L | 19.05 | 152.40 | 14.60 | 116.84 | 5.08 | 17.04 | 14.48 | 30.48 | 06 |
| 12.004 | GB305.0020.150.90.06.L | 20.00 | 150.00 | 14.60 | 115.00 | 5.00 | 18.00 | 15.00 | 31.50 | 06 |
| 12.005 | GB305.0025.170.90.06.L | 25.00 | 170.00 | 14.60 | 130.00 | 5.00 | 23.00 | 17.50 | 34.50 | 06 |
| 12.025 | GB305.1000.670.90.06.L | 25.40 | 170.18 | 14.60 | 129.54 | 5.08 | 23.39 | 17.78 | 34.54 | 06 |
| 12.026 | GB305.1250.800.90.06.L | 31.75 | 203.20 | 14.60 | 162.56 | 5.08 | 29.74 | 21.08 | 39.37 | 06 |
| 12.006 | GB305.0032.200.90.06.L | 32.00 | 200.00 | 14.60 | 160.00 | 5.00 | 30.00 | 21.00 | 39.25 | 06 |
| 12.027 | GB305.0750.600.90.08.L | 19.05 | 152.40 | 14.60 | 116.84 | 5.08 | 17.04 | 14.48 | 30.48 | 08 |
| 12.007 | GB305.0020.150.90.08.L | 20.00 | 150.00 | 14.60 | 115.00 | 5.00 | 18.00 | 15.00 | 31.50 | 08 |
| 12.008 | GB305.0025.170.90.08.L | 25.00 | 170.00 | 14.60 | 130.00 | 5.00 | 23.00 | 17.50 | 34.50 | 08 |
| 12.028 | GB305.1000.670.90.08.L | 25.40 | 170.18 | 14.60 | 129.54 | 5.08 | 23.39 | 17.78 | 34.54 | 08 |
| 12.029 | GB305.1250.800.90.08.L | 31.75 | 203.20 | 14.60 | 162.56 | 5.08 | 29.74 | 21.08 | 39.37 | 08 |
| 12.009 | GB305.0032.200.90.08.L | 32.00 | 200.00 | 14.60 | 160.00 | 5.00 | 30.00 | 21.00 | 39.25 | 08 |
| 12.030 | GB305.0750.600.90.12.L | 19.05 | 152.40 | 19.60 | 116.84 | 5.08 | 17.04 | 14.48 | 30.48 | 12 |
| 12.010 | GB305.0020.150.90.12.L | 20.00 | 150.00 | 19.60 | 115.00 | 5.00 | 18.00 | 15.00 | 31.50 | 12 |
| 12.011 | GB305.0025.170.90.12.L | 25.00 | 170.00 | 19.60 | 130.00 | 5.00 | 23.00 | 17.50 | 34.50 | 12 |
| 12.031 | GB305.1000.670.90.12.L | 25.40 | 170.18 | 19.60 | 129.54 | 5.08 | 23.39 | 17.78 | 34.54 | 12 |
| 12.032 | GB305.1250.800.90.12.L | 31.75 | 203.20 | 19.60 | 162.56 | 5.08 | 29.74 | 21.08 | 39.37 | 12 |
| 12.012 | GB305.0032.200.90.12.L | 32.00 | 200.00 | 19.60 | 160.00 | 5.00 | 30.00 | 21.00 | 39.25 | 12 |

Spare parts

| Article no. | Clamping screw | Tightening torque | Size |
|-------------|----------------|-------------------|-------|
| 25901 | | Nm | |
| Code 4.000 | M4x15x15IP | 4-4.5 | 04-08 |
| Code 4.003 | M4x17x15IP | 4-4.5 | 12 |

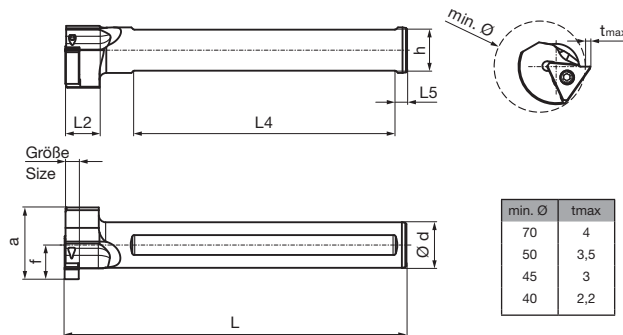
| Article no. | Torx-Plus Wrench |
|-------------|------------------|
| 25904 | |
| Code 15.000 | T15IP T-handle |


Round shank holder, internal machining, with IC

- grooving depth up to 4 mm
- with internal coolant supply from above

Type GB 305

for indexable inserts type 305 see from page 171


 Right hand version shown
 Left hand version mirror image

 Article no. **25370**

version right-hand

| Code no. | Description | d | L | L2 | L4 | L5 | h | f | a | Size |
|----------|---------------------------|-------|--------|-------|--------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm | |
| 12.021 | GB305.0750.600.90.04.R.IK | 19.05 | 152.40 | 14.60 | 116.84 | 5.08 | 17.04 | 14.48 | 30.48 | 04 |
| 12.001 | GB305.0020.150.90.04.R.IK | 20.00 | 150.00 | 14.60 | 115.00 | 5.00 | 18.00 | 15.00 | 31.50 | 04 |
| 12.002 | GB305.0025.170.90.04.R.IK | 25.00 | 170.00 | 14.60 | 130.00 | 5.00 | 23.00 | 17.50 | 34.50 | 04 |
| 12.022 | GB305.1000.670.90.04.R.IK | 25.40 | 170.18 | 14.60 | 129.54 | 5.08 | 23.39 | 17.78 | 34.54 | 04 |
| 12.023 | GB305.1250.800.90.04.R.IK | 31.75 | 205.20 | 14.60 | 162.56 | 5.08 | 29.74 | 21.08 | 39.37 | 04 |
| 12.003 | GB305.0032.200.90.04.R.IK | 32.00 | 200.00 | 14.60 | 160.00 | 5.00 | 30.00 | 21.00 | 39.25 | 04 |
| 12.024 | GB305.0750.600.90.06.R.IK | 19.05 | 152.40 | 14.60 | 116.84 | 5.08 | 17.04 | 14.48 | 30.48 | 06 |
| 12.004 | GB305.0020.150.90.06.R.IK | 20.00 | 150.00 | 14.60 | 115.00 | 5.00 | 18.00 | 15.00 | 31.50 | 06 |
| 12.005 | GB305.0025.170.90.06.R.IK | 25.00 | 170.00 | 14.60 | 130.00 | 5.00 | 23.00 | 17.50 | 34.50 | 06 |
| 12.025 | GB305.1000.670.90.06.R.IK | 25.40 | 170.18 | 14.60 | 129.54 | 5.08 | 23.39 | 17.78 | 34.54 | 06 |
| 12.026 | GB305.1250.800.90.06.R.IK | 31.75 | 203.20 | 14.60 | 162.56 | 5.08 | 29.74 | 21.08 | 39.37 | 06 |
| 12.006 | GB305.0032.200.90.06.R.IK | 32.00 | 200.00 | 14.60 | 160.00 | 5.00 | 30.00 | 21.00 | 39.25 | 06 |
| 12.027 | GB305.0750.600.90.12.R.IK | 19.05 | 152.40 | 14.60 | 116.84 | 5.08 | 17.04 | 14.48 | 30.48 | 08 |
| 12.007 | GB305.0020.150.90.08.R.IK | 20.00 | 150.00 | 14.60 | 115.00 | 5.00 | 18.00 | 15.00 | 31.50 | 08 |
| 12.008 | GB305.0025.170.90.08.R.IK | 25.00 | 170.00 | 14.60 | 130.00 | 5.00 | 23.00 | 17.50 | 34.50 | 08 |
| 12.028 | GB305.1000.670.90.08.R.IK | 25.40 | 170.18 | 14.60 | 129.54 | 5.08 | 23.39 | 17.78 | 34.54 | 08 |
| 12.029 | GB305.1250.800.90.08.R.IK | 31.75 | 203.20 | 14.60 | 162.56 | 5.08 | 29.74 | 21.08 | 39.37 | 08 |
| 12.009 | GB305.0032.200.90.08.R.IK | 32.00 | 200.00 | 14.60 | 160.00 | 5.00 | 30.00 | 21.00 | 39.25 | 08 |
| 12.030 | GB305.0750.600.90.06.R.IK | 19.05 | 152.40 | 19.60 | 116.84 | 5.08 | 17.04 | 14.48 | 30.48 | 12 |
| 12.010 | GB305.0020.150.90.12.R.IK | 20.00 | 150.00 | 19.60 | 115.00 | 5.00 | 18.00 | 15.00 | 31.50 | 12 |
| 12.011 | GB305.0025.170.90.12.R.IK | 25.00 | 170.00 | 19.60 | 130.00 | 5.00 | 23.00 | 17.50 | 34.50 | 12 |
| 12.031 | GB305.1000.670.90.12.R.IK | 25.40 | 170.18 | 19.60 | 129.54 | 5.08 | 23.39 | 17.78 | 34.54 | 12 |
| 12.032 | GB305.1250.800.90.12.R.IK | 31.75 | 203.20 | 19.60 | 162.56 | 5.08 | 29.74 | 21.08 | 39.37 | 12 |
| 12.012 | GB305.0032.200.90.12.R.IK | 32.00 | 200.00 | 19.60 | 160.00 | 5.00 | 30.00 | 21.00 | 39.25 | 12 |

 Article no. **25371**

version left-hand

| Code no. | Description | d | L | L2 | L4 | L5 | h | f | a | Size |
|----------|---------------------------|-------|--------|-------|--------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm | |
| 12.021 | GB305.0750.600.90.04.L.IK | 19.05 | 152.40 | 14.60 | 116.84 | 5.08 | 17.04 | 14.48 | 30.48 | 04 |
| 12.001 | GB305.0020.150.90.04.L.IK | 20.00 | 150.00 | 14.60 | 115.00 | 5.00 | 18.00 | 15.00 | 31.50 | 04 |
| 12.002 | GB305.0025.170.90.04.L.IK | 25.00 | 170.00 | 14.60 | 130.00 | 5.00 | 23.00 | 17.50 | 34.50 | 04 |
| 12.022 | GB305.1000.670.90.04.L.IK | 25.40 | 170.18 | 14.60 | 129.54 | 5.08 | 23.39 | 17.78 | 34.54 | 04 |
| 12.023 | GB305.1250.800.90.04.L.IK | 31.75 | 205.20 | 14.60 | 162.56 | 5.08 | 29.74 | 21.08 | 39.37 | 04 |
| 12.003 | GB305.0032.200.90.04.L.IK | 32.00 | 200.00 | 14.60 | 160.00 | 5.00 | 30.00 | 21.00 | 39.25 | 04 |

System 305

| Code no. | Description | d | L | L2 | L4 | L5 | h | f | a | Size |
|----------|---------------------------|-------|--------|-------|--------|------|-------|-------|-------|------|
| | | mm | mm | mm | mm | mm | mm | mm | mm | |
| 12.024 | GB305.0750.600.90.06.L.IK | 19.05 | 152.40 | 14.60 | 116.84 | 5.08 | 17.04 | 14.48 | 30.48 | 06 |
| 12.004 | GB305.0020.150.90.06.L.IK | 20.00 | 150.00 | 14.60 | 115.00 | 5.00 | 18.00 | 15.00 | 31.50 | 06 |
| 12.005 | GB305.0025.170.90.06.L.IK | 25.00 | 170.00 | 14.60 | 130.00 | 5.00 | 23.00 | 17.50 | 34.50 | 06 |
| 12.025 | GB305.1000.670.90.06.L.IK | 25.40 | 170.18 | 14.60 | 129.54 | 5.08 | 23.39 | 17.78 | 34.54 | 06 |
| 12.026 | GB305.1250.800.90.06.L.IK | 31.75 | 203.20 | 14.60 | 162.56 | 5.08 | 29.74 | 21.08 | 39.37 | 06 |
| 12.006 | GB305.0032.200.90.06.L.IK | 32.00 | 200.00 | 14.60 | 160.00 | 5.00 | 30.00 | 21.00 | 39.25 | 06 |
| 12.027 | GB305.0750.600.90.12.L.IK | 19.05 | 152.40 | 14.60 | 116.84 | 5.08 | 17.04 | 14.48 | 30.48 | 08 |
| 12.007 | GB305.0020.150.90.08.L.IK | 20.00 | 150.00 | 14.60 | 115.00 | 5.00 | 18.00 | 15.00 | 31.50 | 08 |
| 12.008 | GB305.0025.170.90.08.L.IK | 25.00 | 170.00 | 14.60 | 130.00 | 5.00 | 23.00 | 17.50 | 34.50 | 08 |
| 12.028 | GB305.1000.670.90.08.L.IK | 25.40 | 170.18 | 14.60 | 129.54 | 5.08 | 23.39 | 17.78 | 34.54 | 08 |
| 12.029 | GB305.1250.800.90.08.L.IK | 31.75 | 203.20 | 14.60 | 162.56 | 5.08 | 29.74 | 21.08 | 39.37 | 08 |
| 12.009 | GB305.0032.200.90.08.L.IK | 32.00 | 200.00 | 14.60 | 160.00 | 5.00 | 30.00 | 21.00 | 39.25 | 08 |
| 12.030 | GB305.0750.600.90.06.L.IK | 19.05 | 152.40 | 19.60 | 116.84 | 5.08 | 17.04 | 14.48 | 30.48 | 12 |
| 12.010 | GB305.0020.150.90.12.L.IK | 20.00 | 150.00 | 19.60 | 115.00 | 5.00 | 18.00 | 15.00 | 31.50 | 12 |
| 12.011 | GB305.0025.170.90.12.L.IK | 25.00 | 170.00 | 19.60 | 130.00 | 5.00 | 23.00 | 17.50 | 34.50 | 12 |
| 12.031 | GB305.1000.670.90.12.L.IK | 25.40 | 170.18 | 19.60 | 129.54 | 5.08 | 23.39 | 17.78 | 34.54 | 12 |
| 12.032 | GB305.1250.800.90.12.L.IK | 31.75 | 203.20 | 19.60 | 162.56 | 5.08 | 29.74 | 21.08 | 39.37 | 12 |
| 12.012 | GB305.0032.200.90.12.L.IK | 32.00 | 200.00 | 19.60 | 160.00 | 5.00 | 30.00 | 21.00 | 39.25 | 12 |

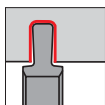
Spare parts

| Article no. | Clamping screw | Tightening torque | Size |
|-------------|----------------|-------------------|-------|
| 25901 | | Nm | |
| Code 4.000 | M4x15x15IP | 4-4.5 | 04-08 |
| Code 4.003 | M4x17x15IP | 4-4.5 | 12 |

| Article no. | Torx-Plus Wrench |
|-------------|------------------|
| 25904 | |
| Code 15.000 | T15IP T-handle |



Indexable insert for radial grooving external and internal

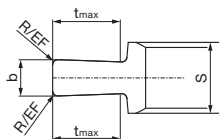
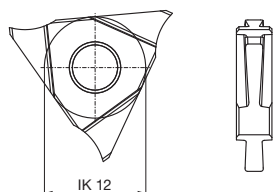


- snap ring grooves to DIN471/472, NW = 0.5-5.15
- indexable insert applicable in right and left holders
- geometry .BA ground
- pay attention to insert seat size 04 / 06

for tool holders type GH305/GB305 see from page 156

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Cutting data page 185

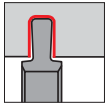


Article no. **25601** **25602** **25603**

| Code no. | Description | NW | b ±0,02 | R | EF | t max | s | Size |
|----------|------------------------|------|---------|------|------|-------|------|------|
| | | mm | mm | mm | mm | mm | mm | |
| 12.001 | GE305.0050.000.BA.04.N | 0.50 | 0.55 | | | 1.50 | 4.20 | 04 |
| 12.002 | GE305.0060.000.BA.04.N | 0.60 | 0.65 | | | 1.50 | 4.20 | 04 |
| 12.003 | GE305.0070.000.BA.04.N | 0.70 | 0.75 | | | 1.50 | 4.20 | 04 |
| 12.004 | GE305.0080.000.BA.04.N | 0.80 | 0.85 | | | 1.50 | 4.20 | 04 |
| 12.005 | GE305.0090.000.BA.04.N | 0.90 | 0.95 | | | 1.50 | 4.20 | 04 |
| 12.006 | GE305.0100.000.BA.04.N | 1.00 | 1.05 | | 0.05 | 3.00 | 4.20 | 04 |
| 12.007 | GE305.0110.000.BA.04.N | 1.10 | 1.22 | | 0.05 | 3.00 | 4.20 | 04 |
| 12.008 | GE305.0130.000.BA.04.N | 1.30 | 1.42 | | 0.05 | 3.00 | 4.20 | 04 |
| 12.009 | GE305.0160.000.BA.04.N | 1.60 | 1.72 | | 0.05 | 4.00 | 4.20 | 04 |
| 12.010 | GE305.0185.015.BA.04.N | 1.85 | 1.97 | 0.15 | | 4.00 | 4.20 | 04 |
| 12.011 | GE305.0215.015.BA.04.N | 2.15 | 2.27 | 0.15 | | 5.00 | 4.20 | 04 |
| 12.012 | GE305.0265.015.BA.04.N | 2.65 | 2.77 | 0.15 | | 5.00 | 4.20 | 04 |
| 12.013 | GE305.0315.015.BA.04.N | 3.15 | 3.27 | 0.15 | | 5.00 | 4.20 | 04 |
| 12.014 | GE305.0415.015.BA.06.N | 4.15 | 4.27 | 0.15 | | 5.00 | 6.20 | 06 |
| 12.015 | GE305.0515.015.BA.06.N | 5.15 | 5.27 | 0.15 | | 5.00 | 6.20 | 06 |

System 305

Indexable insert for radial grooving and copying external and internal



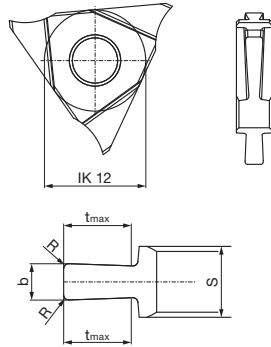
- grooving depth up to 5 mm
- indexable insert applicable in right and left holders
- geometry .BA ground

for tool holders type GH305/GB305 size 04 see from page 156

GUHRING NAVIGATOR

Cutting data page 185

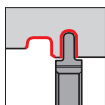
| Tool material | Solid carbide | | |
|---------------|---------------|--------|--------|
| Type | GE 305 | GE 305 | GE 305 |
| Surface | | | |
| | FIRE | TiCN | bright |



Article no. **25605** **25606** **25607**

System 305

| Code no. | Description | b ±0,02 | R | t max | s | Size |
|----------|------------------------|---------|------|-------|------|------|
| | | mm | mm | mm | mm | |
| 12.001 | GE305.0100.010.BA.04.N | 1.00 | 0.10 | 3.00 | 4.20 | 04 |
| 12.002 | GE305.0150.020.BA.04.N | 1.50 | 0.20 | 3.00 | 4.20 | 04 |
| 12.003 | GE305.0200.020.BA.04.N | 2.00 | 0.20 | 4.00 | 4.20 | 04 |
| 12.004 | GE305.0250.030.BA.04.N | 2.50 | 0.30 | 5.00 | 4.20 | 04 |
| 12.005 | GE305.0300.030.BA.04.N | 3.00 | 0.30 | 5.00 | 4.20 | 04 |
| 12.006 | GE305.0350.030.BA.04.N | 3.50 | 0.30 | 5.00 | 4.20 | 04 |
| 12.007 | GE305.0400.020.BA.04.N | 4.00 | 0.20 | 5.00 | 4.20 | 04 |
| 12.008 | GE305.0400.040.BA.04.N | 4.00 | 0.40 | 5.00 | 4.20 | 04 |

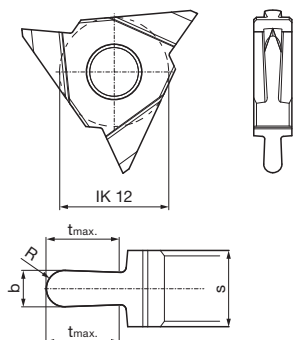

Indexable insert for radial grooving and copying external and internal


- grooving depth up to 5 mm
- indexable insert applicable in right and left holders
- geometry .AA ground

for tool holders type GH305/GB305 size 04 see from page 156

GUHRING NAVIGATOR

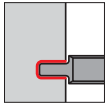
Cutting data page 185



Article no. **25613** **25614** **25615**

| Code no. | Description | b ±0,02 | R | t max | s | Size |
|----------|------------------------|---------|------|-------|------|------|
| | | mm | mm | mm | mm | |
| 12.001 | GE305.0050.025.AA.04.N | 0.50 | 0.25 | 1.50 | 4.20 | 04 |
| 12.002 | GE305.0100.050.AA.04.N | 1.00 | 0.50 | 3.00 | 4.20 | 04 |
| 12.003 | GE305.0110.055.AA.04.N | 1.10 | 0.55 | 3.00 | 4.20 | 04 |
| 12.004 | GE305.0120.060.AA.04.N | 1.20 | 0.60 | 3.00 | 4.20 | 04 |
| 12.005 | GE305.0140.070.AA.04.N | 1.40 | 0.70 | 3.00 | 4.20 | 04 |
| 12.006 | GE305.0150.075.AA.04.N | 1.50 | 0.75 | 3.00 | 4.20 | 04 |
| 12.007 | GE305.0160.080.AA.04.N | 1.60 | 0.80 | 4.00 | 4.20 | 04 |
| 12.008 | GE305.0180.090.AA.04.N | 1.80 | 0.90 | 4.00 | 4.20 | 04 |
| 12.009 | GE305.0200.100.AA.04.N | 2.00 | 1.00 | 4.00 | 4.20 | 04 |
| 12.010 | GE305.0220.110.AA.04.N | 2.20 | 1.10 | 5.00 | 4.20 | 04 |
| 12.011 | GE305.0250.125.AA.04.N | 2.50 | 1.25 | 5.00 | 4.20 | 04 |
| 12.012 | GE305.0280.140.AA.04.N | 2.80 | 1.40 | 5.00 | 4.20 | 04 |
| 12.013 | GE305.0300.150.AA.04.N | 3.00 | 1.50 | 5.00 | 4.20 | 04 |
| 12.014 | GE305.0360.180.AA.04.N | 3.60 | 1.80 | 5.00 | 4.20 | 04 |
| 12.015 | GE305.0400.200.AA.04.N | 4.00 | 2.00 | 5.00 | 4.20 | 04 |

Indexable insert for axial grooving, straight slots

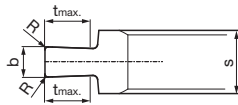
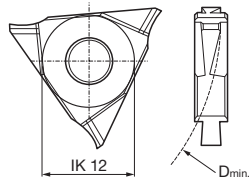


- grooving depth up to 3 mm
- right index. inserts in rh, left index. inserts in lh tool holders
- geometry .BA ground

for tool holders type GH305 size 04 see from page 156

GUHRING NAVIGATOR

Cutting data page 185



Right hand version shown
Left hand version mirror image



| | | | |
|-------------------|--------------|--------------|--------------|
| Article no. | 25626 | 25628 | 25630 |
| Cutting direction | | | |

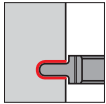
| Code no. | Description | D min | b ±0,02 | R | t max | s | Size |
|----------|------------------------|-------|---------|------|-------|------|------|
| | | mm | mm | mm | mm | mm | |
| 12.001 | GA305.0150.020.BA.04.R | 15.00 | 1.50 | 0.20 | 2.00 | 4.20 | 04 |
| 12.002 | GA305.0200.020.BA.04.R | 30.00 | 2.00 | 0.20 | 3.00 | 4.20 | 04 |
| 12.003 | GA305.0250.020.BA.04.R | 30.00 | 2.50 | 0.20 | 3.00 | 4.20 | 04 |
| 12.004 | GA305.0300.020.BA.04.R | 30.00 | 3.00 | 0.20 | 3.00 | 4.20 | 04 |

| | | | |
|-------------------|--------------|--------------|--------------|
| Article no. | 25627 | 25629 | 25631 |
| Cutting direction | | | |

| Code no. | Description | D min | b ±0,02 | R | t max | s | Size |
|----------|------------------------|-------|---------|------|-------|------|------|
| | | mm | mm | mm | mm | mm | |
| 12.001 | GA305.0150.020.BA.04.L | 15.00 | 1.50 | 0.20 | 2.00 | 4.20 | 04 |
| 12.002 | GA305.0200.020.BA.04.L | 30.00 | 2.00 | 0.20 | 3.00 | 4.20 | 04 |
| 12.003 | GA305.0250.020.BA.04.L | 30.00 | 2.50 | 0.20 | 3.00 | 4.20 | 04 |
| 12.004 | GA305.0300.020.BA.04.L | 30.00 | 3.00 | 0.20 | 3.00 | 4.20 | 04 |



Indexable insert for axial grooving, full radius slots

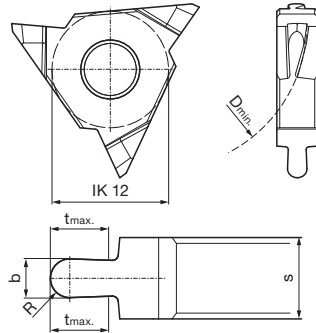


- grooving depth up to 3 mm
- right index. inserts in rh, left index. inserts in lh tool holders
- geometry .AA ground

for tool holders type GH305 size 04 see from page 156

GUHRING NAVIGATOR

Cutting data page 185



Right hand version shown
Left hand version mirror image

Article no. **25634** **25636** **25638**

Cutting direction

| Code no. | Description | D min | b ±0,02 | R | t max | s | Size |
|----------|------------------------|-------|---------|------|-------|------|------|
| | | mm | mm | mm | mm | mm | |
| 12.001 | GA305.0150.075.AA.04.R | 15.00 | 1.50 | 0.75 | 2.00 | 4.20 | 04 |
| 12.002 | GA305.0200.100.AA.04.R | 30.00 | 2.00 | 1.00 | 3.00 | 4.20 | 04 |
| 12.003 | GA305.0300.150.AA.04.R | 30.00 | 3.00 | 1.50 | 3.00 | 4.20 | 04 |
| 12.004 | GA305.0400.200.AA.04.R | 30.00 | 4.00 | 2.00 | 3.00 | 4.20 | 04 |

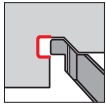
Article no. **25635** **25637** **25639**

Cutting direction

| Code no. | Description | D min | b ±0,02 | R | t max | s | Size |
|----------|------------------------|-------|---------|------|-------|------|------|
| | | mm | mm | mm | mm | mm | |
| 12.001 | GA305.0150.075.AA.04.L | 15.00 | 1.50 | 0.75 | 2.00 | 4.20 | 04 |
| 12.002 | GA305.0200.100.AA.04.L | 30.00 | 2.00 | 1.00 | 3.00 | 4.20 | 04 |
| 12.003 | GA305.0300.150.AA.04.L | 30.00 | 3.00 | 1.50 | 3.00 | 4.20 | 04 |
| 12.004 | GA305.0400.200.AA.04.L | 30.00 | 4.00 | 2.00 | 3.00 | 4.20 | 04 |

System 305

Indexable insert for grooving axial external recesses

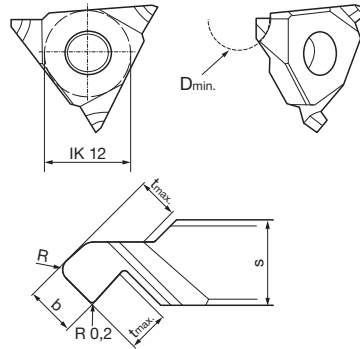


- grooving depth up to 2 mm
- right index. inserts in rh, left index. inserts in lh tool holders
- geometry .AA ground
- for axial external recesses to ISO 9974-2

for tool holders type GH305, 45° depressed centre, see page 165

GUHRING NAVIGATOR

Cutting data page 185



Right hand version shown
Left hand version mirror image



| | | | |
|-------------------|--------------|--------------|--------------|
| Article no. | 25618 | 25620 | 25622 |
| Cutting direction | | | |

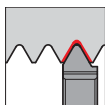
| Code no. | Description | D min | b ±0,02 | R | t max | s | Size |
|----------|------------------------|-------|---------|------|-------|------|------|
| | | mm | mm | mm | mm | mm | |
| 12.001 | GA305.0150.040.AA.04.R | 8.00 | 1.50 | 0.40 | 1.60 | 4.20 | 04 |
| 12.002 | GA305.0200.050.AA.04.R | 12.00 | 2.00 | 0.50 | 1.90 | 4.20 | 04 |
| 12.003 | GA305.0240.060.AA.04.R | 20.00 | 2.40 | 0.60 | 2.00 | 4.20 | 04 |

| | | | |
|-------------------|--------------|--------------|--------------|
| Article no. | 25619 | 25621 | 25623 |
| Cutting direction | | | |

| Code no. | Description | D min | b ±0,02 | R | t max | s | Size |
|----------|------------------------|-------|---------|------|-------|------|------|
| | | mm | mm | mm | mm | mm | |
| 12.001 | GA305.0150.040.AA.04.L | 8.00 | 1.50 | 0.40 | 1.60 | 4.20 | 04 |
| 12.002 | GA305.0200.050.AA.04.L | 12.00 | 2.00 | 0.50 | 1.90 | 4.20 | 04 |
| 12.003 | GA305.0240.060.AA.04.L | 20.00 | 2.40 | 0.60 | 2.00 | 4.20 | 04 |



Indexable insert for thread turning, part profile

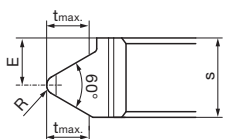
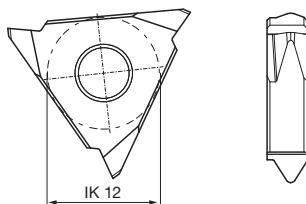


- grooving depth up to 3.5 mm
- ground top rake
- geometry .AA ground
- pay attention to insert seat size 04 / 06

for tool holders type GH305/GB305 see from page 156

GUHRING NAVIGATOR

Cutting data page 185



Right hand version shown
Left hand version mirror image



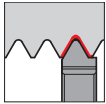
| Article no. | 25654 | 25656 | 25658 |
|-------------------|-------|-------|-------|
| Cutting direction | | | |

| Code no. | Description | P | E | R | t max | s | Size |
|----------|------------------------|---------|------|------|-------|------|------|
| | | | mm | mm | mm | mm | |
| 12.010 | GG305.TM00.100.AA.04.R | 1,00 | 3.60 | 0.14 | 0.70 | 4.20 | 04 |
| 12.020 | GG305.TM00.125.AA.04.R | 1,25 | 3.50 | 0.17 | 0.85 | 4.20 | 04 |
| 12.030 | GG305.TM00.150.AA.04.R | 1,50 | 3.40 | 0.21 | 1.00 | 4.20 | 04 |
| 12.040 | GG305.TM00.175.AA.04.R | 1,75 | 3.20 | 0.25 | 1.20 | 4.20 | 04 |
| 12.050 | GG305.TM00.200.AA.04.R | 2,00 | 3.10 | 0.28 | 1.35 | 4.20 | 04 |
| 12.060 | GG305.TM00.250.AA.04.R | 2,50 | 2.90 | 0.36 | 1.65 | 4.20 | 04 |
| 12.070 | GG305.TM00.300.AA.04.R | 3,00 | 2.60 | 0.43 | 2.60 | 4.20 | 04 |
| 12.080 | GG305.TM00.600.AA.06.R | 3.0-6.0 | 3.50 | 0.43 | 3.50 | 6.20 | 06 |
| 12.090 | GG305.TM00.350.AA.04.R | 3,50 | 2.50 | 0.50 | 2.50 | 4.20 | 04 |

| Article no. | 25655 | 25657 | 25659 |
|-------------------|-------|-------|-------|
| Cutting direction | | | |

| Code no. | Description | P | E | R | t max | s | Size |
|----------|------------------------|---------|------|------|-------|------|------|
| | | | mm | mm | mm | mm | |
| 12.010 | GG305.TM00.100.AA.04.L | 1,00 | 3.60 | 0.14 | 0.70 | 4.20 | 04 |
| 12.020 | GG305.TM00.125.AA.04.L | 1,25 | 3.50 | 0.17 | 0.85 | 4.20 | 04 |
| 12.030 | GG305.TM00.150.AA.04.L | 1,50 | 3.40 | 0.21 | 1.00 | 4.20 | 04 |
| 12.040 | GG305.TM00.175.AA.04.L | 1,75 | 3.20 | 0.25 | 1.20 | 4.20 | 04 |
| 12.050 | GG305.TM00.200.AA.04.L | 2,00 | 3.10 | 0.28 | 1.35 | 4.20 | 04 |
| 12.060 | GG305.TM00.250.AA.04.L | 2,50 | 2.90 | 0.36 | 1.65 | 4.20 | 04 |
| 12.070 | GG305.TM00.300.AA.04.L | 3,00 | 2.60 | 0.43 | 2.60 | 4.20 | 04 |
| 12.080 | GG305.TM00.600.AA.06.L | 3.0-6.0 | 3.50 | 0.43 | 3.50 | 6.20 | 06 |
| 12.090 | GG305.TM00.350.AA.04.L | 3,50 | 2.50 | 0.50 | 2.50 | 4.20 | 04 |

Indexable insert for thread turning, full profile

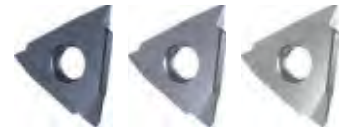
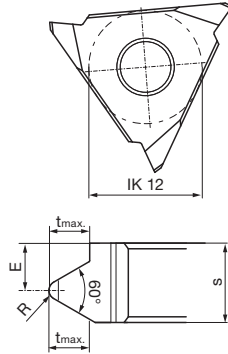


- grooving depth up to 3.9 mm
- ground top rake
- geometry .AA ground
- pay attention to insert seat size 04 / 06 / 08

for tool holders type GH305/GB305 see from page 156

GUHRING NAVIGATOR

Cutting data page 185



Right hand version shown
Left hand version mirror image

| Tool material | Solid carbide | | |
|---------------|---------------|--------|--------|
| Type | GG 305 | GG 305 | GG 305 |
| Surface | | | |
| | FIRE | TiCN | bright |

Article no. **25662** **25664** **25666**

Cutting direction

| Code no. | Description | P | E | R | t max | s | Size |
|----------|------------------------|------|------|------|-------|------|------|
| | | mm | mm | mm | mm | mm | |
| 12.010 | GG305.VM00.100.AA.04.R | 1.00 | 3.60 | 0.14 | 0.70 | 4.20 | 04 |
| 12.020 | GG305.VM00.125.AA.04.R | 1.25 | 3.40 | 0.17 | 1.00 | 4.20 | 04 |
| 12.030 | GG305.VM00.150.AA.04.R | 1.50 | 3.30 | 0.21 | 1.15 | 4.20 | 04 |
| 12.040 | GG305.VM00.175.AA.04.R | 1.75 | 3.20 | 0.25 | 1.30 | 4.20 | 04 |
| 12.050 | GG305.VM00.200.AA.04.R | 2.00 | 3.10 | 0.28 | 1.45 | 4.20 | 04 |
| 12.060 | GG305.VM00.250.AA.04.R | 2.50 | 2.90 | 0.36 | 1.75 | 4.20 | 04 |
| 12.070 | GG305.VM00.300.AA.04.R | 3.00 | 2.70 | 0.43 | 2.10 | 4.20 | 04 |
| 12.080 | GG305.VM00.350.AA.04.R | 3.50 | 2.40 | 0.50 | 2.40 | 4.20 | 04 |
| 12.090 | GG305.VM00.400.AA.06.R | 4.00 | 4.20 | 0.57 | 2.70 | 6.20 | 06 |
| 12.100 | GG305.VM00.500.AA.06.R | 5.00 | 3.80 | 0.72 | 3.30 | 6.20 | 06 |
| 12.110 | GG305.VM00.600.AA.08.R | 6.00 | 5.20 | 0.86 | 3.90 | 8.20 | 08 |

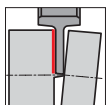
Article no. **25663** **25665** **25667**

Cutting direction

| Code no. | Description | P | E | R | t max | s | Size |
|----------|------------------------|------|------|------|-------|------|------|
| | | mm | mm | mm | mm | mm | |
| 12.010 | GG305.VM00.100.AA.04.L | 1.00 | 3.60 | 0.14 | 0.70 | 4.20 | 04 |
| 12.020 | GG305.VM00.125.AA.04.L | 1.25 | 3.40 | 0.17 | 1.00 | 4.20 | 04 |
| 12.030 | GG305.VM00.150.AA.04.L | 1.50 | 3.30 | 0.21 | 1.15 | 4.20 | 04 |
| 12.040 | GG305.VM00.175.AA.04.L | 1.75 | 3.20 | 0.25 | 1.30 | 4.20 | 04 |
| 12.050 | GG305.VM00.200.AA.04.L | 2.00 | 3.10 | 0.28 | 1.45 | 4.20 | 04 |
| 12.060 | GG305.VM00.250.AA.04.L | 2.50 | 2.90 | 0.36 | 1.75 | 4.20 | 04 |
| 12.070 | GG305.VM00.300.AA.04.L | 3.00 | 2.70 | 0.43 | 2.10 | 4.20 | 04 |
| 12.080 | GG305.VM00.350.AA.04.L | 3.50 | 2.40 | 0.50 | 2.40 | 4.20 | 04 |
| 12.090 | GG305.VM00.400.AA.06.L | 4.00 | 4.20 | 0.57 | 2.70 | 6.20 | 06 |
| 12.100 | GG305.VM00.500.AA.06.L | 5.00 | 3.80 | 0.72 | 3.30 | 6.20 | 06 |
| 12.110 | GG305.VM00.600.AA.08.L | 6.00 | 5.20 | 0.86 | 3.90 | 8.20 | 08 |



Indexable insert for parting off

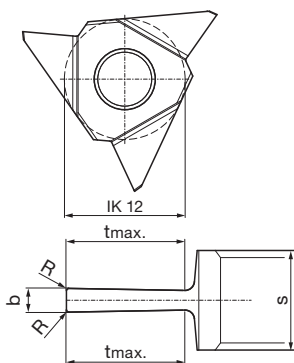


- grooving depth up to 5 mm
- indexable insert applicable in right and left holders
- geometry .AA ground
- without front cutting angle

for tool holders type GH305 size 04 see from page 156

GUHRING NAVIGATOR

Cutting data page 185

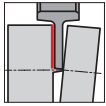


Article no. **25641** **25642** **25643**

| Code no. | Description | b ±0,02 | R | t max | s | Size |
|----------|------------------------|---------|------|-------|------|------|
| | | mm | mm | mm | mm | |
| 12.001 | GZ305.0100.000.AA.04.N | 1.00 | 0.10 | 5.00 | 4.20 | 04 |
| 12.002 | GZ305.0150.000.AA.04.N | 1.50 | 0.10 | 5.00 | 4.20 | 04 |

System 305

Indexable insert for parting off

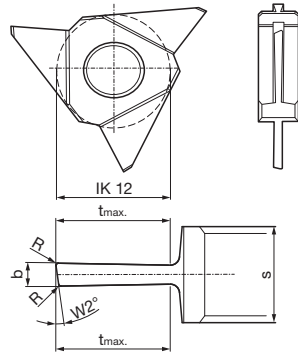


- grooving depth up to 5 mm
- indexable insert applicable in right and left holders
- geometry .AA ground
- with front cutting angle

for tool holders type GH305 size 04 see from page 156

GUHRING NAVIGATOR

Cutting data page 185



Right hand version shown
Left hand version mirror image



| Tool material | Solid carbide | | |
|---------------|---------------|--------|--------|
| Type | GZ 305 | GZ 305 | GZ 305 |
| Surface | | | |
| | FIRE | TiCN | bright |

Article no. **25646** **25648** **25650**
version right-hand right-hand right-hand

| Code no. | Description | b ±0,02 | R | W2 | t max | s | Size |
|----------|------------------------|---------|------|------|-------|------|------|
| | | mm | mm | ° | mm | mm | |
| 12.001 | GZ305.0100.080.AA.04.R | 1.00 | 0.10 | 8.00 | 5.00 | 4.20 | 04 |
| 12.002 | GZ305.0150.080.AA.04.R | 1.50 | 0.10 | 8.00 | 5.00 | 4.20 | 04 |

Article no. **25647** **25649** **25651**
version left-hand left-hand left-hand

| Code no. | Description | b ±0,02 | R | W2 | t max | s | Size |
|----------|------------------------|---------|------|------|-------|------|------|
| | | mm | mm | ° | mm | mm | |
| 12.001 | GZ305.0100.080.AA.04.L | 1.00 | 0.10 | 8.00 | 5.00 | 4.20 | 04 |
| 12.002 | GZ305.0150.080.AA.04.L | 1.50 | 0.10 | 8.00 | 5.00 | 4.20 | 04 |



External radial grooving

| Application: External radial grooving | Tool selection | Customer benefit |
|---------------------------------------|--------------------------------|--|
| Component: Shaft | System: 305 | Instantly, Guhring's insert with three cutting edges convinced with good chip evacuation and longer tool life. |
| Material: C60 | Holder: GH305.2020.125.00.04.R | |
| 1.0601 | Insert: GE305.0130.000.BA.04.N | |
| Machine: Gildemeister CTX410 | | |
| Cooling: External cooling, 10 bar | | |
| Oper. step: Grooving to 1.4 mm | | |
| vc: 100 m/min | | |
| f: 0.15 mm | | |
| ap: | | |
| Groov. depth: 0.7 mm | | |



External radial grooving

| Application: External radial grooving | Tool selection | Customer benefit |
|---------------------------------------|---|---|
| Component: Shaft | System: 305 | The change from external cooling to a Guhring holder with internal cooling resulted in a considerably longer tool life. There is one tool change less per shift and 25 more components can be manufactured per shift. |
| Material: Ck50 | Holder: GH305.2020.125.00.04.R.IK | |
| 1.1206 | Insert: Special grooving insert b 2.72 mm | |
| Machine: Gildemeister CTX420 | | |
| Cooling: 10 bar | | |
| Oper. step: Grooving to b 2.72 mm | | |
| vc: 10 m/min | | |
| f: 0.08 mm | | |
| ap: | | |
| Groov. depth: 1.3 mm | | |



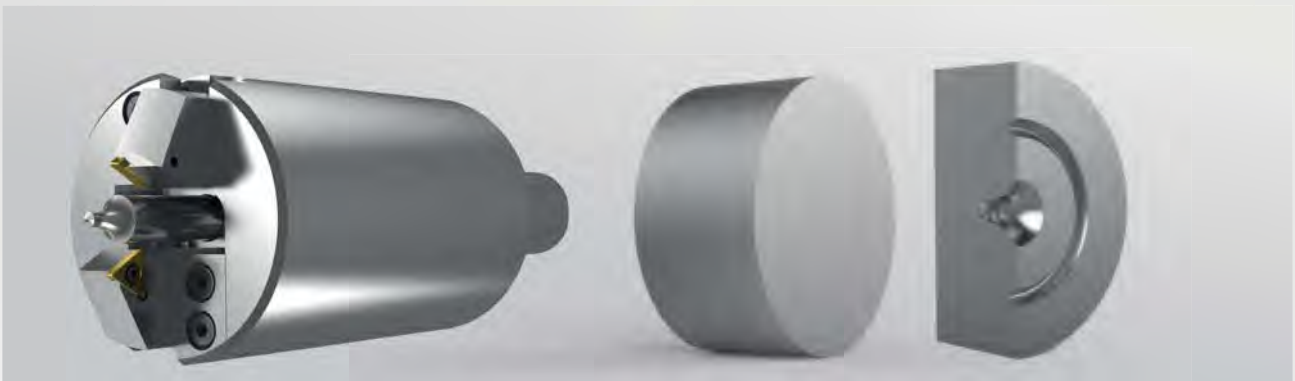
Axial grooving

| Application: Axial grooving | Tool selection | Customer benefit |
|-----------------------------|---------------------------------------|---|
| Component: Adapter sleeve | System: 106 | Under the same application conditions, the Guhring tool instantly achieves 50% more components. Therefore, there is much improvement potential in this application in order to increase cutting speed and feed rate to save time. |
| Material: 16 MnCr 5 | Holder: GB106.0020.040.00.22.N.IK.CIT | |
| 1.7139 | Insert: GA106.0200.015.17.60.R | |
| Machine: Citizen A20 | | |
| Cooling: Neat oil, 80 bar | | |
| Oper. step: Semi-finishing | | |
| vc: 100 m/min | | |
| f: 0.02 mm | | |
| ap: D1 7.5 mm/D2 12.6 mm | | |
| Groov. depth: 2.9 mm | | |

GE 100

MULTIFUNCTIONAL tool systems for END MACHINING

- \ Modular system for machining various component dimensions: facing, chamfering, turning, and centre boring with only one tool
- \ Precision polished DIN indexable insert range and special contours available



- | Tool: Drive shaft – input post
- | Material: 20MnCrS5
- | Machining: Grooving and centre drilling
- | Customer benefit: shorter machining times, quicker and easier change of cutting tool



- | Tool: Electronic component - Pin
- | Material: CuZn39Pb3
- | Machining: Grooving with profile plate
- | Customer benefit: Processing safety, precise reproducibility












TECHNICAL SECTION & ACCESSORIES

Technical section
& Accessories



GUHRINGNAVIGATOR
 SYSTEM 104/106/108/110

| Machining | Feed range f (mm/rev.) | Point radius R | Cutting depth a _p (mm) | General formulas |
|---|---------------------------|--|--|---|
|    | 0.02 - 0.08 | R 0.05 R 0.10 R 0.15 R 0.20 R 0.25 R 0.30 | 0.02 - 0.07 0.05 - 0.15 0.08 - 0.20 0.12 - 0.25 0.13 - 0.28 0.17 - 0.35 | Cutting speed (v _c) $v_c = \frac{d_1 \cdot \pi \cdot n}{1000}$ [m/min] |
|    | 0.01 - 0.03 | | | Revolutions per minute (n) $n = \frac{v_c \cdot 1000}{d_1 \cdot \pi}$ [U/min] |
|    | 0.01 - 0.05 | | Rule of thumb: a _p ~ r | Feed rate (v _f) v _f = f · n [mm/min] |

Guide values for feed and cutting depths



| ISO | Material | Material examples/ material number | Tensile strength (N/mm ²) | Brinell hardness (HB) | Cutting speed v _c (m/min) | | | | | | | |
|-------------------------------|--|---|--|--|---|------------------|-------------|--------|------------|-------|--------|---|
| | | | | | TiN Ⓢ | TiAlN nanoA Ⓢ | Bright ○ | | | | | |
| P | Carbon steel | C <= 0.15% | 11SMn30+C / 1.0715 C15 / 1.0401 | 500 600 | 150 180 | 20-160 | 50-200 | 15-90 | | | | |
| | | C ≥ 0.15-0.45% | S235JR (ST37-2) / 1.0037 Ck22 / 1.1151 | 400 600 | 120 180 | | | | | | | |
| | | C > 0.45% | S355JO (St52-3) / 1.0553 C60 / 1.0601 | 600 900 | 180 270 | | | | | | | |
| | Low-alloyed steel (alloy content ≤5%) | annealed | 16MnCr5 / 1.7131 18CrNi8 / 1.5920 | 650 650 | 200 200 | 20-160 | 50-180 | 15-70 | | | | |
| | | heat-treatable | 25CrMoV4 / 1.7218 42CrMo4V / 1.7225 | 900 1100 | 270 320 | | | | | | | |
| | | High-alloyed steel (alloy content >5%) | annealed | X37CrMoV5-1 / 1.2343 X153CrMoV12 / 1.2379 | 750 850 | | | | 220 250 | 25-90 | 40-140 | - |
| | | | heat-treatable | 55NiCrMoV7 / 1.2714 | 1200 | | | | 350 | | | |
| | Cast steel | un-alloyed, low-alloyed | GS52 / 1.0552 | 600 | 180 | 20-120 | 30-180 | - | | | | |
| | | high-alloyed | GX40CrNiSi22-10 / 1.4826 | 750 | 220 | - | 30-90 | - | | | | |
| | M | Stainless steel | martensitic, ferritic, tempered | X14CrMoS17 / 1.4104 X4CrNiMo16-5-1 / 1.4418 | 800 1000 | 240 300 | 20-70 | 30-90 | - | | | |
| austenitic, Ni > 8% | | | | X5CrNi18-10 / 1.4301 X2CrNiMo17-12-2 / 1.4404 | 650 | 200 | | | | | | |
| austenitic, ferritic (Duplex) | | | X2CrNiMoCuN25-6-3 / 1.4507 X2CrNiMoN25-7-4 / 1.4410 | 850 | 250 | - | 30-100 | - | | | | |
| | | | Grey cast iron | low tensile strength | EN-GJL-200 (GG20) / 0.6020 | | 180 | 30-150 | 30-180 | 30-90 | | |
| K | Spheroidal graphite iron | high tensile strength | EN-GJL-400 (GG40) / 0.6040 | | 260 | 30-120 | 30-150 | 30-70 | | | | |
| | | low tensile strength | EN-GJS-400-15 (GGG40) / 0.7040 | | 160 | 30-130 | 30-160 | - | | | | |
| | Malleable cast iron | high tensile strength | EN-GJS-700-2 (GGG70) / 0.7070 | | 260 | 30-110 | 30-140 | - | | | | |
| | | low tensile strength | EN-GJMW-350-4 (GTW35) / 0.8035 | | 125 | 30-130 | 30-160 | - | | | | |
| N | Al-alloys | high tensile strength | EN-GJMB-550-4 (GTS55) / 0.8155 | | 250 | 30-110 | 30-140 | - | | | | |
| | | non-heat-treatable <12% Si | EN-AW-2017 (AlCuMg1) / 3.1325 | | 60 | 30-550 | 30-550 | 30-250 | | | | |
| | Al-cast-alloys | heat-treatable <12% Si | EN-AW-6082 (AlMgSi1) / 3.2315 | | 100 | 30-400 | 30-400 | 30-180 | | | | |
| | | non-heat-treatable <12% Si | AlSi9Cu3 / 3.2163 | | 80 | 30-550 | 30-550 | 30-250 | | | | |
| | Copper alloys | heat-treatable <12% Si | AlSi10Mg / 3.2383 | | 100 | 30-400 | 30-400 | 30-180 | | | | |
| | | brass, lead alloy | CuZn39Pb2 (MS58) / 2.0380 | 400 | 120 | 30-400 | 30-400 | 30-180 | | | | |
| S | Heat resistant alloys, super alloys | bronze | CuSn6 / 2.1020 | 500 | 150 | 30-240 | 30-240 | 30-180 | | | | |
| | | NiFe-base, annealed | NiCr15Fe (Alloy600) / 2.4816 | 700 | | - | 15-70 | | | | | |
| | | NiFe-Basis, hardened | | 950 | | - | 15-50 | | | | | |
| | | NiCo-Basis, annealed | NiMo16Cr15W (Alloy C-276) / 2.4819 | 800 | | - | 15-50 | | | | | |
| | | NiCo-Basis, cast | | 1100 | | - | 10-40 | - | | | | |
| | Titanium-alloys | NiCo-Basis, hardened | NiCr19NbMo (Alloy718) / 2.4668 | 1200 | | - | 10-35 | | | | | |
| | | annealed | Ti6Al4V / 3.7164 | 900 | | - | 15-50 | | | | | |
| | | hardened | | 1200 | | - | 10-35 | | | | | |
| H | Hardened steels | Heat-treatable steel | | | > 52 HRC | - | 20 - 40 | - | | | | |
| | | Heat-treatable steel, case hardened steel | | | > 59 HRC | - | 10 - 30 | - | | | | |
| | | Heat-treatable steel, case hardened steel | | | > 62 HRC | - | (CBN) | - | | | | |

The specified values must be adapted to the machine and machining conditions.



GUHRINGNAVIGATOR

SYSTEM 305

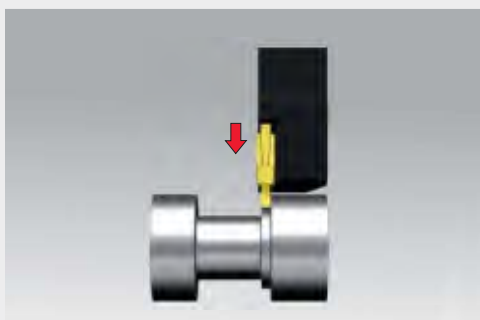
| | | | | |
|--|---|---|---|---|
|  <p>Geometry .BA ground round chip breaker</p> | <p>Feed rate f (mm/rev.)</p> <p>↓ 0.03 - 0.15</p> <p>↔ 0.02 - 0.12 ap = 0.1 - 0.5 mm</p> |  <p>Geometry .AA ground flat chip breaker</p> | <p>Feed rate f (mm/rev.)</p> <p>↓ 0.03 - 0.15</p> <p>↔ 0.02 - 0.12 ap = 0.1 - 0.5 mm</p> | <p>General formulas</p> <p>Cutting speed (v_c)</p> $v_c = \frac{d_1 \cdot \pi \cdot n}{1000} \text{ [m/min]}$ <p>Revolutions per minute (n)</p> $n = \frac{v_c \cdot 1000}{d_1 \cdot \pi} \text{ [U/min]}$ <p>Feed rate (v_f)</p> $v_f = f \cdot n \text{ [mm/min]}$ |
| | <p>↓ = radial feed direction ↔ = axial feed direction</p> | | | |

| ISO | Material | Material examples/ material number | Tensile strength (N/mm ²) | Brinell hardness (HB) | Cutting speed vc (m/min) | | |
|---|---|---------------------------------------|--|--|-----------------------------|------------|---------|
| | | | | | FIRE/nanoFIRE | TiCN | |
| P | Carbon steel | C ≤ 0.15% | 11SMn30+C / 1.0715 C15 / 1.0401 | 500 600 | 150 180 | 150-220 | 130-200 |
| | | C ≥ 0.15-0.45% | S235JR (ST37-2) / 1.0037 Ck22 / 1.1151 | 400 600 | 120 180 | | |
| | | C > 0.45% | S355JO (St52-3) / 1.0553 C60 / 1.0601 | 600 900 | 180 270 | | |
| | Low-alloyed steel (alloy content ≤5%) | annealed | 16MnCr5 / 1.7131 18CrNi8 / 1.5920 | 650 650 | 200 200 | 120-170 | 90-150 |
| | | heat-treatable | 25CrMoV4 / 1.7218 42CrMo4V / 1.7225 | 900 1100 | 270 320 | 90-150 | 70-130 |
| | High-alloyed steel (alloy content >5%) | annealed | X37CrMoV5-1 / 1.2343 X153CrMoV12 / 1.2379 | 750 850 | 220 250 | 130-180 | - |
| | | heat-treatable | 55NiCrMoV7 / 1.2714 | 1200 | 350 | 70-120 | - |
| | Cast steel | un-alloyed, low-alloyed | GS52 / 1.0552 | 600 | 180 | 130-180 | - |
| | | high-alloyed | GX40CrNiSi22-10 / 1.4826 | 750 | 220 | 100-140 | - |
| | M | Stainless steel | martensitic, ferritic, tempered | X14CrMoS17 / 1.4104 X4CrNiMo16-5-1 / 1.4418 | 800 1000 | 240 300 | 90-160 |
| austenitic, Ni > 8% | | | X5CrNi18-10 / 1.4301 X2CrNiMo17-12-2 / 1.4404 | 650 | 200 | 90-160 | 70-140 |
| austenitic, ferritic (Duplex) | | | X2CrNiMoCuN25-6-3 / 1.4507 X2CrNiMoN25-7-4 / 1.4410 | 850 | 250 | 70-100 | 50-120 |
| | | | | | | | |
| K | Grey cast iron | low tensile strength | EN-GJL-200 (GG20) / 0.6020 | | 180 | 90-150 | - |
| | | high tensile strength | EN-GJL-400 (GG40) / 0.6040 | | 260 | 70-110 | - |
| | Spheroidal graphite iron | low tensile strength | EN-GJS-400-15 (GGG40) / 0.7040 | | 160 | 90-150 | 70-100 |
| | | high tensile strength | EN-GJS-700-2 (GGG70) / 0.7070 | | 260 | 70-110 | 50-90 |
| | Malleable cast iron | low tensile strength | EN-GJMW-350-4 (GTW35) / 0.8035 | | 125 | 70-140 | 60-100 |
| | | high tensile strength | EN-GJMB-550-4 (GTS55) / 0.8155 | | 250 | 50-90 | 50-70 |
| N | Al-alloys | non-heat-treatable <12% Si | EN-AW-2017 (AlCuMg1) / 3.1325 | | 60 | - | 500-800 |
| | | heat-treatable <12% Si | EN-AW-6082 (AlMgSi1) / 3.2315 | | 100 | - | 200-400 |
| | Al-cast-alloys | non-heat-treatable <12% Si | AlSi9Cu3 / 3.2163 | | 80 | - | 500-800 |
| | | heat-treatable <12% Si | AlSi10Mg / 3.2383 | | 100 | - | 200-400 |
| | Copper alloys | brass, lead alloy | CuZn39Pb2 (MS58) / 2.0380 | 400 | 120 | - | 130-250 |
| | | bronze | CuSn6 / 2.1020 | 500 | 150 | - | 100-180 |
| S | Heat resistant alloys, super alloys | NiFe-base, annealed | NiCr15Fe (Alloy600) / 2.4816 | 700 | - | - | 30-70 |
| | | NiFe-Basis, hardened | | 950 | - | - | 30-50 |
| | | NiCo-Basis, annealed | NiMo16Cr15W (Alloy C-276) / 2.4819 | 800 | - | - | 30-60 |
| | | NiCo-Basis, cast | | 1100 | - | - | 30-40 |
| | | NiCo-Basis, hardened | NiCr19NbMo (Alloy718) / 2.4668 | 1200 | - | - | 20-30 |
| | Titanium-alloys | annealed | Ti6Al4V / 3.7164 | 900 | - | - | 30-50 |
| | | hardened | | 1200 | - | - | 20-30 |
| | H | Hardened steels | Heat-treatable steel | | | > 52 HRC | 20 - 40 |
| Heat-treatable steel, case hardened steel | | | | | > 59 HRC | 10 - 30 | - |
| Heat-treatable steel, case hardened steel | | | | | > 62 HRC | (CBN) | - |

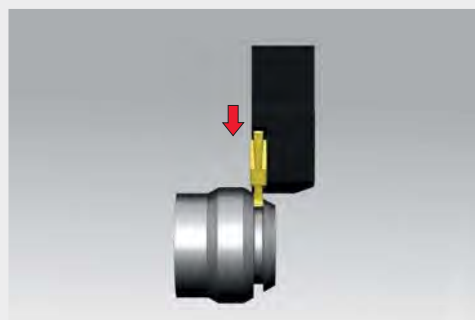
The specified values must be adapted to the machine and machining conditions.



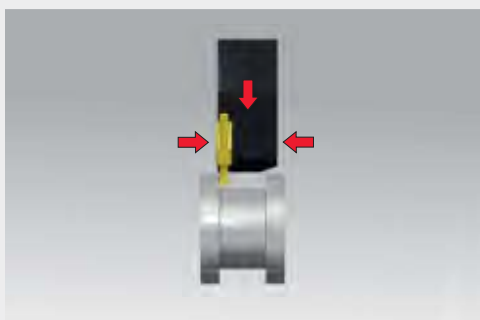
General machining hints



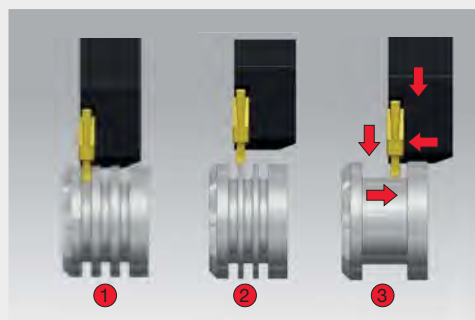
Width of machining should be min. 70% of the width of the cutting edge



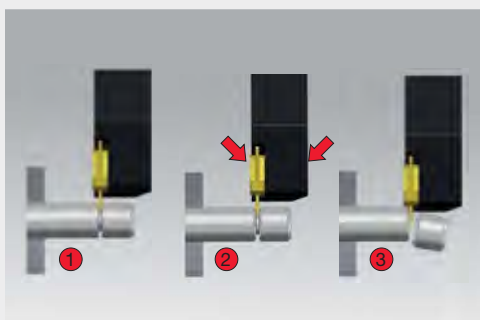
Reduce feed by 20 – 50% when grooving on inclined faces



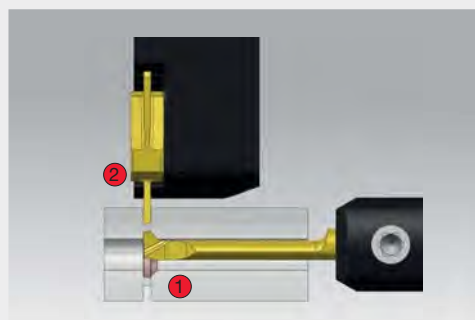
Recessing
- radial stroke
- turning in axial direction
- leave axial and radial stock for finishing



Our hint for clever recessing:
1 – (pre)-grooving „comb“
2 – removing remaining webs
width of the webs max: width of insert $b - 2 \times r$
3 - finishing



Our hint for clever parting:
1 – (pre)-grooving
2 – chamfering
3 - parting



Our hint for clever parting with bore in centre:
1 – (pre)-grooving with tool type GV104
2 – parting with tool type GZ305



General application hints

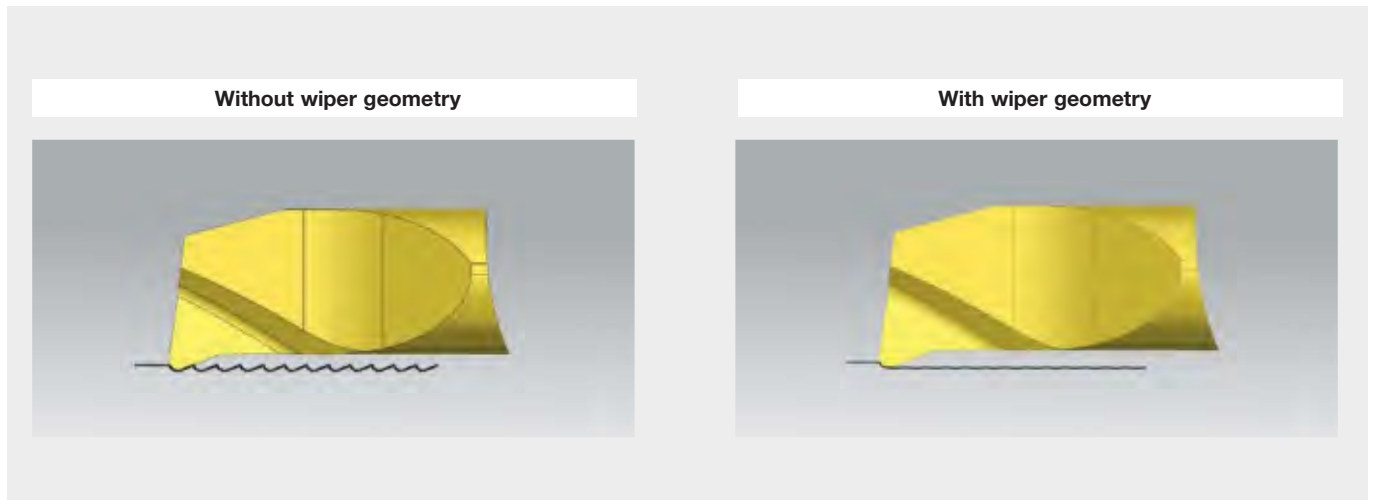
Solution

Subject

| | | Solution | | | | | | | | | | | |
|--------------------------|-------------------------------------|----------|----------------|---------------|------------------------|---------------|-------|-----------------|---------------|--------------------|---------------|-------------------------------|---------|
| | | Feed | Feed at centre | Cutting speed | RH/LH edge orientation | Corner radius | Wiper | Width of groove | Tool clamping | Workpiece clamping | Tool overhang | Centre height of cutting edge | Coolant |
| Related to wear | Edge chipping | ↓ | ↓ | | | ↑ | | | 🔍 | 🔍 | 🔍 | 🔍 | |
| | Build up edge | | | ↑ | | | | | | | | | 👍 |
| | Flank wear | 🔍 | ↓ | ↓ | | ↑ | | | | | | 🔍 | 👍 |
| | Plastic deformation | ↓ | ↑ | ↓ | | ↑ | | | | | | | 👍 |
| Related to the component | Vibrations | ↑ | | ↓ | | ↓ | | ↓ | 🔍 | 🔍 | ↓ | 🔍 | |
| | Burrs | | ↓ | | 👍 | ↓ | | | | | | 🔍 | 👍 |
| | Surface | ↓ | ↓ | ↑ | | ↑ | 👍 | ↑ | 🔍 | 🔍 | ↓ | 🔍 | 👍 |
| | Long chips (no chip breakage) | ↑ | | ↑ | | | | | | | | | 👍 |
| | (too) short chips, compressed chips | ↓ | | | | | | | | | | | |

- ↓ decrease values (large impact)
- ↑ increase values (large impact)
- ↓ decrease values (low impact)
- ↑ increase values (low impact)
- 🔍 check
- 👍 apply

Application hints for the cutting insert GJ104/106/108 with wiper geometry



The wiper geometry offers multiple options

- You retain the feed rate of the cutting insert without wiper geometry and achieve a considerably better surface finish.
- You increase the feed rate taking the entire process (material, chip formation, stability) into consideration and achieve the following improvements:
 - reduced machining time
 - therefore reduced engagement of the tool, improving tool life
 - improved chip formation/chip breakage
 - thicker chip enables better heat dissipation

Please note the following carefully!

The cutting insert/holder must be positioned axially parallel to optimize the wiper. This is the only way the wiper geometry can achieve its desired effect to improve the surface finish.

General formulas to determine the surface finish quality

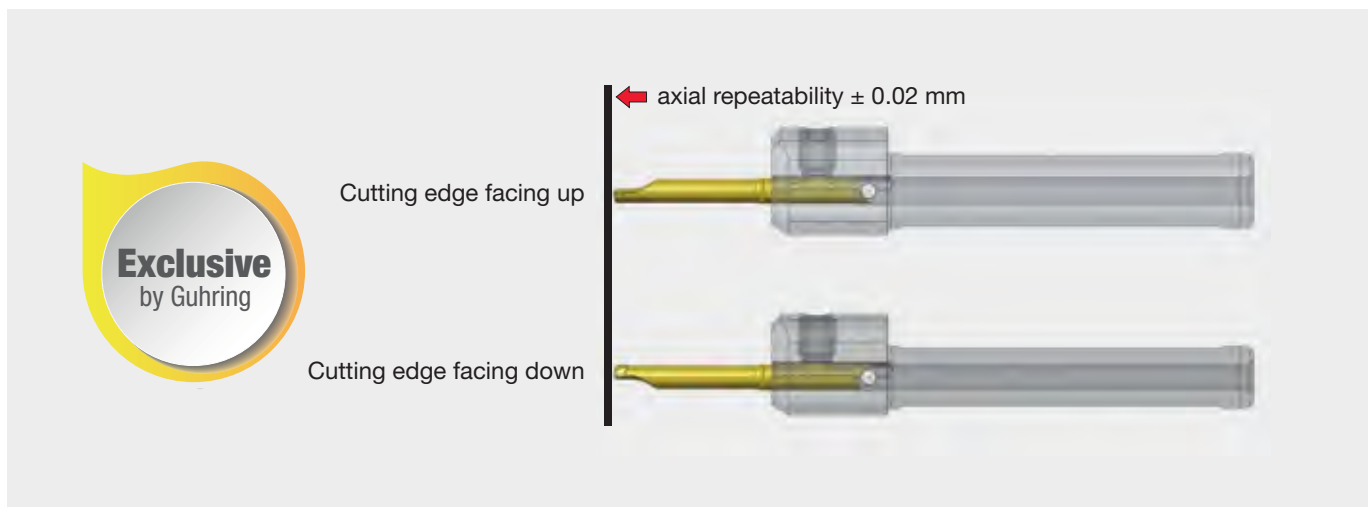
| | | |
|----------------------------|----------------------------|-------------------------------------|
| $R_{th} = f^2 / 8 \cdot r$ | $r = f^2 / 8 \cdot R_{th}$ | $f = \sqrt{8 \cdot r \cdot R_{th}}$ |
|----------------------------|----------------------------|-------------------------------------|

Application example

| Application: Boring out Ø 4 mm | Tool selection | Customer benefit |
|--------------------------------|-----------------------------------|--|
| Component: Sleeve | System: 104 | Rz 5-8 µm was achieved with a cutting insert without wiper. With a wiper cutting insert Rz values could be improved to 2-4 µm. In the 2nd step vc was increased to 130 m/min. This resulted in a further surface finish improvement. |
| Material: 42CrMo4 | Holder: GB104.0016.075.00.15.N.IK | |
| 1.7225 | Insert: GJ104.2337.020.17.40.R | |
| Machine: Spinner | TiAlN nanoA | |
| Cooling: 20 bar | | |
| Operat. step: Finishing | | |
| vc: 90 m/min | | |
| f: 0.08 mm | | |
| ap: 0.15 | | |
| Groov. depth: - | | |

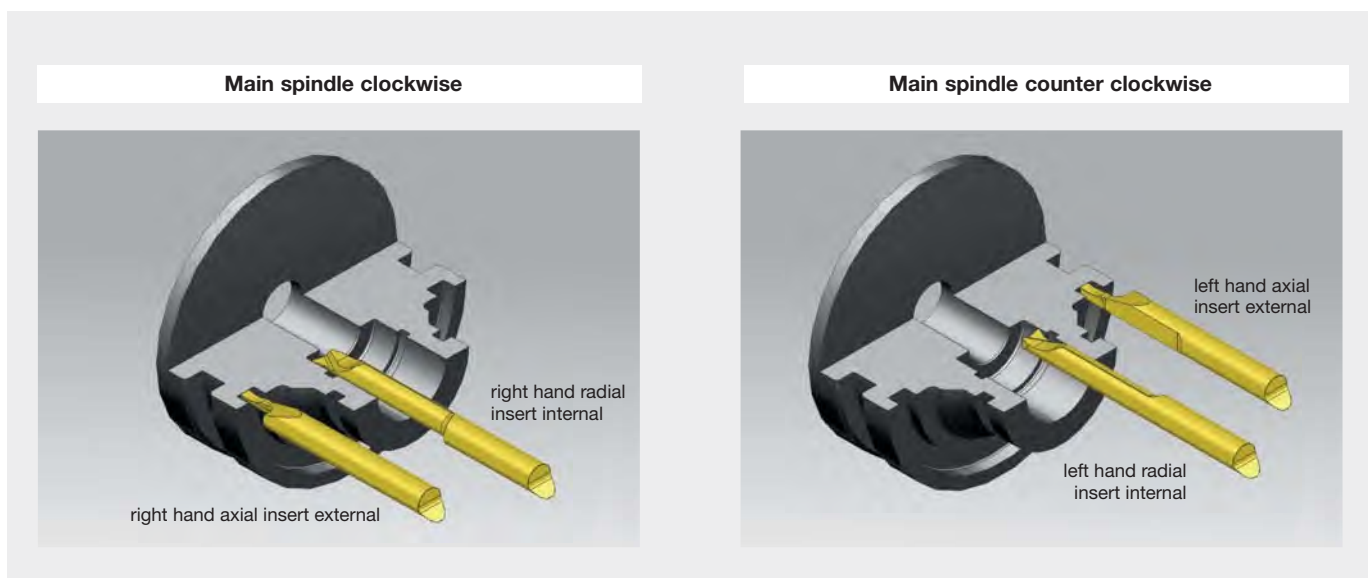


System 104/106/108/110 Positioning and clamping



Guhring's system 104/106/108/110 is unique in terms of insert positioning and clamping: The position between cutting edge facing up and cutting edge facing down can be changed by keeping the same length position without loosening the holder.

Definition of the cutting edge position



Internal threading System GG104/GG106/GG108

| Pitch/P | | Recommended number of cuts with internal threading | | | | | | |
|---------|------|--|----------|--------|-----------------|-----------|-----------------------|-----------|
| | | Steel materials (tensile strength in N/mm ²) | | | Stainless steel | Cast iron | Heat-resistant alloys | Aluminium |
| mm | Gg/° | 400-700 | 700-1150 | > 1150 | | | | |
| 0.3 | | 3 | 4 | 5 | 5 | 3 | 5 | 3 |
| 0.5 | 48 | 5 | 6 | 8 | 8 | 5 | 8 | 5 |
| 0.8 | 32 | 7 | 8 | 9 | 9 | 7 | 9 | 7 |
| 1 | 24 | 8 | 9 | 10 | 10 | 8 | 10 | 8 |
| 1.25 | 19 | 10 | 11 | 12 | 12 | 10 | 12 | 10 |
| 1.5 | 16 | 12 | 13 | 15 | 15 | 12 | 15 | 12 |
| 1.75 | 14 | 14 | 15 | 18 | 18 | 14 | 18 | 14 |
| 2 | 11 | 16 | 17 | 20 | 20 | 16 | 20 | 16 |
| 3 | 8 | 22 | 24 | 30 | 30 | 22 | 30 | 22 |

Feed direction internal threading

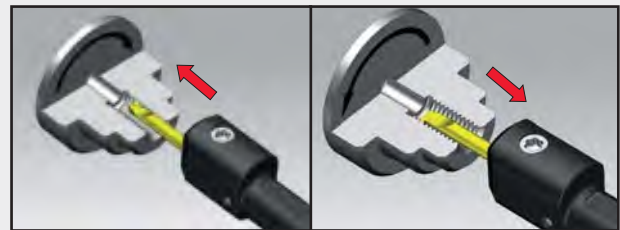
Right-hand thread



Insert: Right-hand design
Direction of rotation: Clockwise
M3 turning from outside in

Insert: Left-hand design
Direction of rotation: Anticlockwise
M4 turning from inside out

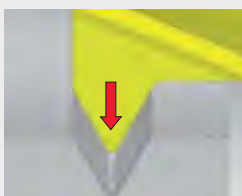
Left-hand thread



Insert: Left-hand design
Direction of rotation: Anticlockwise
M4 turning from outside in

Insert: Right-hand design
Direction of rotation: Clockwise
M3 turning from inside out

Feed process



Radial feed

- Both cutting edges engaged at the same time
- High cutting pressure and thermal load
- Especially suitable for the machining of short-chipping materials
- For the production of threads with a small pitch and small thread depth as well as multiple start depths to prevent pitch errors



One-sided flank in-feed

- Only one cutting edge engaged
- Lower cutting pressure and thermal load
- Especially suitable for the machining of long-chipping materials
- Achieving a higher surface finish quality at the respective thread flank



Reciprocal flank in-feed

- Both cutting edges alternately engaged
- Lower cutting pressure and thermal load
- Especially suitable for the machining of long-chipping materials
- Achieving a higher surface finish quality at the flanks



Internal threading System GG104/GG106/GG108

| Pre-drill-diameters for metrical threads | | | | | | |
|--|-------------|------------------------------------|--------------------------------------|-------------------|-------------|--|
| Regular pitch thread | | | | Fine pitch thread | | |
| Nominal-Ø | Pitch mm | Pre-drill-Ø* full profile mm | Pre-drill-Ø partial profile mm | Nominal-Ø | Pitch mm | Tapp. size hole Ø partial profile mm |
| M 2 | 0.40 | 1.50 | 1.60 | M 2 | 0.20 | 1.80 |
| M 2.5 | 0.45 | 1.85 | 2.05 | M 2.5 | 0.35 | 2.15 |
| M 3 | 0.50 | 2.40 | 2.50 | M 3 | 0.35 | 2.65 |
| M 4 | 0.7 | 3.10 | 3.30 | M 3.5 | 0.35 | 3.15 |
| M 4.5 | 0.75 | | 3.75 | M 4 | 0.50 | 3.50 |
| M 5 | 0.80 | 4.00 | 4.20 | M 4.5 | 0.50 | 4.00 |
| M 6 | 1.00 | | 5.00 | M 5 | 0.50 | 4.50 |
| M 8 | 1.25 | | 6.80 | M 5.5 | 0.50 | 5.00 |
| M 10 | 1.5 | | 8.5 | M 6 | 0.75 | 5.25 |
| M 12 | 1.75 | | 10.25 | | | |

*max. allowance (ap) in core diameter = 0.2 mm

Application example

| Application: Internal thread | Tool selection | Customer benefit |
|------------------------------|-----------------------------------|---|
| Component: Threaded sleeve | System: 106 | Guhring's cutting insert leads to considerably less manual re-working. The customer saves time and money. |
| Material: TiAl 6 V 4 | Holder: GB106.0016.090.00.22.N.IK | |
| 3.7165 | Insert: GG106.TM08.125.22.68.R | |
| Machine: Mazak Nexus 200 | | |
| Cooling: 12 bar | | |
| Operat.step: Threading | | |
| vc: 25 m/min | | |
| f: Pitch | | |
| ap: | | |
| Groov. depth: | | |

Broaching System GN104 and GN106

General hints

Please align the tool accurately.

The alignment surface on the tool holder GB104/106 is a great help.

Application instructions

- With blind holes a run-out groove / undercut or cross hole must be at the groove end to allow chip evacuation
- As a general rule the delivery of coolant (soluble or neat oil) helps the broaching process. It allows chips to be flushed out of the hole as well as increasing the surface finish quality of the slot and tool life.
- On the return stroke the tool must travel completely out of the slot.
- Pay attention to the feed Ø when programming the first stroke (load on the cutting corners).

Calculating the feed diameter Ø d1 for the first stroke

Example: Hole-Ø: 8 mm
Groove width: 5 mm
Safety distance between cutting corners and workpiece-Ø: 0,15 mm

$$r = \text{radius workpiece (hole-}\varnothing \text{ 8/2)} = 4$$

$$b = \text{Cutting edge / 2 (5/2)} = 2,5$$

$$\text{Feed radius} = \sqrt{r^2 - b^2} - \text{safety distance}$$

$$\text{Feed radius} = \sqrt{4^2 - 2,5^2} - 0,15 = 2,97$$

$$\text{Feed diameter } \varnothing d1 = 2.97 \times 2 = \varnothing 5.94$$

The feed diameter for the first stroke in the machining example above is Ø 5.94



Feed and feed rate

- The feed per stroke is dependent on the tensile strength of the material to be machined.
- The feed rate when broaching corresponds to the cutting speed and is controlled by the Z-axis of the machine.
- Achievable speeds are partly limited by the machine conditions.

| | Tensile strength (N/mm ²) | | | | | |
|----------------------|---------------------------------------|------|------|------|------|------|
| | 300 | 400 | 600 | 800 | 1000 | 1200 |
| Feed rate (mm/min) | 10000 | 8000 | 7000 | 6000 | 5000 | 4000 |
| Feed per stroke (mm) | 0.1 | 0.08 | 0.07 | 0.06 | 0.05 | 0.04 |

* Values are for guidance only. The machine condition, rigidity of component clamping as well as the workpiece material influence the cutting parameters.



Broaching

System GN104 and GN106

Sequence of machining

Broaching square profile:

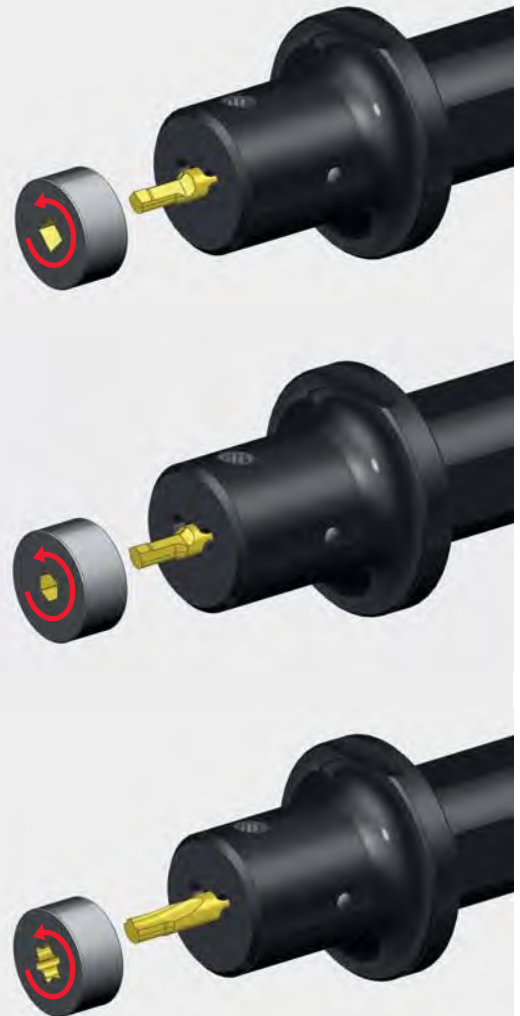
- The broaching inserts generate a 90° corner
- The component must be repositioned 4 times each 90° to complete the square profile

Broaching hexagon profile:

- The broaching inserts generate a 60° corner
- The component must be repositioned 6 times each 60° to complete the hexagon profile

Broaching Torx profile:

- The broaching inserts generate one section of the torx profile
- The component must be repositioned 6 times each 60° to complete the torx profile



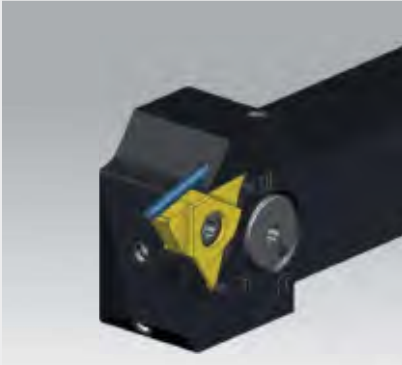
Application example

| Application: Hexagon broaching | Tool selection | Customer benefit |
|---|-----------------------------------|---|
| Component: Sleeve | System: 106 Special tool | The current process required a high amount of manual rework. Also the tool life was low. With the Gühring tool the customer achieves a very good surface with high tool life. Also there is no more manual rework required. |
| Material: X 10 CrNiS 18 9 | Holder: GB106.0025.075.00.22.S.IK | |
| 1.4305 | Insert: Special insert | |
| Machine: Spinner TC 65 | TiAlN nanoA | |
| Cooling: 20 bar | | |
| Operat. step: Semifinishing & finishing | | |
| vc: - | | |
| f: 3200 mm | | |
| ap: 0,06 | | |
| Groov. depth: SW 9.3 (special) | | |

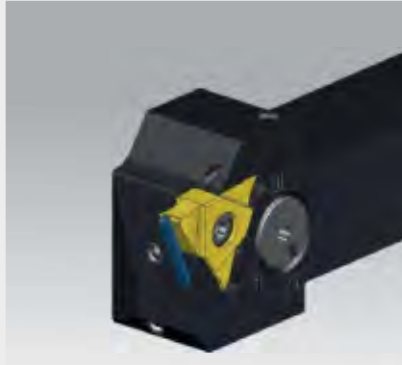
Application hints for holder GH305...EST with adjustable coolant supply



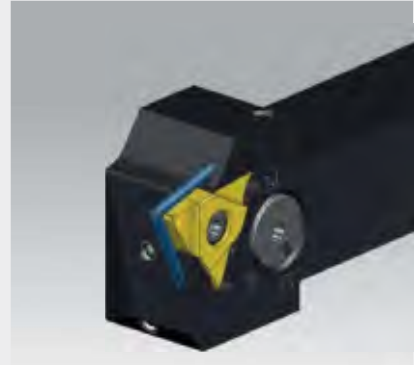
The adjustable valve directs the coolant to the cutting edge as follows:



Coolant supply directed to the rake face



Coolant supply directed to the clearance face



Coolant supply directed to both spots

The GH305 . . . EST is Guhring's patent pending grooving holder with internal coolant.

What makes it worth the effort?

- You can optimally provide your process with coolant even at low coolant pressure:
 - first choice is the coolant supply to the rake face
 - if chips interfere or prevent coolant delivery, the temperature can be effectively controlled by cooling the clearance face.
- With high coolant pressure we recommend cooling from both coolant holes:
 - cooling the rake face can positively influence chip fracture
 - clearance face coolant additionally maintains the temperature of the cutting edge

Application example

| Application: External grooving radial | Tool selection | Customer benefit |
|--|---------------------------------------|---|
| Component: Piston | System: 305 | Guhring's precision ground insert offers more tool life than the just sintered product of the competitor. Additionally the customer reported better chip formation as well as improved surface quality. |
| Material: 17 CrNiM0 6 | Holder: GH305.2020.125.00.04.R.IK.EST | |
| 1.6587 | Insert: GE305.0200.020.BA.04.N | |
| Machine: Mazak Quick Turn Smart 200 | | |
| Cooling: 20 bar | | |
| Operat. step: groov. 58 HRC, 0.8mm case d. | | |
| vc: 40 m/min | | |
| f: 0.06 mm | | |
| ap: | | |
| Groov. depth: 3 mm | | |



Conversion Table Inch-Millimeter from 1/64 to 11 63/64

| Size (Inch) | mm | Part of Inch (decimal) | Size (Inch) | mm | Part of Inch (decimal) | Size (Inch) | mm | Part of Inch (decimal) | Size (Inch) | mm | Part of Inch (decimal) |
|-------------|------|------------------------|-------------|------|------------------------|-------------|-------|------------------------|-------------|-------|------------------------|
| - | 0.10 | 0.0039 | 51 | 1.70 | 0.0670 | 4 | 5.31 | 0.2090 | - | 14.00 | 0.5512 |
| 97 | 0.15 | 0.0059 | | 1.75 | 0.0689 | 3 | 5.41 | 0.213 | 9/16 | 14.29 | 0.5625 |
| 96 | 0.16 | 0.0063 | 50 | 1.78 | 0.0700 | | 5.50 | 0.2165 | | 14.50 | 0.5709 |
| 95 | 0.17 | 0.0067 | | 1.80 | 0.0709 | 7/32 | 5.56 | 0.2188 | 37/64 | 14.68 | 0.5781 |
| 94 | 0.18 | 0.0071 | 49 | 1.85 | 0.0730 | 2 | 5.61 | 0.221 | - | 15.00 | 0.5906 |
| 93 | 0.19 | 0.0075 | | 1.90 | 0.0748 | 1 | 5.79 | 0.228 | 19/32 | 15.08 | 0.5938 |
| 92 | 0.20 | 0.0079 | 48 | 1.93 | 0.0760 | A | 5.94 | 0.234 | 39/64 | 15.48 | 0.6094 |
| 91 | 0.21 | 0.0083 | | 1.95 | 0.0768 | 15/64 | 5.95 | 0.2344 | | 15.50 | 0.6102 |
| 90 | 0.22 | 0.0087 | 5/64 | 1.98 | 0.0781 | - | 6.00 | 0.2362 | 5/8 | 15.88 | 0.625 |
| 89 | 0.23 | 0.0091 | 47 | 1.99 | 0.0785 | B | 6.05 | 0.238 | - | 16.00 | 0.6299 |
| 88 | 0.24 | 0.0095 | - | 2.00 | 0.0787 | C | 6.15 | 0.242 | 41/64 | 16.27 | 0.6406 |
| - | 0.25 | 0.0098 | | 2.05 | 0.0807 | D | 6.25 | 0.246 | | 16.50 | 0.6496 |
| 87 | 0.25 | 0.0100 | 46 | 2.06 | 0.0810 | 1/4 | 6.35 | 0.25 | 21/32 | 16.67 | 0.6562 |
| | 0.26 | 0.0102 | 45 | 2.08 | 0.0820 | E | 6.35 | 0.25 | - | 17.00 | 0.6693 |
| 86 | 0.27 | 0.0105 | | 2.15 | 0.0846 | | 6.50 | 0.2559 | 43/64 | 17.07 | 0.6719 |
| | 0.27 | 0.0106 | 44 | 2.18 | 0.0860 | F | 6.53 | 0.257 | 11/16 | 17.46 | 0.6875 |
| 85 | 0.28 | 0.0110 | 43 | 2.26 | 0.0890 | G | 6.63 | 0.261 | | 17.50 | 0.689 |
| | 0.29 | 0.0114 | 42 | 2.37 | 0.0935 | 17/64 | 6.75 | 0.2656 | 45/64 | 17.86 | 0.7031 |
| 84 | 0.29 | 0.0115 | 3/32 | 2.38 | 0.0938 | | 6.75 | 0.2657 | - | 18.00 | 0.7087 |
| - | 0.30 | 0.0118 | 41 | 2.44 | 0.0960 | H | 6.76 | 0.266 | 23/32 | 18.26 | 0.7188 |
| 83 | 0.30 | 0.0120 | 40 | 2.50 | 0.0980 | I | 6.91 | 0.272 | | 18.50 | 0.7283 |
| 82 | 0.32 | 0.0125 | 39 | 2.53 | 0.0995 | - | 7.00 | 0.2756 | 47/64 | 18.65 | 0.7344 |
| | 0.32 | 0.0126 | 38 | 2.58 | 0.1015 | J | 7.04 | 0.2772 | - | 19.00 | 0.748 |
| 81 | 0.33 | 0.0130 | 37 | 2.64 | 0.1040 | K | 7.14 | 0.281 | 3/4 | 19.05 | 0.75 |
| 80 | 0.34 | 0.0135 | 36 | 2.71 | 0.1065 | 9/32 | 7.14 | 0.2812 | 49/64 | 19.45 | 0.7656 |
| 79 | 0.37 | 0.0145 | 7/64 | 2.78 | 0.1094 | L | 7.37 | 0.29 | | 19.50 | 0.7677 |
| 1/64 | 0.40 | 0.0156 | 35 | 2.79 | 0.11 | M | 7.49 | 0.2949 | 25/32 | 19.84 | 0.7812 |
| 78 | 0.41 | 0.0160 | 34 | 2.82 | 0.111 | | 7.50 | 0.2953 | - | 20.00 | 0.7874 |
| 77 | 0.46 | 0.0180 | 33 | 2.87 | 0.113 | 19/64 | 7.54 | 0.2969 | 51/64 | 20.24 | 0.7969 |
| - | 0.50 | 0.0197 | | 2.90 | 0.1142 | N | 7.67 | 0.3020 | | 20.50 | 0.8071 |
| 76 | 0.51 | 0.0200 | 32 | 2.95 | 0.116 | | 7.75 | 0.3051 | 13/16 | 20.64 | 0.8125 |
| 75 | 0.53 | 0.0210 | - | 3.00 | 0.1181 | 5/16 | 7.94 | 0.3125 | - | 21.00 | 0.8268 |
| 74 | 0.57 | 0.0225 | 31 | 3.05 | 0.12 | - | 8.00 | 0.315 | 53/64 | 21.03 | 0.8281 |
| - | 0.60 | 0.0236 | 1/8 | 3.18 | 0.125 | O | 8.03 | 0.316 | 27/32 | 21.43 | 0.8438 |
| 73 | 0.61 | 0.0240 | 30 | 3.26 | 0.1285 | P | 8.20 | 0.323 | | 21.50 | 0.8465 |
| 72 | 0.64 | 0.0250 | | 3.30 | 0.1299 | 21/64 | 8.33 | 0.3281 | 55/64 | 21.84 | 0.8594 |
| 71 | 0.66 | 0.0260 | 29 | 3.45 | 0.136 | Q | 8.43 | 0.332 | - | 22.00 | 0.8661 |
| - | 0.70 | 0.0276 | | 3.50 | 0.1378 | | 8.50 | 0.3346 | 7/8 | 22.23 | 0.875 |
| 70 | 0.71 | 0.0280 | 28 | 3.57 | 0.1405 | R | 8.61 | 0.339 | | 22.50 | 0.8858 |
| 69 | 0.74 | 0.0292 | 9/64 | 3.57 | 0.1406 | 11/32 | 8.73 | 0.3438 | 57/64 | 22.62 | 0.8906 |
| - | 0.75 | 0.0295 | 27 | 3.66 | 0.144 | | 8.75 | 0.3445 | - | 23.00 | 0.9055 |
| 68 | 0.79 | 0.0310 | 26 | 3.73 | 0.147 | S | 8.84 | 0.348 | 29/32 | 23.02 | 0.9062 |
| 1/32 | 0.79 | 0.0313 | | 3.75 | 0.1476 | - | 9.00 | 0.3543 | 59/64 | 23.42 | 0.9219 |
| - | 0.80 | 0.0315 | 25 | 3.80 | 0.1495 | T | 9.09 | 0.358 | | 23.50 | 0.9252 |
| 67 | 0.81 | 0.0320 | 24 | 3.86 | 0.152 | 23/64 | 9.13 | 0.3594 | 15/16 | 23.81 | 0.9375 |
| 66 | 0.84 | 0.0330 | 23 | 3.91 | 0.154 | U | 9.35 | 0.368 | - | 24.00 | 0.9449 |
| 65 | 0.89 | 0.0350 | 5/32 | 3.97 | 0.1562 | | 9.50 | 0.374 | 61/64 | 24.21 | 0.9531 |
| - | 0.90 | 0.0354 | 22 | 3.99 | 0.157 | 3/8 | 9.53 | 0.375 | | 24.50 | 0.9646 |
| 64 | 0.91 | 0.0360 | - | 4.00 | 0.1575 | V | 9.56 | 0.377 | 31/32 | 24.61 | 0.9688 |
| 63 | 0.94 | 0.0370 | 21 | 4.04 | 0.159 | W | 9.80 | 0.386 | - | 25.00 | 0.9843 |
| 62 | 0.97 | 0.0380 | 20 | 4.09 | 0.161 | 25/64 | 9.92 | 0.3906 | 63/64 | 25.00 | 0.9844 |
| 61 | 0.99 | 0.0390 | | 4.20 | 0.1654 | - | 10.00 | 0.3937 | 1 | 25.40 | 1.00 |
| - | 1.00 | 0.0394 | 19 | 4.22 | 0.166 | X | 10.08 | 0.397 | | | |
| 60 | 1.02 | 0.0400 | 18 | 4.31 | 0.1695 | Y | 10.26 | 0.4040 | | | |
| 59 | 1.04 | 0.0410 | 11/64 | 4.37 | 0.1719 | 13/32 | 10.32 | 0.4062 | | | |
| 58 | 1.07 | 0.0420 | 17 | 4.39 | 0.173 | Z | 10.49 | 0.413 | | | |
| 57 | 1.09 | 0.0430 | 16 | 4.50 | 0.177 | | 10.50 | 0.4134 | | | |
| 56 | 1.18 | 0.0465 | 15 | 4.57 | 0.18 | 27/64 | 10.72 | 0.4219 | | | |
| 3/64 | 1.19 | 0.0469 | 14 | 4.62 | 0.182 | - | 11.00 | 0.4331 | | | |
| | 1.20 | 0.0472 | 13 | 4.70 | 0.185 | 7/16 | 11.11 | 0.4375 | | | |
| | 1.25 | 0.0492 | 3/16 | 4.76 | 0.1875 | | 11.50 | 0.4528 | | | |
| | 1.30 | 0.0512 | 12 | 4.80 | 0.189 | 29/64 | 11.51 | 0.4531 | | | |
| 55 | 1.32 | 0.0520 | 11 | 4.85 | 0.191 | 15/32 | 11.91 | 0.4688 | | | |
| 54 | 1.40 | 0.0550 | 10 | 4.91 | 0.1935 | - | 12.00 | 0.4724 | | | |
| | 1.45 | 0.0571 | 9 | 4.98 | 0.196 | 31/64 | 12.30 | 0.4844 | | | |
| | 1.50 | 0.0591 | - | 5.00 | 0.1968 | | 12.50 | 0.4921 | | | |
| 53 | 1.51 | 0.0595 | 8 | 5.05 | 0.199 | 1/2 | 12.70 | 0.50 | | | |
| | 1.55 | 0.0610 | 7 | 5.11 | 0.2010 | - | 13.00 | 0.5118 | | | |
| 1/16 | 1.59 | 0.0625 | 13/64 | 5.16 | 0.2031 | 33/64 | 13.10 | 0.5156 | | | |
| | 1.60 | 0.0630 | 6 | 5.18 | 0.2040 | 17/32 | 13.49 | 0.5312 | | | |
| 52 | 1.61 | 0.0635 | 5 | 5.22 | 0.2055 | | 13.50 | 0.5315 | | | |
| | 1.65 | 0.0650 | | 5.25 | 0.2067 | 35/64 | 13.89 | 0.5469 | | | |

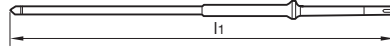
Torque wrenches



Article no. **4915**

| Size | Nm | l1 mm | Code no. |
|------|-----|----------|----------|
| 1/4 | 2-8 | 200.000 | 8.000 |

Torx-Plus interchangeable blade



Article no. **4960**

| Size | Nm | l1 mm | Code no. |
|--------|----|----------|----------|
| 6,6 NM | | 175.000 | 15.000 |

Torx-Plus screwdriver



- Key with T-handle code no. 15.000
- Allen key code no. 15.001



Article no. **25904**

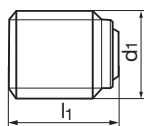
| Size | l1 mm | Code no. |
|------|----------|----------|
| 15IP | 65.000 | 15.000 |
| 15IP | 97.000 | 15.001 |



Clamping screws



• for system
104/106/108/110



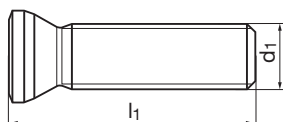
Article no. **25900**

| Size | d1 | l1 | Code no. |
|------|----|-------|----------|
| | | mm | |
| 15IP | M6 | 7.500 | 6.000 |

Clamping screws



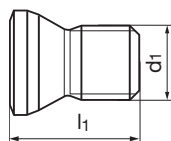
• for system 305



Article no. **25901**

| Size | d1 | l1 | Code no. |
|------|-----------|--------|----------|
| | | mm | |
| 15IP | M4 | 15.000 | 4.000 |
| 15IP | M4 | 22.000 | 4.001 |
| 15IP | M4 x 0,35 | 11.000 | 4.002 |
| 15IP | M4 x 0,5 | 17.000 | 4.003 |

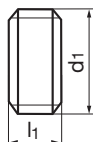
Clamping screws



Article no. **25902**

| Size | d1 | l1 | Code no. |
|------|----|--------|----------|
| | | mm | |
| 15IP | M4 | 15.000 | 4.000 |
| 15IP | M4 | 7.000 | 4.001 |

Activation screws



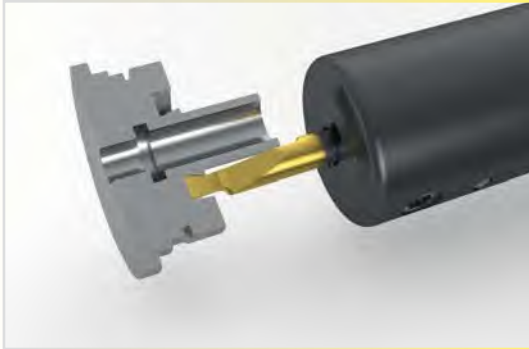
Article no. **25905**

| Size | d1 | l1 | Code no. |
|------|------|-------|----------|
| | | mm | |
| SW 4 | G1/8 | 5.000 | 5.000 |



SPECIAL SOLUTIONS made to measure

SYSTEM 104



Face grooving and copying dovetail grooving

Insert: GA 104



Internal threading

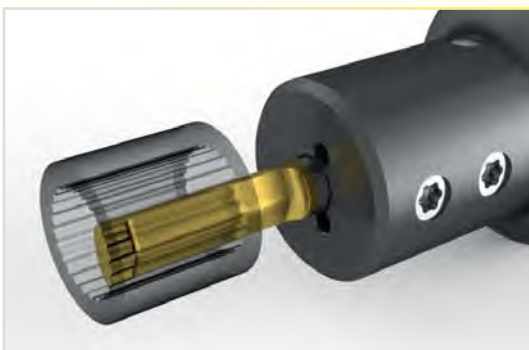
Insert: GG 104

SYSTEM 106



Copying a radius at the bottom of a bore on a turning centre

Insert: GT 106



Broaching an internal spline, pre- and finish-cutter in one tool

Insert: GN 106



SYSTEM 305



Broaching an internal longitudinal grooves from hole \varnothing 30 mm,

i.e. for profile forms or tooth profiles

Clamping holder and indexable insert type 305



External/internal circular milling of form recesses

Milling body and indexable insert type 305



Indexable insert type 305, basic width 4.2 mm

Grooving with external edge chamfering,
form width up to 4.2 mm, form depth up to 4 mm



Indexable insert type 305, basic width 6.2 mm

Two grooves in one operation,
form width up to 6.2 mm, form depth up to 4 mm



Indexable insert type 305, basic width 8.2 mm

Profile form insert, external contour,
form width up to 8.2 mm, form depth up to 4 mm



Indexable insert type 305, basic width 12.2 mm

Profile form insert, external contour,
form width up to 12.2 mm, form depth up to 4 mm

| Article no. | Page | Type | Description | Tool material | Standard |
|-------------|------|--------|---|---------------|--------------|
| 4915 | 196 | | Torque wrenches | | Company std. |
| 4960 | 196 | | Torx-Plus interchangeable blade | | Company std. |
| 25000 | 16 | GB 104 | Round shank holder, clamping screw top | | Company std. |
| 25001 | 17 | GB 104 | Round shank holder, clamping screw lateral | | Company std. |
| 25002 | 23 | GH 104 | Square shank holder, 90° offset | | Company std. |
| 25003 | 23 | GH 104 | Square shank holder, 90° offset | | Company std. |
| 25006 | 28 | GB 104 | Round shank holder, 4 clamping surfaces | | Company std. |
| 25010 | 25 | GH 104 | Polygon shank holder, to ISO 26623, straight 0° | | Company std. |
| 25012 | 26 | GH 104 | Polygon shank holder, to ISO 26623, off-set 90° | | Company std. |
| 25013 | 26 | GH 104 | Polygon shank holder, to ISO 26623, off-set 90° | | Company std. |
| 25016 | 27 | GH 104 | HSK-T holder, to ISO 12164-3, straight 0° | | Company std. |
| 25017 | 19 | GB 104 | Round shank holder, clamping screw above, without clamping surfaces | | Company std. |
| 25018 | 18 | GB 104 | Round shank holder, clamping screw above, four clamping surfaces | | Company std. |
| 25019 | 24 | GH 104 | Square shank holder, straight 0° | | Company std. |
| 25020 | 24 | GH 104 | Square shank holder, straight 0° | | Company std. |
| 25021 | 20 | GB 104 | Round shank holder, clamping screw above, for Citizen machine | | Company std. |
| 25022 | 21 | GB 104 | Round shank holder, clamping screw above, for Star machine | | Company std. |
| 25023 | 22 | GB 104 | Round shank holder, clamping screw above, for Tornos machine | | Company std. |
| 25050 | 29 | GT 104 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25051 | 30 | GT 104 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25052 | 29 | GT 104 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25053 | 30 | GT 104 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25056 | 29 | GT 104 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25057 | 30 | GT 104 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25058 | 31 | GT 104 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25059 | 32 | GT 104 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25060 | 31 | GT 104 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25061 | 32 | GT 104 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25064 | 31 | GT 104 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25065 | 32 | GT 104 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25066 | 33 | GT 104 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25067 | 34 | GT 104 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25068 | 33 | GT 104 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25069 | 34 | GT 104 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25072 | 33 | GT 104 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25073 | 34 | GT 104 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25074 | 35 | GT 104 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25075 | 35 | GT 104 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25076 | 35 | GT 104 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25077 | 35 | GT 104 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25080 | 35 | GT 104 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25081 | 35 | GT 104 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25082 | 37 | GT 104 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25083 | 37 | GT 104 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25084 | 37 | GT 104 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25085 | 37 | GT 104 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25088 | 37 | GT 104 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25089 | 37 | GT 104 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25090 | 39 | GJ 104 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25091 | 39 | GJ 104 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25092 | 39 | GJ 104 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25093 | 39 | GJ 104 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25096 | 39 | GJ 104 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25097 | 39 | GJ 104 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25106 | 40 | GT 104 | Cutting insert for back boring and profiling | Solid carbide | Company std. |
| 25107 | 40 | GT 104 | Cutting insert for back boring and profiling | Solid carbide | Company std. |
| 25108 | 40 | GT 104 | Cutting insert for back boring and profiling | Solid carbide | Company std. |
| 25109 | 40 | GT 104 | Cutting insert for back boring and profiling | Solid carbide | Company std. |
| 25112 | 40 | GT 104 | Cutting insert for back boring and profiling | Solid carbide | Company std. |
| 25113 | 40 | GT 104 | Cutting insert for back boring and profiling | Solid carbide | Company std. |
| 25114 | 42 | GT 104 | Cutting insert for boring out and chamfering | Solid carbide | Company std. |
| 25115 | 42 | GT 104 | Cutting insert for boring out and chamfering | Solid carbide | Company std. |
| 25116 | 42 | GT 104 | Cutting insert for boring out and chamfering | Solid carbide | Company std. |
| 25117 | 42 | GT 104 | Cutting insert for boring out and chamfering | Solid carbide | Company std. |
| 25120 | 42 | GT 104 | Cutting insert for boring out and chamfering | Solid carbide | Company std. |
| 25121 | 42 | GT 104 | Cutting insert for boring out and chamfering | Solid carbide | Company std. |
| 25124 | 43 | GE 104 | Cutting insert for internal grooving, straight slots | Solid carbide | Company std. |
| 25125 | 43 | GE 104 | Cutting insert for internal grooving, straight slots | Solid carbide | Company std. |
| 25126 | 43 | GE 104 | Cutting insert for internal grooving, straight slots | Solid carbide | Company std. |
| 25127 | 43 | GE 104 | Cutting insert for internal grooving, straight slots | Solid carbide | Company std. |
| 25130 | 43 | GE 104 | Cutting insert for internal grooving, straight slots | Solid carbide | Company std. |
| 25131 | 43 | GE 104 | Cutting insert for internal grooving, straight slots | Solid carbide | Company std. |

| Article no. | Page | Type | Description | Tool material | Standard |
|-------------|------|--------|--|---------------|--------------|
| 25228 | 57 | GN 104 | Cutting insert for internal hexagon | Solid carbide | Company std. |
| 25229 | 57 | GN 104 | Cutting insert for internal hexagon | Solid carbide | Company std. |
| 25231 | 57 | GN 104 | Cutting insert for internal hexagon | Solid carbide | Company std. |
| 25232 | 58 | GN 104 | Cutting insert for internal square | Solid carbide | Company std. |
| 25233 | 58 | GN 104 | Cutting insert for internal square | Solid carbide | Company std. |
| 25235 | 58 | GN 104 | Cutting insert for internal square | Solid carbide | Company std. |
| 25236 | 59 | GN 104 | Cutting insert for Torx | Solid carbide | Company std. |
| 25237 | 59 | GN 104 | Cutting insert for Torx | Solid carbide | Company std. |
| 25239 | 59 | GN 104 | Cutting insert for Torx | Solid carbide | Company std. |
| 25300 | 62 | GB 106 | Round shank holder, clamping screw top | | Company std. |
| 25301 | 63 | GB 106 | Round shank holder, clamping screw lateral | | Company std. |
| 25302 | 74 | GB 106 | Round shank holder, 4 clamping surfaces | | Company std. |
| 25304 | 70 | GH 106 | Square shank holder, 90° offset | | Company std. |
| 25305 | 70 | GH 106 | Square shank holder, 90° offset | | Company std. |
| 25307 | 71 | GH 106 | Polygon shank holder, to ISO 26623, straight 0° | | Company std. |
| 25308 | 72 | GH 106 | Polygon shank holder, to ISO 26623, off-set 90° | | Company std. |
| 25309 | 72 | GH 106 | Polygon shank holder, to ISO 26623, off-set 90° | | Company std. |
| 25311 | 73 | GH 106 | HSK-T holder, to ISO 12164-3, straight 0° | | Company std. |
| 25314 | 69 | GH 106 | Square shank holder, straight 0° | | Company std. |
| 25315 | 69 | GH 106 | Square shank holder, straight 0° | | Company std. |
| 25316 | 66 | GB 106 | Round shank holder, clamping screw above, for Citizen machine | | Company std. |
| 25317 | 67 | GB 106 | Round shank holder, clamping screw above, for Star machine | | Company std. |
| 25318 | 68 | GB 106 | Round shank holder, clamping screw above, for Tornos machine | | Company std. |
| 25319 | 65 | GB 106 | Round shank holder, clamping screw above, without clamping surfaces | | Company std. |
| 25320 | 64 | GB 106 | Round shank holder, clamping screw above, four clamping surfaces | | Company std. |
| 25350 | 156 | GH 305 | Square shank holder straight, external machining, without IC | | Company std. |
| 25351 | 157 | GH 305 | Square shank holder straight, external machining, without IC | | Company std. |
| 25352 | 158 | GH 305 | Square shank holder straight, external machining, with IC | | Company std. |
| 25353 | 159 | GH 305 | Square shank holder straight, external machining, with IC | | Company std. |
| 25356 | 161 | GH 305 | Square shank holder 90° offset, external machining, without IC | | Company std. |
| 25357 | 162 | GH 305 | Square shank holder 90° offset, external machining, without IC | | Company std. |
| 25358 | 163 | GH 305 | Square shank holder 90° offset, external machining, with IC | | Company std. |
| 25359 | 164 | GH 305 | Square shank holder 90° offset, external machining, with IC | | Company std. |
| 25362 | 165 | GH 305 | Square shank holder 45° offset, external machining, without IC | | Company std. |
| 25363 | 165 | GH 305 | Square shank holder 45° offset, external machining, without IC | | Company std. |
| 25364 | 166 | GH 305 | Square shank holder 45° offset, external machining, with IC | | Company std. |
| 25365 | 166 | GH 305 | Square shank holder 45° offset, external machining, with IC | | Company std. |
| 25368 | 167 | GB 305 | Round shank holder, internal machining, without IC | | Company std. |
| 25369 | 167 | GB 305 | Round shank holder, internal machining, without IC | | Company std. |
| 25370 | 169 | GB 305 | Round shank holder, internal machining, with IC | | Company std. |
| 25371 | 169 | GB 305 | Round shank holder, internal machining, with IC | | Company std. |
| 25372 | 160 | GH 305 | Square shank holder straight, external machining, IC adjustable | | Company std. |
| 25373 | 160 | GH 305 | Square shank holder straight, external machining, IC adjustable | | Company std. |
| 25500 | 88 | GT 106 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25501 | 89 | GT 106 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25502 | 88 | GT 106 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25503 | 89 | GT 106 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25506 | 88 | GT 106 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25507 | 89 | GT 106 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25508 | 90 | GT 106 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25509 | 91 | GT 106 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25510 | 90 | GT 106 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25511 | 91 | GT 106 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25514 | 90 | GT 106 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25515 | 91 | GT 106 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25516 | 86 | GT 106 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25517 | 87 | GT 106 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25518 | 86 | GT 106 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25519 | 87 | GT 106 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25522 | 86 | GT 106 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25523 | 87 | GT 106 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25601 | 171 | GE 305 | Indexable insert for radial grooving external and internal | Solid carbide | Company std. |
| 25602 | 171 | GE 305 | Indexable insert for radial grooving external and internal | Solid carbide | Company std. |
| 25603 | 171 | GE 305 | Indexable insert for radial grooving external and internal | Solid carbide | Company std. |
| 25605 | 172 | GE 305 | Indexable insert for radial grooving and copying external and internal | Solid carbide | Company std. |
| 25606 | 172 | GE 305 | Indexable insert for radial grooving and copying external and internal | Solid carbide | Company std. |
| 25607 | 172 | GE 305 | Indexable insert for radial grooving and copying external and internal | Solid carbide | Company std. |
| 25613 | 173 | GE 305 | Indexable insert for radial grooving and copying external and internal | Solid carbide | Company std. |
| 25614 | 173 | GE 305 | Indexable insert for radial grooving and copying external and internal | Solid carbide | Company std. |
| 25615 | 173 | GE 305 | Indexable insert for radial grooving and copying external and internal | Solid carbide | Company std. |
| 25618 | 176 | GA 305 | Indexable insert for grooving axial external recesses | Solid carbide | Company std. |
| 25619 | 176 | GA 305 | Indexable insert for grooving axial external recesses | Solid carbide | Company std. |



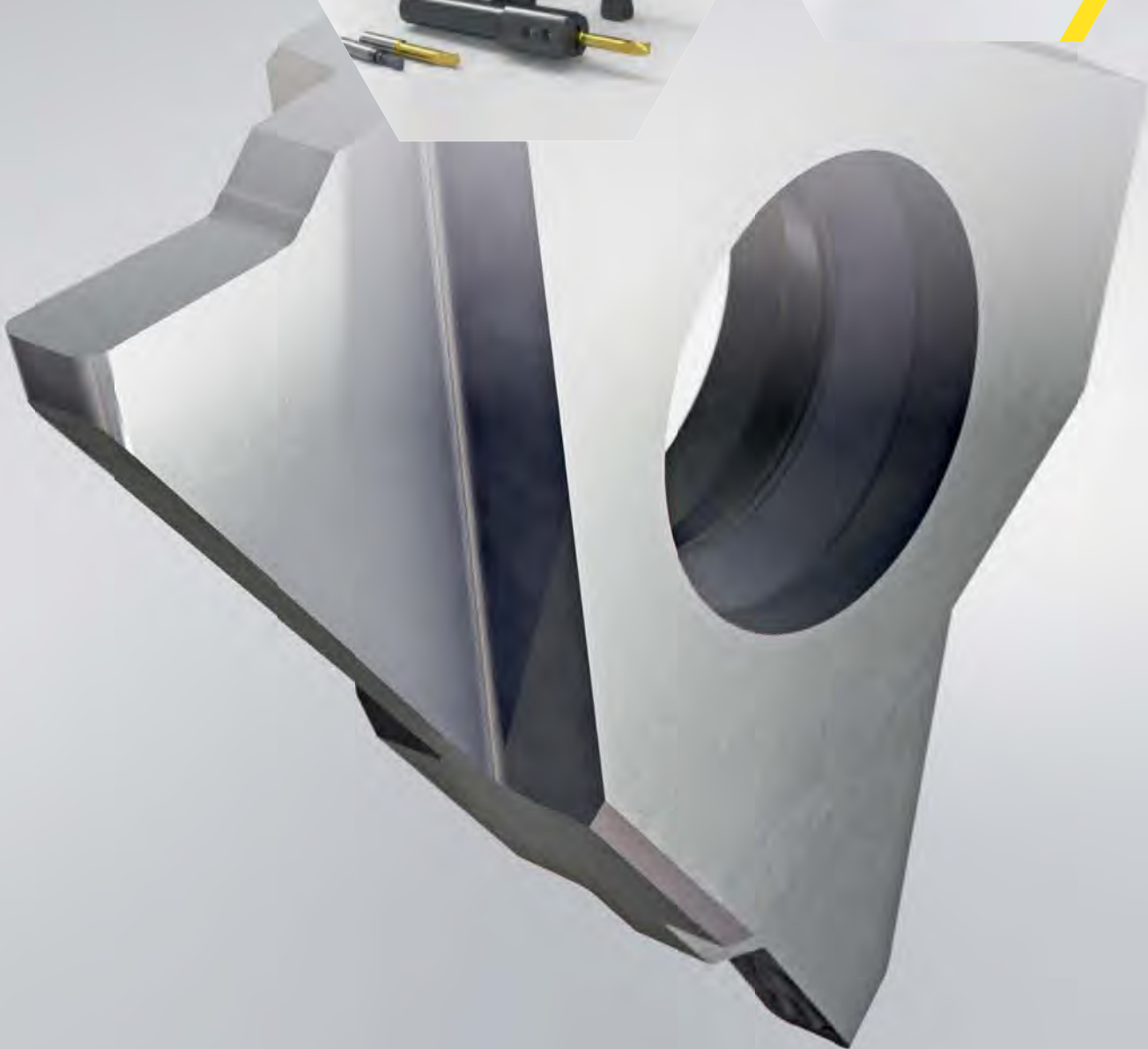
| Article no. | Page | Type | Description | Tool material | Standard |
|-------------|------|--------|---|---------------|--------------|
| 25850 | 92 | GJ 106 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25851 | 93 | GJ 106 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25854 | 92 | GJ 106 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25855 | 93 | GJ 106 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25856 | 96 | GT 106 | Cutting insert for back boring and profiling | Solid carbide | Company std. |
| 25857 | 96 | GT 106 | Cutting insert for back boring and profiling | Solid carbide | Company std. |
| 25858 | 96 | GT 106 | Cutting insert for back boring and profiling | Solid carbide | Company std. |
| 25859 | 96 | GT 106 | Cutting insert for back boring and profiling | Solid carbide | Company std. |
| 25862 | 96 | GT 106 | Cutting insert for back boring and profiling | Solid carbide | Company std. |
| 25863 | 96 | GT 106 | Cutting insert for back boring and profiling | Solid carbide | Company std. |
| 25864 | 98 | GT 106 | Cutting insert for boring out and chamfering | Solid carbide | Company std. |
| 25865 | 99 | GT 106 | Cutting insert for boring out and chamfering | Solid carbide | Company std. |
| 25866 | 98 | GT 106 | Cutting insert for boring out and chamfering | Solid carbide | Company std. |
| 25867 | 99 | GT 106 | Cutting insert for boring out and chamfering | Solid carbide | Company std. |
| 25870 | 98 | GT 106 | Cutting insert for boring out and chamfering | Solid carbide | Company std. |
| 25871 | 99 | GT 106 | Cutting insert for boring out and chamfering | Solid carbide | Company std. |
| 25872 | 102 | GE 106 | Cutting insert for internal grooving, straight slots | Solid carbide | Company std. |
| 25873 | 102 | GE 106 | Cutting insert for internal grooving, straight slots | Solid carbide | Company std. |
| 25874 | 102 | GE 106 | Cutting insert for internal grooving, straight slots | Solid carbide | Company std. |
| 25875 | 102 | GE 106 | Cutting insert for internal grooving, straight slots | Solid carbide | Company std. |
| 25878 | 102 | GE 106 | Cutting insert for internal grooving, straight slots | Solid carbide | Company std. |
| 25879 | 102 | GE 106 | Cutting insert for internal grooving, straight slots | Solid carbide | Company std. |
| 25880 | 106 | GE 106 | Cutting insert for internal grooving, full radius slots | Solid carbide | Company std. |
| 25881 | 106 | GE 106 | Cutting insert for internal grooving, full radius slots | Solid carbide | Company std. |
| 25882 | 106 | GE 106 | Cutting insert for internal grooving, full radius slots | Solid carbide | Company std. |
| 25883 | 106 | GE 106 | Cutting insert for internal grooving, full radius slots | Solid carbide | Company std. |
| 25886 | 106 | GE 106 | Cutting insert for internal grooving, full radius slots | Solid carbide | Company std. |
| 25887 | 106 | GE 106 | Cutting insert for internal grooving, full radius slots | Solid carbide | Company std. |
| 25888 | 84 | GT 106 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25889 | 85 | GT 106 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25890 | 84 | GT 106 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25891 | 85 | GT 106 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25894 | 84 | GT 106 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25895 | 85 | GT 106 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 25896 | 120 | GN 106 | Cutting insert for internal hexagon | Solid carbide | Company std. |
| 25897 | 120 | GN 106 | Cutting insert for internal hexagon | Solid carbide | Company std. |
| 25898 | 120 | GN 106 | Cutting insert for internal hexagon | Solid carbide | Company std. |
| 25900 | 197 | | Clamping screws | | Company std. |
| 25901 | 197 | | Clamping screws | | Company std. |
| 25902 | 197 | | Clamping screws | | Company std. |
| 25904 | 196 | | Torx-Plus screwdriver | | Company std. |
| 25905 | 197 | | Activation screws | | Company std. |
| 27000 | 124 | GB 108 | Round shank holder, clamping screw top | | Company std. |
| 27001 | 125 | GB 108 | Round shank holder, clamping screw lateral | | Company std. |
| 27002 | 126 | GB 108 | Round shank holder, clamping screw above, four clamping surfaces | | Company std. |
| 27003 | 127 | GB 108 | Round shank holder, clamping screw above, without clamping surfaces | | Company std. |
| 27007 | 128 | GH 108 | Square shank holder, straight 0° | | Company std. |
| 27008 | 128 | GH 108 | Square shank holder, straight 0° | | Company std. |
| 27009 | 129 | GH 108 | Square shank holder, 90° offset | | Company std. |
| 27010 | 129 | GH 108 | Square shank holder, 90° offset | | Company std. |
| 27050 | 151 | GB 110 | Round shank holder, clamping screw top | | Company std. |
| 27051 | 152 | GB 110 | Round shank holder, clamping screw lateral | | Company std. |
| 27100 | 130 | GT 108 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 27101 | 130 | GT 108 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 27102 | 130 | GT 108 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 27103 | 130 | GT 108 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 27104 | 132 | GT 108 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 27105 | 132 | GT 108 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 27106 | 132 | GT 108 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 27107 | 132 | GT 108 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 27108 | 134 | GT 108 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 27109 | 134 | GT 108 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 27110 | 134 | GT 108 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 27111 | 134 | GT 108 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 27116 | 136 | GJ 108 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 27117 | 136 | GJ 108 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 27118 | 136 | GJ 108 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 27119 | 136 | GJ 108 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 27120 | 138 | GT 108 | Cutting insert for back boring and profiling | Solid carbide | Company std. |
| 27121 | 138 | GT 108 | Cutting insert for back boring and profiling | Solid carbide | Company std. |
| 27122 | 138 | GT 108 | Cutting insert for back boring and profiling | Solid carbide | Company std. |
| 27123 | 138 | GT 108 | Cutting insert for back boring and profiling | Solid carbide | Company std. |



| Article no. | Page | Type | Description | Tool material | Standard |
|-------------|------|--------|---|---------------|--------------|
| 27124 | 140 | GE 108 | Cutting insert for internal grooving, straight slots | Solid carbide | Company std. |
| 27125 | 140 | GE 108 | Cutting insert for internal grooving, straight slots | Solid carbide | Company std. |
| 27126 | 140 | GE 108 | Cutting insert for internal grooving, straight slots | Solid carbide | Company std. |
| 27127 | 140 | GE 108 | Cutting insert for internal grooving, straight slots | Solid carbide | Company std. |
| 27128 | 144 | GE 108 | Cutting insert for internal grooving, full radius slots | Solid carbide | Company std. |
| 27129 | 144 | GE 108 | Cutting insert for internal grooving, full radius slots | Solid carbide | Company std. |
| 27130 | 144 | GE 108 | Cutting insert for internal grooving, full radius slots | Solid carbide | Company std. |
| 27131 | 144 | GE 108 | Cutting insert for internal grooving, full radius slots | Solid carbide | Company std. |
| 27200 | 131 | GT 108 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 27201 | 131 | GT 108 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 27202 | 131 | GT 108 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 27203 | 131 | GT 108 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 27204 | 133 | GT 108 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 27205 | 133 | GT 108 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 27206 | 133 | GT 108 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 27207 | 133 | GT 108 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 27208 | 135 | GT 108 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 27209 | 135 | GT 108 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 27210 | 135 | GT 108 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 27211 | 135 | GT 108 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 27216 | 137 | GJ 108 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 27217 | 137 | GJ 108 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 27218 | 137 | GJ 108 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 27219 | 137 | GJ 108 | Cutting insert for boring out and profiling | Solid carbide | Company std. |
| 27220 | 139 | GT 108 | Cutting insert for back boring and profiling | Solid carbide | Company std. |
| 27221 | 139 | GT 108 | Cutting insert for back boring and profiling | Solid carbide | Company std. |
| 27222 | 139 | GT 108 | Cutting insert for back boring and profiling | Solid carbide | Company std. |
| 27223 | 139 | GT 108 | Cutting insert for back boring and profiling | Solid carbide | Company std. |
| 27224 | 142 | GE 108 | Cutting insert for internal grooving, straight slots | Solid carbide | Company std. |
| 27225 | 142 | GE 108 | Cutting insert for internal grooving, straight slots | Solid carbide | Company std. |
| 27226 | 142 | GE 108 | Cutting insert for internal grooving, straight slots | Solid carbide | Company std. |
| 27227 | 142 | GE 108 | Cutting insert for internal grooving, straight slots | Solid carbide | Company std. |
| 27228 | 146 | GE 108 | Cutting insert for internal grooving, full radius slots | Solid carbide | Company std. |
| 27229 | 146 | GE 108 | Cutting insert for internal grooving, full radius slots | Solid carbide | Company std. |
| 27230 | 146 | GE 108 | Cutting insert for internal grooving, full radius slots | Solid carbide | Company std. |
| 27231 | 146 | GE 108 | Cutting insert for internal grooving, full radius slots | Solid carbide | Company std. |



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