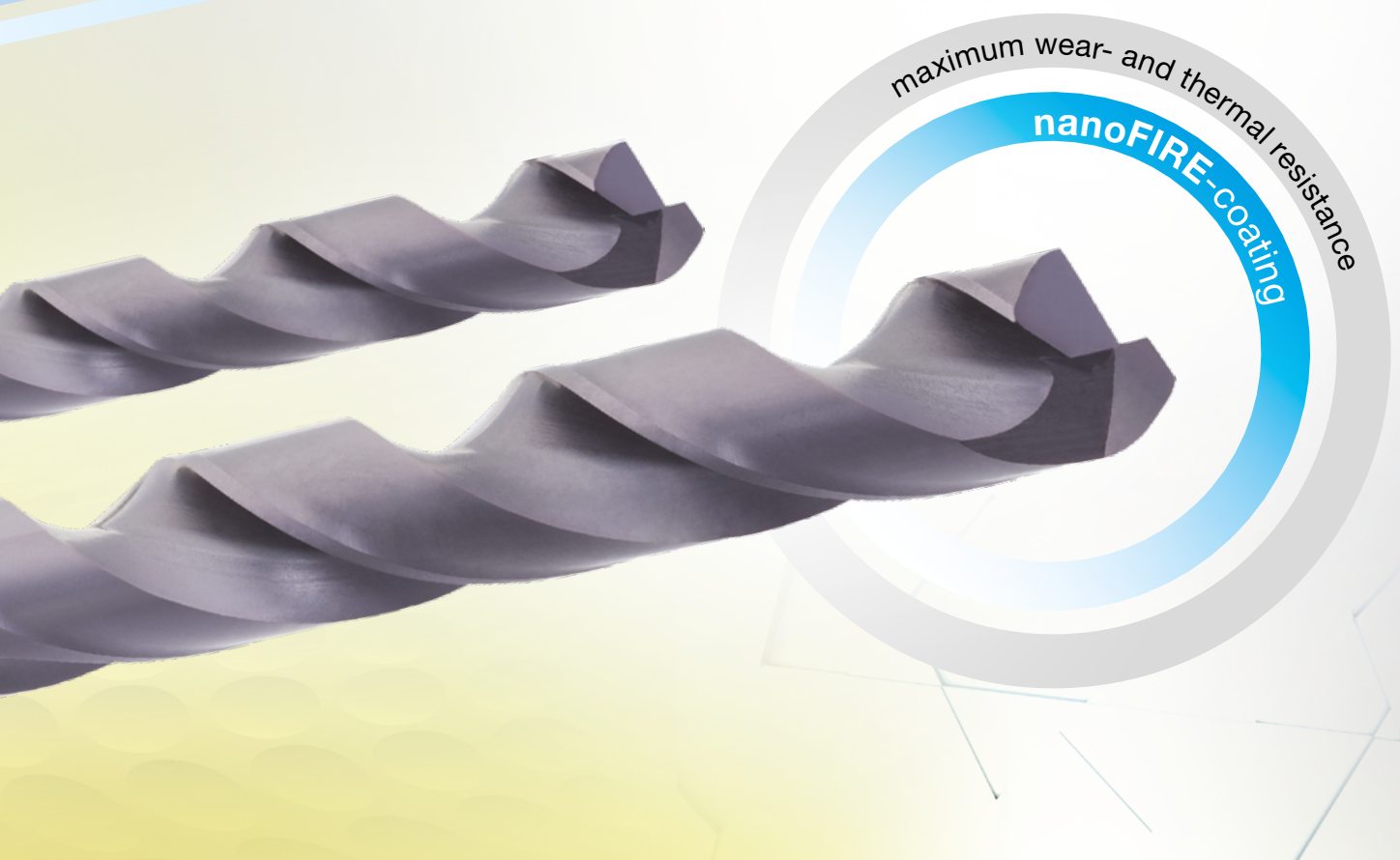


# GUHRING

- nanoFIRE-coating for maximum performance in **high-alloyed materials and special alloys**
- 8% cobalt-alloyed HSCO steel for **maximum performance at high temperatures**
- especially stable tool design with 135° split point



## M42-Twist drill

for the machining of high-alloyed,  
high-tensile materials and special alloys

GUHRING – YOUR WORLD-WIDE PARTNER

## M42-Twist drill

for the machining of high-alloyed,  
high-tensile materials and special alloys

- standard range
- Ø 1.00 - 16.00 mm

### Very stable drill design

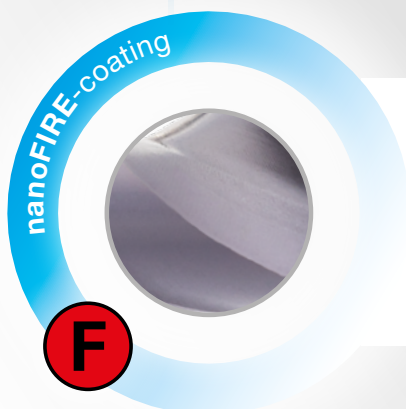
Specially reinforced core for  
maximum tool stability in  
difficult-to-machine materials

### Tool material

8% cobalt-alloyed high-speed  
steel for longer tool life and  
high thermal resistance enables  
operations in difficult-to-machine  
materials or at high temperatures

### 135°-split point

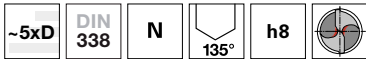
accurate spotting without centre  
punching or centering



As well as nitrogen and titanium the multi-layer nanoFIRE-coating also contains aluminium which provides the extreme thermal- and wear-resistance property in the established Guhring coating. It features a high hardness and possesses an outstanding thermo-chemical resistance making nanoFIRE predominantly suitable for the machining of high-tensile and high-alloyed materials.



**Jobber drills**



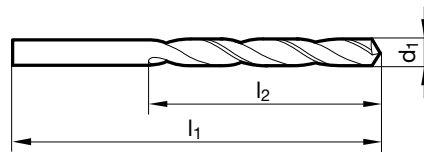
Tool material **M42**

Surface finish **F**

Cutting direction **R**

Discount group 139

- P** • Web thinning  $\geq \varnothing$  1.000 mm • optimised split point • 8% cobalt-alloyed HSCO high speed steel • especially high wear-resistance
- M** •
- K** • Hard/high-tensile alloy on CrNi basis • special alloys Hastelloy, Inconel, Nimonic • stainless-/acid-/heat-resistant steels • wear-resistant sheet metal • steel/bronze up to 1400 N/mm<sup>2</sup>
- N** ○
- S** •
- H** •



Guhring no. **1199**

d1		l1	l2	Availability	d1		l1	l2	Availability	d1		l1	l2	Availability
mm	inch	mm	mm		mm	inch	mm	mm		mm	inch	mm	mm	
1.000		34.00	12.00	•	4.760	3/16	86.00	52.00	•	8.500		117.00	75.00	•
1.100		36.00	14.00	•	4.800		86.00	52.00	•	8.600		125.00	81.00	•
1.200		38.00	16.00	•	4.900		86.00	52.00	•	8.700		125.00	81.00	•
1.300		38.00	16.00	•	5.000		86.00	52.00	•	8.730		125.00	81.00	•
1.400		40.00	18.00	•	5.100		86.00	52.00	•	8.800		125.00	81.00	•
1.500		40.00	18.00	•	5.160	13/64	86.00	52.00	•	8.900		125.00	81.00	•
1.590	1/16	43.00	20.00	•	5.200		86.00	52.00	•	9.000		125.00	81.00	•
1.600		43.00	20.00	•	5.300		86.00	52.00	•	9.100		125.00	81.00	•
1.700		43.00	20.00	•	5.400		93.00	57.00	•	9.200		125.00	81.00	•
1.800		46.00	22.00	•	5.500		93.00	57.00	•	9.300		125.00	81.00	•
1.900		46.00	22.00	•	5.600		93.00	57.00	•	9.400		125.00	81.00	•
2.000		49.00	24.00	•	5.700		93.00	57.00	•	9.500		125.00	81.00	•
2.100		49.00	24.00	•	5.800		93.00	57.00	•	9.600		133.00	87.00	•
2.200		53.00	27.00	•	5.900		93.00	57.00	•	9.700		133.00	87.00	•
2.300		53.00	27.00	•	5.950	15/64	93.00	57.00	•	9.800		133.00	87.00	•
2.380	3/32	57.00	30.00	•	6.000		93.00	57.00	•	9.900		133.00	87.00	•
2.400		57.00	30.00	•	6.100		101.00	63.00	•	9.920	25/64	133.00	87.00	•
2.500		57.00	30.00	•	6.200		101.00	63.00	•	10.000		133.00	87.00	•
2.600		57.00	30.00	•	6.300		101.00	63.00	•	10.100		133.00	87.00	•
2.700		61.00	33.00	•	6.350	1/4	101.00	63.00	•	10.200		133.00	87.00	•
2.800		61.00	33.00	•	6.400		101.00	63.00	•	10.500		133.00	87.00	•
2.900		61.00	33.00	•	6.500		101.00	63.00	•	10.800		142.00	94.00	•
3.000		61.00	33.00	•	6.600		101.00	63.00	•	11.000		142.00	94.00	•
3.100		65.00	36.00	•	6.700		101.00	63.00	•	11.200		142.00	94.00	•
3.170	1/8	65.00	36.00	•	6.750	17/64	109.00	69.00	•	11.500		142.00	94.00	•
3.200		65.00	36.00	•	6.800		109.00	69.00	•	11.800		142.00	94.00	•
3.300		65.00	36.00	•	6.900		109.00	69.00	•	11.910	15/32	151.00	101.00	•
3.400		70.00	39.00	•	7.000		109.00	69.00	•	12.000		151.00	101.00	•
3.500		70.00	39.00	•	7.100		109.00	69.00	•	12.200		151.00	101.00	•
3.600		70.00	39.00	•	7.200		109.00	69.00	•	12.500		151.00	101.00	•
3.700		70.00	39.00	•	7.300		109.00	69.00	•	13.000		151.00	101.00	•
3.800		75.00	43.00	•	7.400		109.00	69.00	•	14.000		160.00	108.00	•
3.900		75.00	43.00	•	7.500		109.00	69.00	•	15.000		169.00	114.00	•
3.970	5/32	75.00	43.00	•	7.600		117.00	75.00	•	16.000		178.00	120.00	•
4.000		75.00	43.00	•	7.700		117.00	75.00	•					
4.100		75.00	43.00	•	7.800		117.00	75.00	•					
4.200		75.00	43.00	•	7.900		117.00	75.00	•					
4.300		80.00	47.00	•	8.000		117.00	75.00	•					
4.400		80.00	47.00	•	8.100		117.00	75.00	•					
4.500		80.00	47.00	•	8.200		117.00	75.00	•					
4.600		80.00	47.00	•	8.300		117.00	75.00	•					
4.700		80.00	47.00	•	8.400		117.00	75.00	•					

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