



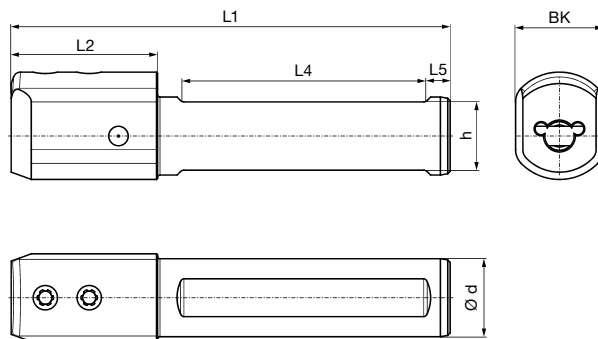
Round shank holder, clamping screw top

Series no. **25300**

- for inserts type 106
- with internal coolant delivery

Type GB 106

System 106



Code no.	Description	d	d	h	L1	L2	L4	L5	BK
		mm	inch	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		1/2	11.00	89.92	26.67	54.86	5.08	13.9
6.016	GB106.0625.354.00.22.N.IK		5/8	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		3/4	17.04	105.41	26.67	69.85	5.08	N/A
6.004	GB106.0020.095.00.22.N.IK	20.00		18.00	95.00	30.00	55.00	5.00	N/A
6.005	GB106.0022.095.00.22.N.IK	22.00		20.00	95.00	N/A	55.00	5.00	N/A
6.006	GB106.0025.100.00.22.N.IK	25.00		23.00	100.00	N/A	55.00	5.00	N/A
6.018	GB106.1000.415.00.22.N.IK		1"	23.39	105.41	N/A	69.85	5.08	N/A

Spare parts

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

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



SYSTEM 106

MICRO-PRECISION TOOLS



Round shank holder

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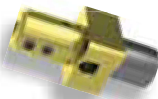
Square shank holder

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Modular holder

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Star holders
Backworking

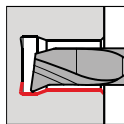
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Round shank holder
Broaching

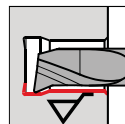
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Tool holder



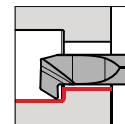
Boring out
and profiling, Type GT

from page 83



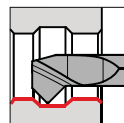
Boring out,
with Wiper, Type GJ

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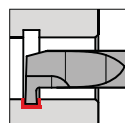
Back boring
and profiling, Type GT

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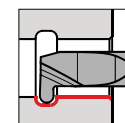
Boring out
and chamfering, Type GT

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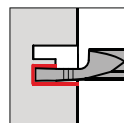
Internal grooving,
straight slots, Type GE

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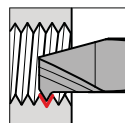
Internal grooving,
full radius slots, Type GE

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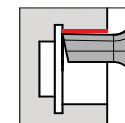
Axial grooving bores,
Type GA

from page 118



Internal threading,
Type GG

from page 123



Broaching,
Type GN

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Cutting inserts from hole-Ø 5 mm

Machining	Feed range f (IPR)	Point radius R (mm)	Cutting depth a _p (in)	General formulas
  	0.0008 - 0.0031	R 0.05 (0.002in) R 0.10 (0.004in) R 0.15 (0.006in) R 0.20 (0.008in) R 0.25 (0.010in) R 0.30 (0.012in)	0.0008 - 0.0028 0.0020 - 0.0059 0.0031 - 0.0079 0.0047 - 0.0098 0.0051 - 0.0110 0.0067 - 0.0138	Cutting speed (SFM) RPM x Dia. / 3.82 = SFM
  	0.0004 - 0.0012			Revolutions per minute (RPM) SFM x 3.82 / Dia. = RPM
  	0.0004 - 0.0020		Rule of thumb: a _p ~ r	Feed rate (IPM) IPR x RPM = IPM

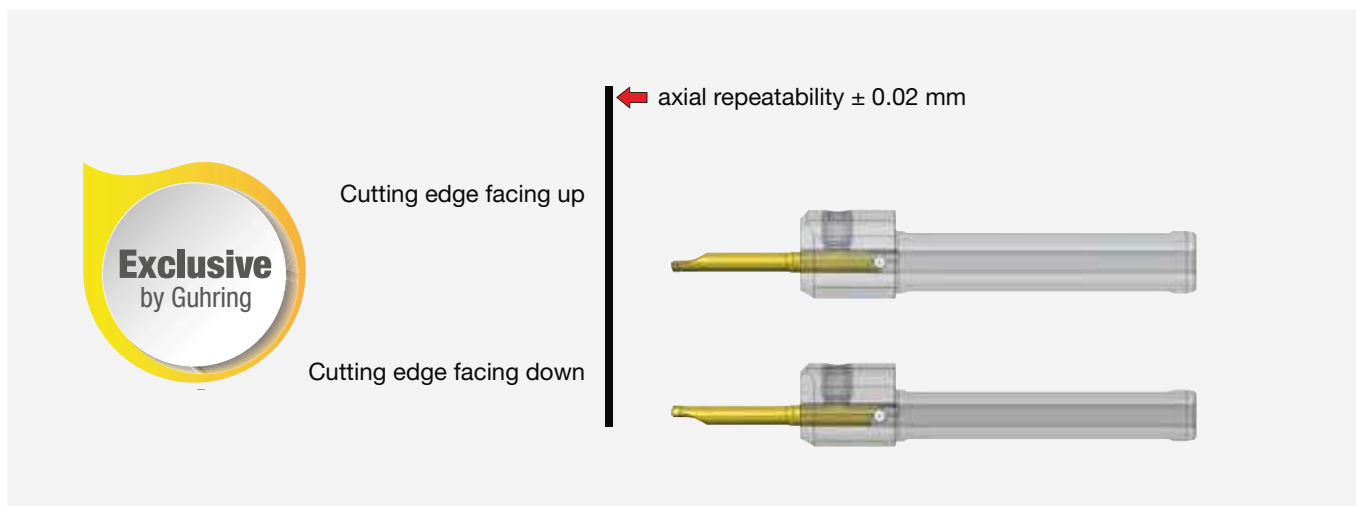
Guide values for feed and cutting depths

ISO	Material		Material examples/ material number	Tensile strength (N/mm ²)	Brinell hardness (HB)	Cutting speed SFM (surface feet / min)		
						TiN Ⓢ	nano-A Ⓢ	uncoated ○
P	Carbon steel	C ≤ 0.15 %	11SMn30+C / 1.0715 C15 / 1.0401	500 600	150 180	65-525	165-655	50-295
		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	65-295	165-525	-
	Low-alloyed steel (alloy content ≤ 5%)	annealed	16MnCr5 / 1.7131 18CrNi8 / 1.5920	650 650	200 200	65-525	165-590	50-230
		heat-treatable	25CrMoV4 / 1.7218 42CrMo4V / 1.7225	900 1100	270 320	-	100-395	-
	High-alloyed steel (alloy content > 5%)	annealed	X37CrMoV5-1 / 1.2343 X153CrMoV12 / 1.2379	750 850	220 250	80-295	130-460	-
		heat-treatable	55NiCrMoV7 / 1.2714	1200	350	-	100-330	-
	Cast steel	un-alloyed, low-alloyed	GS52 / 1.0552	600	180	65-395	100-590	-
		high-alloyed	GX40CrNiSi22-10 / 1.4826	750	220	-	100-295	-
M	Stainless steel	martensitic, ferritic, tempered	X14CrMoS17 / 1.4104 X4CrNiMo16-5-1 / 1.4418	800 1000	240 300	65-230	100-295	-
			X5CrNi18-10 / 1.4301 X2CrNiMo17-12-2 / 1.4404	650	200	65-300	100-360	-
		austenitic, Ni > 8 %	X2CrNiMoCuN25-6-3 / 1.4507 X2CrNiMoN25-7-4 / 1.4410	850	250	-	100-330	-
		austenitic, ferritic (Duplex)						
K	Grey cast iron	low tensile strength	EN-GJL-200 (GG20) / 0.6020		180	100-490	100-590	100-295
		high tensile strength	EN-GJL-400 (GG40) / 0.6040		260	100-395	100-490	100-230
	Spheroidal graphite iron	low tensile strength	EN-GJS-400-15 (GGG40) / 0.7040		160	100-425	100-525	-
		high tensile strength	EN-GJS-700-2 (GGG70) / 0.7070		260	100-360	100-460	-
	Malleable cast iron	low tensile strength	EN-GJMW-350-4 (GTW35) / 0.8035		125	100-425	100-525	-
		high tensile strength	EN-GJMB-550-4 (GTS55) / 0.8155		250	100-360	100-460	-
N	Al-alloys	non-heat-treatable <12% Si	EN-AW-2017 (AlCuMg1) / 3.1325		60	100-1805	100-1805	100-820
		heat-treatable <12% Si	EN-AW-6082 (AlMgSi1) / 3.2315		100	100-1310	100-1310	100-590
	Al-cast-alloys	non-heat-treatable <12% Si	AlSi9Cu3 / 3.2163		80	100-1805	100-1805	100-820
		heat-treatable <12% Si	AlSi10Mg / 3.2383		100	100-1310	100-1310	100-590
	Copper alloys	brass, lead alloy	CuZn39Pb2 (MS58) / 2.0380	400	120	100-1310	100-1310	100-590
		bronze	CuSn6 / 2.1020	500	150	100-240	100-240	100-590
S	Heat resistant alloys, super alloys	NiFe-base, annealed	NiCr15Fe (Alloy600) / 2.4816	700		-	50-230	
		NiFe-base, hardened		950		-	50-165	
		NiCo-base, annealed	NiMo16Cr15W (Alloy C-276) / 2.4819	800		-	50-165	
		NiCo-base, cast		1100		-	30-130	-
		NiCo-base, hardened	NiCr19NbMo (Alloy718) / 2.4668	1200		-	30-115	
	Titanium-alloys	annealed	Ti6Al4V / 3.7164	900		-	15-165	
		hardened		1200		-	30-115	
H	Hardened steels	Heat-treatable steel			> 52 HRC	-	65-130	-
		Heat-treatable/case hardened steel			> 59 HRC	-	30-100	-
		Heat-treatable/case hardened steel			> 62 HRC	-	(CBN)	-

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

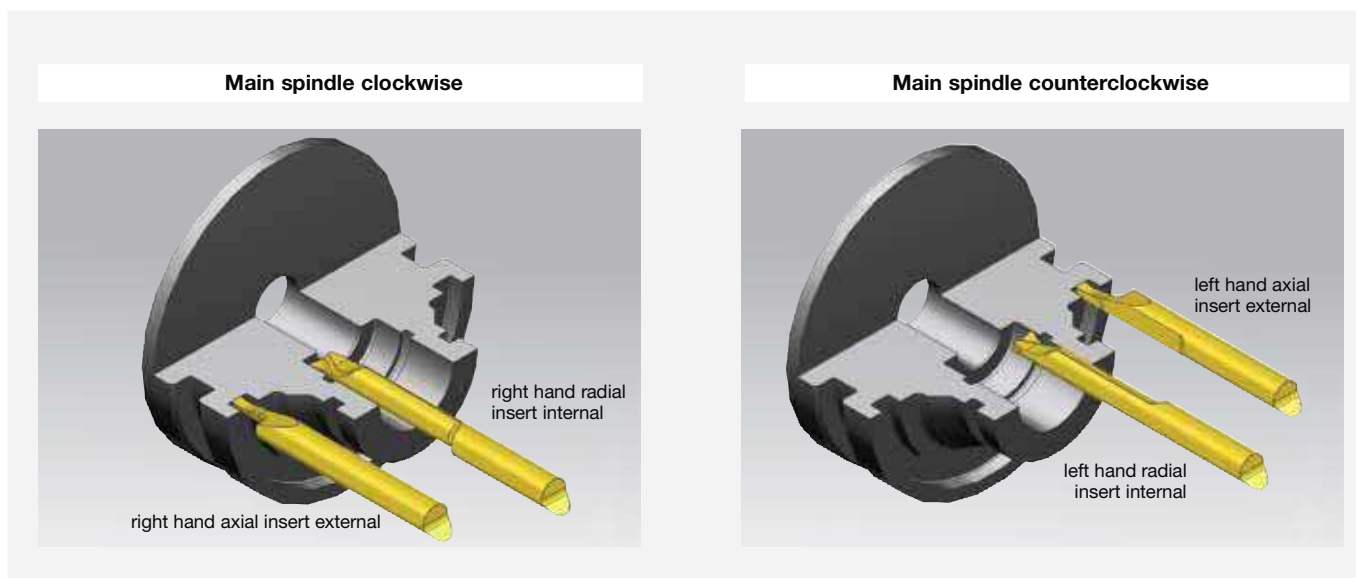


System 104/106/108/110 Positioning and clamping



Gühring'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





Troubleshooting

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