

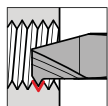


Cutting insert for internal threading, partial profile - metric standard threads

Series no.

25766

25770



- pitch $P = 1.25-1.75$
- $Dh6 = 6.00$ mm

for tool holders type GB106/GH106 see from page 70

Tool material

Solid carbide

Type

GG 106

GG 106

Coating

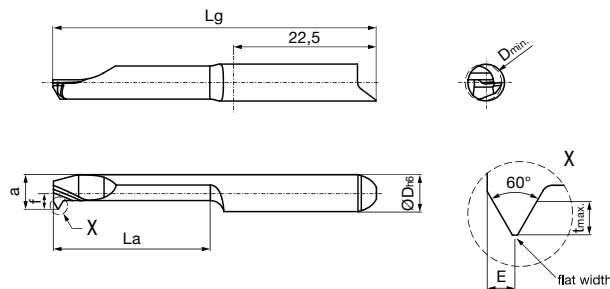
a

○

nano-A

uncoated

Cutting data page 214



Right hand version shown
Left hand version mirror image

Cutting direction



Code no.	Description	G	P	TPI	D min	f	E	a	flat width	t max	La	Lg
			mm		mm	mm	mm	mm	mm	mm	mm	mm
6.010	GG106.TM08.125.12.68.R	M8	1.25	20	6.80	2.95	0.70	5.95	0.146	0.70	12.00	37.00
6.001	GG106.TM08.125.17.68.R	M8	1.25	20	6.80	2.95	0.70	5.95	0.146	0.70	17.00	42.00
6.002	GG106.TM08.125.22.68.R	M8	1.25	20	6.80	2.95	0.70	5.95	0.146	0.70	22.00	47.00
6.003	GG106.TM08.125.27.68.R	M8	1.25	20	6.80	2.95	0.70	5.95	0.146	0.70	27.00	52.00
6.011	GG106.TM08.125.32.68.R	M8	1.25	20	6.80	2.95	0.70	5.95	0.146	0.70	32.00	57.00
6.012	GG106.TM08.125.37.68.R	M8	1.25	20	6.80	2.95	0.70	5.95	0.146	0.70	37.00	62.00
6.013	GG106.TM08.125.42.68.R	M8	1.25	20	6.80	2.95	0.70	5.95	0.146	0.70	42.00	67.00
6.014	GG106.TM10.150.12.85.R	M10	1.50	16	8.50	2.95	0.85	5.95	0.178	0.85	12.00	37.00
6.004	GG106.TM10.150.17.85.R	M10	1.50	16	8.50	2.95	0.85	5.95	0.178	0.85	17.00	42.00
6.005	GG106.TM10.150.22.85.R	M10	1.50	16	8.50	2.95	0.85	5.95	0.178	0.85	22.00	47.00
6.006	GG106.TM10.150.27.85.R	M10	1.50	16	8.50	2.95	0.85	5.95	0.178	0.85	27.00	52.00
6.015	GG106.TM10.150.32.85.R	M10	1.50	16	8.50	2.95	0.85	5.95	0.178	0.85	32.00	57.00
6.016	GG106.TM10.150.37.85.R	M10	1.50	16	8.50	2.95	0.85	5.95	0.178	0.85	37.00	62.00
6.017	GG106.TM10.150.42.85.R	M10	1.50	16	8.50	2.95	0.85	5.95	0.178	0.85	42.00	67.00
6.018	GG106.TM12.175.12.99.R	M12	1.75	14	10.20	2.95	1.00	5.95	0.209	1.00	12.00	37.00
6.007	GG106.TM12.175.17.99.R	M12	1.75	14	10.20	2.95	1.00	5.95	0.209	1.00	17.00	42.00
6.008	GG106.TM12.175.22.99.R	M12	1.75	14	10.20	2.95	1.00	5.95	0.209	1.00	22.00	47.00
6.009	GG106.TM12.175.27.99.R	M12	1.75	14	10.20	2.95	1.00	5.95	0.209	1.00	27.00	52.00
6.019	GG106.TM12.175.32.99.R	M12	1.75	14	10.20	2.95	1.00	5.95	0.209	1.00	32.00	57.00
6.020	GG106.TM12.175.37.99.R	M12	1.75	14	10.20	2.95	1.00	5.95	0.209	1.00	37.00	62.00
6.021	GG106.TM12.175.42.99.R	M12	1.75	14	10.20	2.95	1.00	5.95	0.209	1.00	42.00	67.00

Series no. **25767** **25771**Cutting direction  

System 106

Code no.	Description	G	P	TPI	D min	f	E	a	flat width	t max	La	Lg
			mm		mm	mm	mm	mm	mm	mm	mm	mm
6.010	GG106.TM08.125.12.68.L	M8	1.25	20	6.80	2.95	0.70	5.95	0.146	0.70	12.00	37.00
6.001	GG106.TM08.125.17.68.L	M8	1.25	20	6.80	2.95	0.70	5.95	0.146	0.70	17.00	42.00
6.002	GG106.TM08.125.22.68.L	M8	1.25	20	6.80	2.95	0.70	5.95	0.146	0.70	22.00	47.00
6.003	GG106.TM08.125.27.68.L	M8	1.25	20	6.80	2.95	0.70	5.95	0.146	0.70	27.00	52.00
6.011	GG106.TM08.125.32.68.L	M8	1.25	20	6.80	2.95	0.70	5.95	0.146	0.70	32.00	57.00
6.012	GG106.TM08.125.37.68.L	M8	1.25	20	6.80	2.95	0.70	5.95	0.146	0.70	37.00	62.00
6.013	GG106.TM08.125.42.68.L	M8	1.25	20	6.80	2.95	0.70	5.95	0.146	0.70	42.00	67.00
6.014	GG106.TM10.150.12.85.L	M10	1.50	16	8.50	2.95	0.85	5.95	0.178	0.85	12.00	37.00
6.004	GG106.TM10.150.17.85.L	M10	1.50	16	8.50	2.95	0.85	5.95	0.178	0.85	17.00	42.00
6.005	GG106.TM10.150.22.85.L	M10	1.50	16	8.50	2.95	0.85	5.95	0.178	0.85	22.00	47.00
6.006	GG106.TM10.150.27.85.L	M10	1.50	16	8.50	2.95	0.85	5.95	0.178	0.85	27.00	52.00
6.015	GG106.TM10.150.32.85.L	M10	1.50	16	8.50	2.95	0.85	5.95	0.178	0.85	32.00	57.00
6.016	GG106.TM10.150.37.85.L	M10	1.50	16	8.50	2.95	0.85	5.95	0.178	0.85	37.00	62.00
6.017	GG106.TM10.150.42.85.L	M10	1.50	16	8.50	2.95	0.85	5.95	0.178	0.85	42.00	67.00
6.018	GG106.TM12.175.12.99.L	M12	1.75	14	10.20	2.95	1.00	5.95	0.209	1.00	12.00	37.00
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6.008	GG106.TM12.175.22.99.L	M12	1.75	14	10.20	2.95	1.00	5.95	0.209	1.00	22.00	47.00
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6.019	GG106.TM12.175.32.99.L	M12	1.75	14	10.20	2.95	1.00	5.95	0.209	1.00	32.00	57.00
6.020	GG106.TM12.175.37.99.L	M12	1.75	14	10.20	2.95	1.00	5.95	0.209	1.00	37.00	62.00
6.021	GG106.TM12.175.42.99.L	M12	1.75	14	10.20	2.95	1.00	5.95	0.209	1.00	42.00	67.00



SYSTEM 106

MICRO-PRECISION TOOLS

System 106



Round shank holder

from page 70



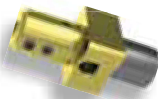
Square shank holder

from page 77



Modular holder

from page 79



Star holders
Backworking

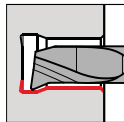
page 82



Round shank holder
Broaching

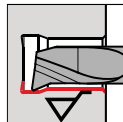
page 128

Tool holder



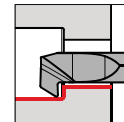
Boring out
and profiling, Type GT

from page 83



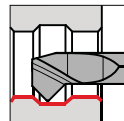
Boring out,
with Wiper, Type GJ

page 100



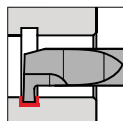
Back boring
and profiling, Type GT

page 104



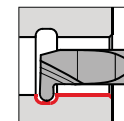
Boring out
and chamfering, Type GT

page 106



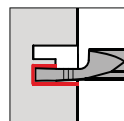
Internal grooving,
straight slots, Type GE

from page 110



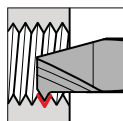
Internal grooving,
full radius slots, Type GE

from page 114



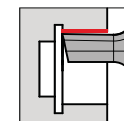
Axial grooving bores,
Type GA

from page 118



Internal threading,
Type GG

from page 123



Broaching,
Type GN

page 129

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

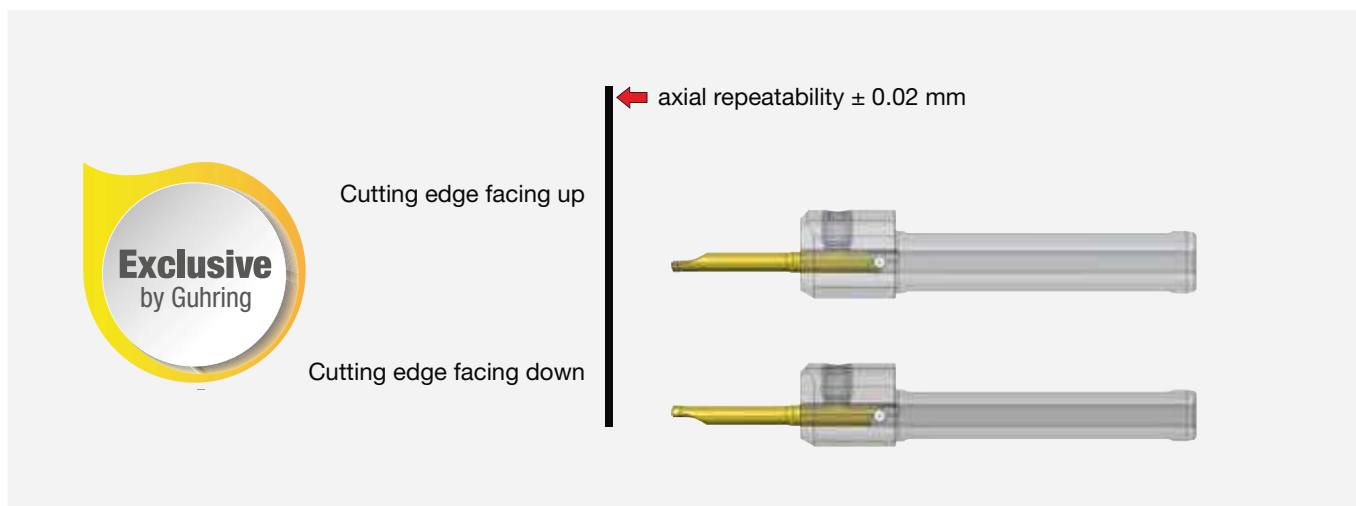
Guide values for feed and cutting depths

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, ferritic (Duplex)	X2CrNiMoCuN25-6-3 / 1.4507 X2CrNiMoN25-7-4 / 1.4410	850	250	-	100-330	-
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.

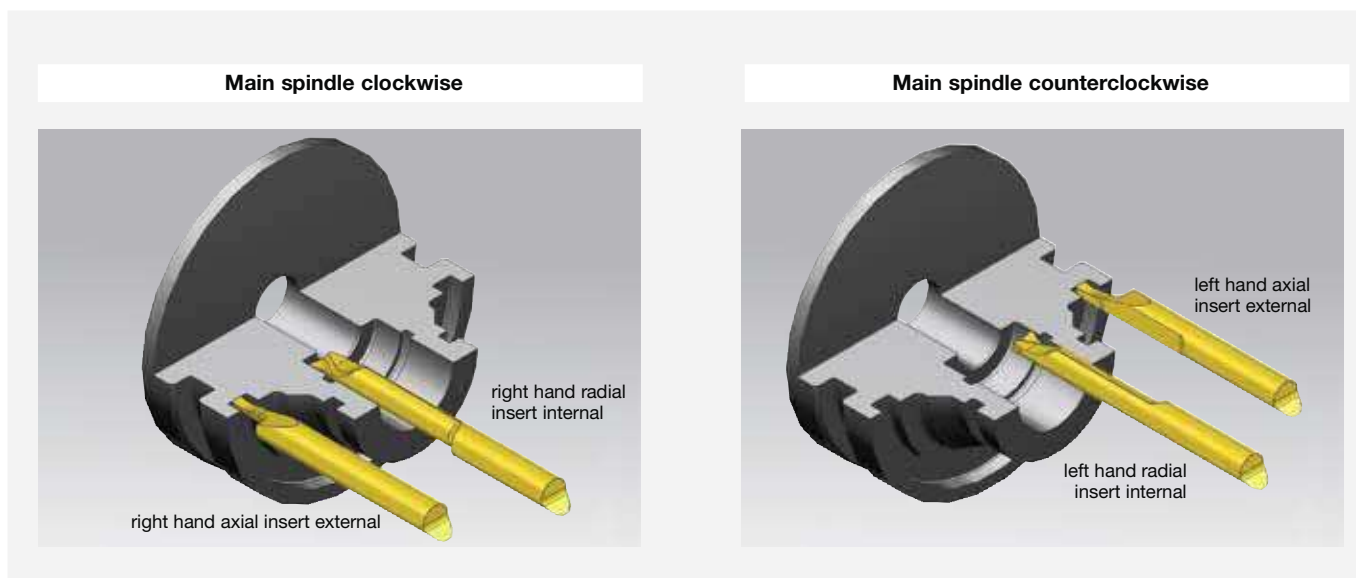


System 104/106/108/110 Positioning and clamping



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

Internal threading

System GG 104/106/108

		Recommended number of cuts with internal threading						
Pitch/P		Steel materials (tensile strength in N/mm ²)			Stainless steel	Cast iron	Heat-resistant alloys	Aluminium
mm	TPI	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	20	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	12	16	17	20	20	16	20	16
3	8	22	24	30	30	22	30	22

Feed direction internal threading

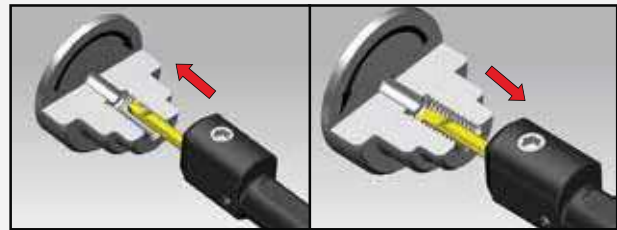
Right-hand thread



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

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

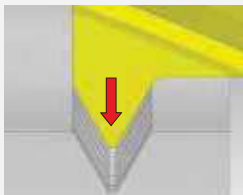
Left-hand thread



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

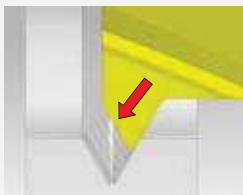
Insert: Right-hand design
Direction of rotation: Clockwise
M3 turning from inside out

Feed process



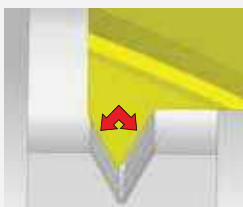
Radial feed

- 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
- Achieve 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
- Achieve a higher surface finish quality at the flanks



Internal threading

System GG 104/106/108

Pre-drill diameters for metric threads						
Standard 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	Pre-drill 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

Conversion table - pitch (in.) to pitch (mm)

TPI	Pitch, in	Pitch, mm	TPI	Pitch, in	Pitch, mm	TPI	Pitch, in	Pitch, mm	TPI	Pitch, in	Pitch, mm
127	0.00787	0.200	44	0.02273	0.577	20	0.05000	1.270	7	0.14286	3.629
120	0.00833	0.212	42.33	0.02362	0.600	19	0.05263	1.337	6.35	0.15748	4.000
112	0.00893	0.227	40	0.02500	0.635	18	0.05556	1.411	6	0.16667	4.233
101.6	0.00984	0.250	36.29	0.02756	0.700	16.93	0.05907	1.500	5.64	0.17730	4.504
100	0.01000	0.254	36	0.02778	0.706	16	0.06250	1.588	5.08	0.19685	5.000
96	0.01042	0.265	34	0.02941	0.747	14.51	0.06892	1.751	5	0.20000	5.080
90	0.01111	0.282	33.87	0.02952	0.750	14	0.07143	1.814	4.62	0.21645	5.498
84.67	0.01181	0.300	32	0.03125	0.794	13	0.07692	1.954	4.5	0.22222	5.644
80	0.01250	0.318	31.75	0.03150	0.800	12.7	0.07874	2.000	4.23	0.23641	6.005
72.57	0.01378	0.350	30	0.03333	0.847	12	0.08333	2.117	4	0.25000	6.350
72	0.01389	0.353	28.22	0.03544	0.900	11.5	0.08696	2.209	3	0.33333	8.467
64	0.01563	0.397	28	0.03571	0.907	11	0.09091	2.309	2	0.50000	1.270
63.5	0.01575	0.400	27	0.03704	0.941	10.16	0.09843	2.500			
60	0.01667	0.423	26	0.03846	0.977	10	0.10000	2.540			
56.44	0.01772	0.450	25.4	0.03937	1.000	9	0.11111	2.822			
56	0.01786	0.454	24	0.04167	1.058	8.47	0.11806	2.999			
50.8	0.01969	0.500	22	0.04545	1.155	8	0.12500	3.175			
48	0.02083	0.529	20.32	0.04921	1.250	7.26	0.13774	3.499			