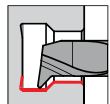




Cutting insert for boring out and profiling

Series no. **27204** **27206**• radial free 47°, t_{max} 1

for tool holders type GH108/GB108 see from page 134

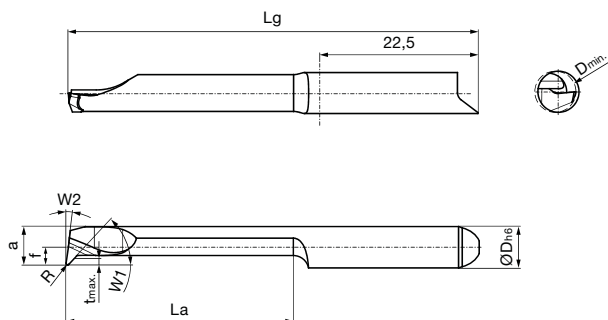
Tool material **Solid carbide**

Type GT 108 GT 108

Coating **a** ○

nano-A uncoated

Cutting data page 214

Right hand version shown
Left hand version mirror image

System 108

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

Series 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



SYSTEM 108

MICRO-PRECISION TOOLS



Round shank holder

from page 134



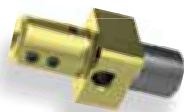
Square shank holder

from page 140



Modular holder

from page 142



Star holder

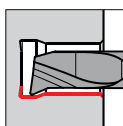
page 145



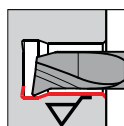
Round shank holder
Broaching

page 170

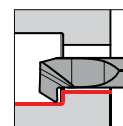
Tool holder



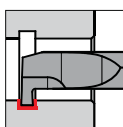
Boring out
and profiling, Type GT
from page 146



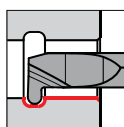
Boring out,
with Wiper, Type GJ
page 152



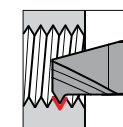
Back boring
and profiling, Type GT
page 154



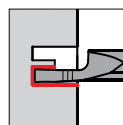
Internal grooving,
straight slots, Type GE
from page 156



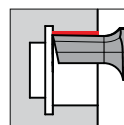
Internal grooving,
full radius slots, Type GE
from page 160



Internal threading,
Type GG
from page 164



Axial grooving bores,
Type GA
from page 166



Broaching,
Type GN
page 171

Cutting inserts from hole-Ø 7 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

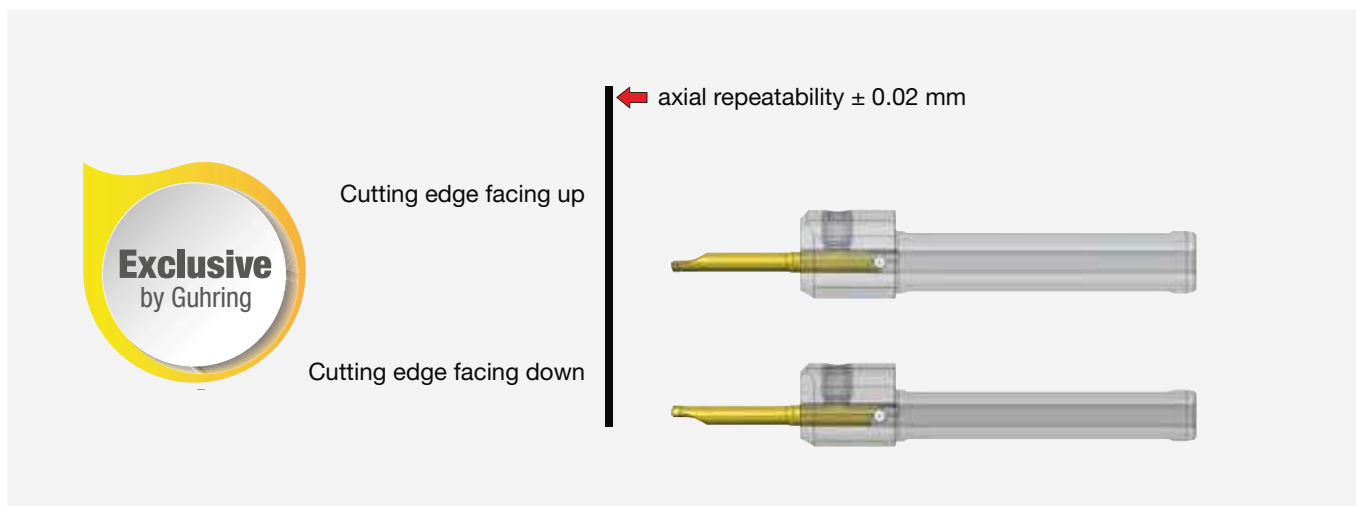
Guide values for feed and cutting depths

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.

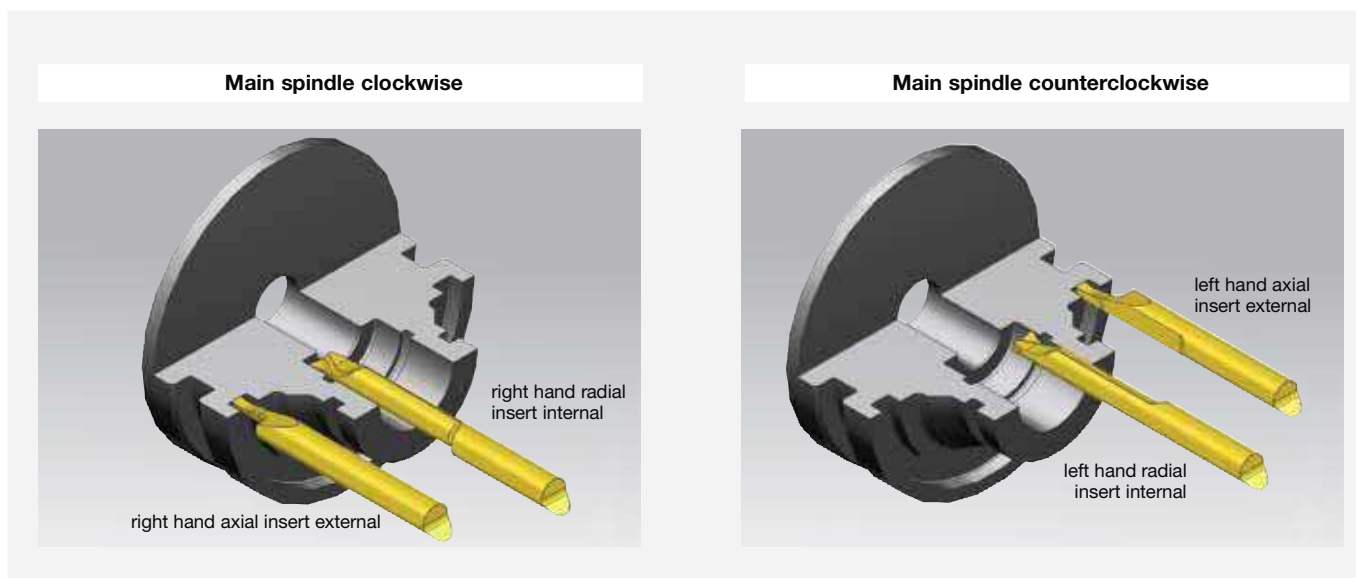


System 104/106/108/110 Positioning and clamping



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