



Solid carbide drills

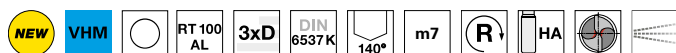
Solid carbide drills

Ratio drills with coolant ducts

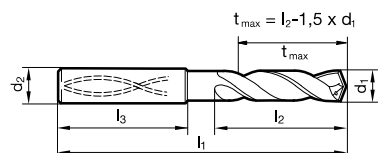
Article no. **6062**



cutting data see page 58



Web thinning $\geq \varnothing 3,000$ • relieved cone • main cutting edge is slightly concave • optimised cutting edge geometry
• sharp cutting characteristics • polished functional surfaces for the prevention of built-up edges



Article no.

6062

d1 mm	inch	d2 h6 mm	l1 mm	l2 mm	l3 mm	Order no.
3.000		6.0	62.0	20.0	36.0	6062 3.000
3.100		6.0	62.0	20.0	36.0	6062 3.100
3.170	1/8	6.0	62.0	20.0	36.0	6062 3.170
3.200		6.0	62.0	20.0	36.0	6062 3.200
3.250		6.0	62.0	20.0	36.0	6062 3.250
3.300		6.0	62.0	20.0	36.0	6062 3.300
3.400		6.0	62.0	20.0	36.0	6062 3.400
3.500		6.0	62.0	20.0	36.0	6062 3.500
3.570	9/64	6.0	62.0	20.0	36.0	6062 3.570
3.600		6.0	62.0	20.0	36.0	6062 3.600
3.700		6.0	62.0	20.0	36.0	6062 3.700
3.800		6.0	66.0	24.0	36.0	6062 3.800
3.900		6.0	66.0	24.0	36.0	6062 3.900
3.970	5/32	6.0	66.0	24.0	36.0	6062 3.970
4.000		6.0	66.0	24.0	36.0	6062 4.000
4.100		6.0	66.0	24.0	36.0	6062 4.100
4.200		6.0	66.0	24.0	36.0	6062 4.200
4.300		6.0	66.0	24.0	36.0	6062 4.300
4.370	11/64	6.0	66.0	24.0	36.0	6062 4.370
4.400		6.0	66.0	24.0	36.0	6062 4.400
4.500		6.0	66.0	24.0	36.0	6062 4.500
4.600		6.0	66.0	24.0	36.0	6062 4.600
4.650		6.0	66.0	24.0	36.0	6062 4.650
4.700		6.0	66.0	24.0	36.0	6062 4.700
4.760	3/16	6.0	66.0	28.0	36.0	6062 4.760
4.800		6.0	66.0	28.0	36.0	6062 4.800
4.900		6.0	66.0	28.0	36.0	6062 4.900
5.000		6.0	66.0	28.0	36.0	6062 5.000
5.100		6.0	66.0	28.0	36.0	6062 5.100
5.160	13/64	6.0	66.0	28.0	36.0	6062 5.160
5.200		6.0	66.0	28.0	36.0	6062 5.200
5.300		6.0	66.0	28.0	36.0	6062 5.300
5.400		6.0	66.0	28.0	36.0	6062 5.400
5.500		6.0	66.0	28.0	36.0	6062 5.500
5.550		6.0	66.0	28.0	36.0	6062 5.550
5.560	7/32	6.0	66.0	28.0	36.0	6062 5.560
5.600		6.0	66.0	28.0	36.0	6062 5.600
5.700		6.0	66.0	28.0	36.0	6062 5.700
5.800		6.0	66.0	28.0	36.0	6062 5.800
5.900		6.0	66.0	28.0	36.0	6062 5.900
5.950	15/64	6.0	66.0	28.0	36.0	6062 5.950
6.000		6.0	66.0	28.0	36.0	6062 6.000
6.100		8.0	79.0	34.0	36.0	6062 6.100
6.200		8.0	79.0	34.0	36.0	6062 6.200
6.300		8.0	79.0	34.0	36.0	6062 6.300
6.350	1/4	8.0	79.0	34.0	36.0	6062 6.350
6.400		8.0	79.0	34.0	36.0	6062 6.400
6.500		8.0	79.0	34.0	36.0	6062 6.500
6.600		8.0	79.0	34.0	36.0	6062 6.600
6.700		8.0	79.0	34.0	36.0	6062 6.700
6.750	17/64	8.0	79.0	34.0	36.0	6062 6.750
6.800		8.0	79.0	34.0	36.0	6062 6.800
6.900		8.0	79.0	34.0	36.0	6062 6.900
7.000		8.0	79.0	34.0	36.0	6062 7.000
7.100		8.0	79.0	41.0	36.0	6062 7.100
7.140	9/32	8.0	79.0	41.0	36.0	6062 7.140
7.200		8.0	79.0	41.0	36.0	6062 7.200
7.300		8.0	79.0	41.0	36.0	6062 7.300
7.400		8.0	79.0	41.0	36.0	6062 7.400
7.500		8.0	79.0	41.0	36.0	6062 7.500
7.540	19/64	8.0	79.0	41.0	36.0	6062 7.540
7.600		8.0	79.0	41.0	36.0	6062 7.600
7.700		8.0	79.0	41.0	36.0	6062 7.700
7.800		8.0	79.0	41.0	36.0	6062 7.800
7.900		8.0	79.0	41.0	36.0	6062 7.900
7.940	5/16	8.0	79.0	41.0	36.0	6062 7.940

Article no.

6062

d1 mm	inch	d2 h6 mm	l1 mm	l2 mm	l3 mm	Order no.
8.000		8.0	79.0	41.0	36.0	6062 8.000
8.100		10.0	89.0	47.0	40.0	6062 8.100
8.200		10.0	89.0	47.0	40.0	6062 8.200
8.300	21/64	10.0	89.0	47.0	40.0	6062 8.300
8.330		10.0	89.0	47.0	40.0	6062 8.330
8.400		10.0	89.0	47.0	40.0	6062 8.400
8.500		10.0	89.0	47.0	40.0	6062 8.500
8.600		10.0	89.0	47.0	40.0	6062 8.600
8.700		10.0	89.0	47.0	40.0	6062 8.700
8.730	11/32	10.0	89.0	47.0	40.0	6062 8.730
8.800		10.0	89.0	47.0	40.0	6062 8.800
8.900		10.0	89.0	47.0	40.0	6062 8.900
9.000		10.0	89.0	47.0	40.0	6062 9.000
9.100		10.0	89.0	47.0	40.0	6062 9.100
9.130	23/64	10.0	89.0	47.0	40.0	6062 9.130
9.200		10.0	89.0	47.0	40.0	6062 9.200
9.250		10.0	89.0	47.0	40.0	6062 9.250
9.300		10.0	89.0	47.0	40.0	6062 9.300
9.340		10.0	89.0	47.0	40.0	6062 9.340
9.400		10.0	89.0	47.0	40.0	6062 9.400
9.500		10.0	89.0	47.0	40.0	6062 9.500
9.520	3/8	10.0	89.0	47.0	40.0	6062 9.520
9.600		10.0	89.0	47.0	40.0	6062 9.600
9.700		10.0	89.0	47.0	40.0	6062 9.700
9.800		10.0	89.0	47.0	40.0	6062 9.800
9.900		10.0	89.0	47.0	40.0	6062 9.900
9.920	25/64	10.0	89.0	47.0	40.0	6062 9.920
10.000		10.0	89.0	47.0	40.0	6062 10.000
10.100		12.0	102.0	55.0	45.0	6062 10.100
10.200		12.0	102.0	55.0	45.0	6062 10.200
10.300		12.0	102.0	55.0	45.0	6062 10.300
10.320	13/32	12.0	102.0	55.0	45.0	6062 10.320
10.400		12.0	102.0	55.0	45.0	6062 10.400
10.500		12.0	102.0	55.0	45.0	6062 10.500
10.600		12.0	102.0	55.0	45.0	6062 10.600
10.700		12.0	102.0	55.0	45.0	6062 10.700
10.800		12.0	102.0	55.0	45.0	6062 10.800
10.900		12.0	102.0	55.0	45.0	6062 10.900
11.000		12.0	102.0	55.0	45.0	6062 11.000
11.100		12.0	102.0	55.0	45.0	6062 11.100
11.110	7/16	12.0	102.0	55.0	45.0	6062 11.110
11.200		12.0	102.0	55.0	45.0	6062 11.200
11.300		12.0	102.0	55.0	45.0	6062 11.300
11.400		12.0	102.0	55.0	45.0	6062 11.400
11.500		12.0	102.0	55.0	45.0	6062 11.500
11.600		12.0	102.0	55.0	45.0	6062 11.600
11.700		12.0	102.0	55.0	45.0	6062 11.700
11.800		12.0	102.0	55.0	45.0	6062 11.800
11.900		12.0	102.0	55.0	45.0	6062 11.900
11.910	15/32	12.0	102.0	55.0	45.0	6062 11.910
12.000		12.0	102.0	55.0	45.0	6062 12.000
12.100		14.0	107.0	60.0	45.0	6062 12.100
12.200		14.0	107.0	60.0	45.0	6062 12.200
12.500		14.0	107.0	60.0	45.0	6062 12.500
12.600		14.0	107.0	60.0	45.0	6062 12.600
12.700	1/2	14.0	107.0	60.0	45.0	6062 12.700
12.800		14.0	107.0	60.0	45.0	6062 12.800
12.900		14.0	107.0	60.0	45.0	6062 12.900
13.000		14.0	107.0	60.0	45.0	6062 13.000
13.100	33/64	14.0	107.0	60.0	45.0	6062 13.100
13.300		14.0	107.0	60.0	45.0	6062 13.300
13.400		14.0	107.0	60.0	45.0	6062 13.400
13.500		14.0	107.0	60.0	45.0	6062 13.500
13.700		14.0	107.0	60.0	45.0	6062 13.700
13.800		14.0	107.0	60.0	45.0	6062 13.800
14.000		14.0	107.0	60.0	45.0	6062 14.000



Article no.						6062
d1 mm	inch	d2 h6 mm	l1 mm	l2 mm	l3 mm	Order no.
14.500		16.0	115.0	65.0	48.0	6062 14.500
14.800		16.0	115.0	65.0	48.0	6062 14.800
15.000		16.0	115.0	65.0	48.0	6062 15.000
15.500		16.0	115.0	65.0	48.0	6062 15.500
15.800		16.0	115.0	65.0	48.0	6062 15.800
16.000		16.0	115.0	65.0	48.0	6062 16.000
16.500		18.0	123.0	73.0	48.0	6062 16.500
17.000		18.0	123.0	73.0	48.0	6062 17.000
17.500		18.0	123.0	73.0	48.0	6062 17.500
18.000		18.0	123.0	73.0	48.0	6062 18.000
18.500		20.0	131.0	79.0	50.0	6062 18.500
19.000		20.0	131.0	79.0	50.0	6062 19.000

Article no.						6062
d1 mm	inch	d2 h6 mm	l1 mm	l2 mm	l3 mm	Order no.
19.500		20.0	131.0	79.0	50.0	6062 19.500
20.000		20.0	131.0	79.0	50.0	6062 20.000

Solid carbide drills



Ratio drills with coolant ducts RT 100 AL, 3xD und 5xD



Machining group		f (mm/rev) with nom. Ø								
	v _c (m/min)	3	4	6	8	10	12	14	16	20
P1.1.1 Unalloyed steel, annealed, 0.15 % C, Rm 420 N/mm ² , 125 HB										
P1.1.2 Unalloyed steel, heat-treated, 0.15 % C, Rm 420 N/mm ² , 125 HB										
P1.1.3 Unalloyed steel, annealed, 0.45 % C, Rm 640 N/mm ² , 190 HB										
P1.1.4 Unalloyed steel, heat-treated, 0.45 % C, Rm 640 N/mm ² , 190 HB										
P1.1.5 Unalloyed steel, heat-treated, 0.45 % C, Rm 850 N/mm ² , 250 HB										
P1.1.6 Unalloyed steel, annealed, 0.75 % C, Rm 915 N/mm ² , 270 HB										
P1.1.7 Unalloyed steel, heat-treated, 0.75 % C, Rm 1020 N/mm ² , 300 HB										
P2.1.1 Low-alloy steel, annealed, Rm 610 N/mm ² , 180 HB										
P2.1.2 Low-alloy steel, heat-treated, Rm 930 N/mm ² , 275 HB										
P2.1.3 Low-alloy steel, heat-treated, Rm 1020 N/mm ² , 300 HB										
P2.1.4 Low-alloy steel, heat-treated, Rm 1190 N/mm ² , 350 HB										
P3.1.1 High-alloy steel and tool steel, annealed, Rm 680 N/mm ² , 200 HB										
P3.1.2 High-alloy steel and tool steel, hardened and tempered, Rm 1100 N/mm ² , 325 HB										
M1.1.1 Stainless steel, ferritic/martensitic, with machining additives										
M1.1.2 Stainless steel, ferritic/martensitic, annealed, Rm 680 N/mm ² , 200 HB										
M1.1.3 Stainless steel, ferritic/martensitic, heat-treated, Rm 810 N/mm ² , 240 HB										
M2.1.1 Stainless steel, austenitic, quenched, 180 HB										
M2.2.1 Duplex steel, high-strength stainless steels										
K1.1.1 Grey cast iron, pearlitic/ferritic, 180 HB										
K1.1.2 Grey cast iron, pearlitic/martensitic, 260 HB										
K1.2.1 Cast iron with spheroidal graphite, ferritic, 160 HB										
K1.2.2 Cast iron with spheroidal graphite, pearlitic, 250 HB										
K1.3.1 Malleable cast iron, ferritic, 130 HB										
K1.3.2 Malleable cast iron, pearlitic, 230 HB										
K2.1.1 Vermicular graphite cast iron (GJV)										
K2.2.1 Austenitic-ferritic spheroidal graphite cast iron (ADI)										
N1.1.1 Wrought aluminium alloys, non-hardened, 60 HB	240	0.190	0.240	0.325	0.405	0.480	0.550	0.620	0.685	0.815
N1.1.2 Wrought aluminium alloys, hardened, 100 HB	240	0.190	0.240	0.325	0.405	0.480	0.550	0.620	0.685	0.815
N2.1.1 Aluminium casting alloys, non-hardened, ≤ 12 % Si, 75 HB	220	0.190	0.240	0.325	0.405	0.480	0.550	0.620	0.685	0.815
N2.1.2 Aluminium casting alloys, hardened, ≤ 12 % Si, 90 HB	220	0.190	0.240	0.325	0.405	0.480	0.550	0.620	0.685	0.815
N2.1.3 Aluminium casting alloys, non-hardened, > 12 % Si, 130 HB	185	0.165	0.205	0.275	0.345	0.410	0.470	0.525	0.585	0.690
N3.1.1 Copper and copper alloys: Free-machining alloy, Pb > 1 %	160	0.125	0.155	0.210	0.260	0.305	0.355	0.395	0.440	0.520
N3.1.2 Copper and copper alloys: CuZn, CuSnZn	135	0.105	0.130	0.175	0.220	0.260	0.300	0.335	0.375	0.440
N3.1.3 Copper and copper alloys: CuSn, lead-free copper and copper electrolyte	130	0.100	0.120	0.165	0.205	0.245	0.280	0.315	0.350	0.415
N4.1.1 Non-metallic materials: Duroplastics, fibre-reinforced plastics	90	0.040	0.050	0.065	0.080	0.095	0.110	0.125	0.135	0.165
N4.1.2 Non-metallic materials: Hard rubber, wood, etc.	90	0.040	0.050	0.065	0.080	0.095	0.110	0.125	0.135	0.165
N4.1.3 Non-metallic materials: Graphite										
S1.1.1 Heat-resistant alloys, Fe-based, annealed, 200 HB										
S1.1.2 Heat-resistant alloys, Fe-based, hardened, 280 HB										
S1.1.3 Heat-resistant alloys, Ni- or Co-based, annealed, 250 HB										
S1.1.4 Heat-resistant alloys, Ni- or Co-based, hardened, 350 HB										
S1.1.5 Heat-resistant alloys, Ni- or Co-based, cast, 320 HB										
S2.1.1 Titanium alloys, pure titanium, Rm 400 N/mm ²										
S2.1.2 Titanium alloys, Alpha and Beta alloys, hardened, Rm 1050 N/mm ²										
H1.1.1 Hardened steel, hardened and tempered, < 55 HRC										
H1.1.2 Hardened steel, hardened and tempered, < 60 HRC										
H1.1.3 Hardened steel, hardened and tempered, > 60 HRC										
H2.1.1 Chilled cast iron, 400 HB										
H2.1.2 Chilled cast iron, hardened and tempered, < 55 HRC										



RT 100 AL

Drilling specialist for non-ferrous metals

No built-up edges and
perfect chip removal

**The RT 100 AL is characterised by its round,
open point geometry and concave cutting edge shape.**

As a result, the drill ensures optimum chip formation and
safe chip removal in both wrought and cast aluminium alloys.

Furthermore, the sharp, micro-polished cutting edges
ensure smooth cutting characteristics and low process
temperatures. Combined with the polished flutes – which
further promote chip removal – the polished surfaces in
the web thinning and on the clearance faces prevent
material adhesion and minimise built-up edges.

Your advantages: With the RT 100 AL, you benefit
from maximum process reliability when machining
non-ferrous metals, even with high cutting values.

x **Tool life** increased by 16 %
x **Machining time** reduced by 25 %

-  **X** soft cut & low process temperature even in heat-treated AISi alloys
-  **X** fewer built-up edges & less material adhesion
-  **X** long tool life thanks to wear-resistant carbide grade
-  **X** optimum formation & removal of chips in non-ferrous metals



optimised open point geometry
for optimum chip removal

sharp, concave cutting edges
for smooth cutting characteristics & low process temperatures

polished functional surfaces
prevent material adhesion & minimise built-up edges

available in the diameter range
3xD | 5xD | 7xD, Ø 3.0–20.0 mm
12xD, Ø 3.0–16.0 mm

Application example

Component:	Moulded part in the food industry, AlMg5 (3.3555)	
Tool:	#6062, Ø 11.8 mm	
Customer target:	Process-reliable and economical machining	
Difficulty:	Reliable chip removal with high machining parameters	
Cutting data:	Gühring	Competition
	v_c 250 m/min	v_c 220 m/min
	f 0.35 mm/rev	f 0.30 mm/rev
Tool life:	4608 m	3974 m