

# GÜHRING

## GROOVING SYSTEMS



# NEW

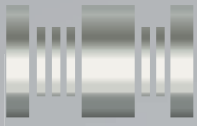
Boring out  
Grooving  
Threading  
Broaching  
Special tools



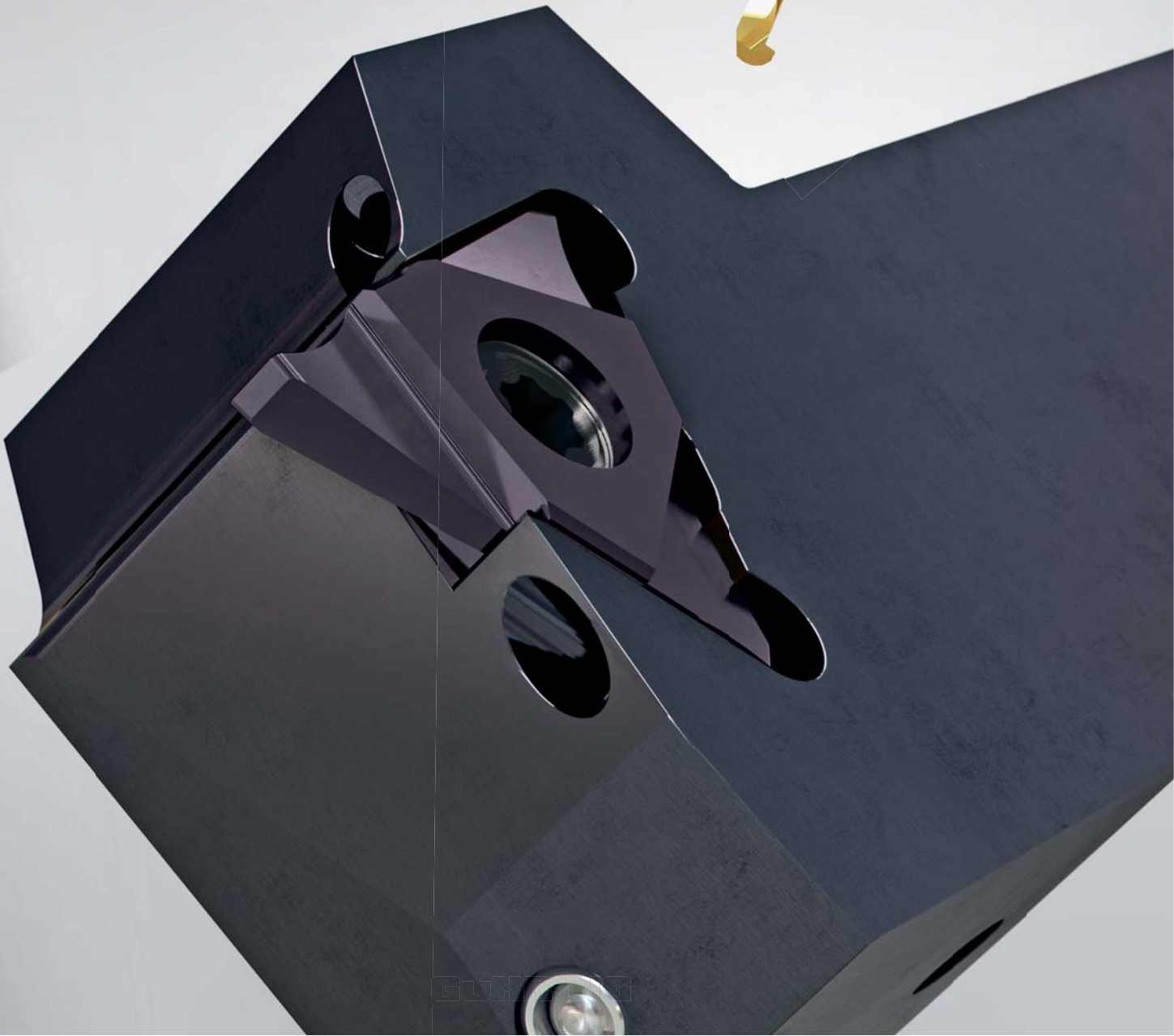
// FLEXIBLE  
// ECONOMICAL  
// ACCURATE

**GÜHRING**

**GÜHRING**



**GROOVING**  
SYSTEMS





# GROOVING SYSTEMS

highest quality and flexibility thanks  
to maximum manufacturing depth



## GRINDING – INDEXABLE INSERTS AND CUTTING INSERTS

Complete production on  
Guhring built grinding machines



## COATING – INDEXABLE INSERTS AND CUTTING INSERTS

// In-house coating on  
Guhring built coating systems  
// Latest coating technology  
and coating types







## MILLING/TURNING – HOLDER PRODUCTION



### **GUHRING'S OWN CARBIDE PRODUCTION**

Blanks – Indexable inserts and cutting inserts  
Guhring own carbide grades



# WE KEEP ON GROWING

| PROGRAMME EXPANSION | MORE SIZES | NEW APPLICATIONS

This rapid development is made possible by the huge manufacturing depth at Guhring, which is also evident in the grooving tool product line. Carbide manufactured in-house and specially developed machines and coatings from our own R&D are typical of Guhring products. This is no longer exclusive to rotating tools, but now also applies to stationary tools.

## 108

The new System 108 is the logical next development of the range of micro-precision tools. With a shank diameter of 8 mm and a minimum machining diameter of 7 mm, System 108 is a valuable addition to the existing tool portfolio. The shank diameter of 8 mm provides maximum stability and therefore high processing safety. The start-up range offers over 700 different articles for boring and profiling up to a maximum depth of 2.5 mm, internal grooving up to a maximum depth of 3 mm and back boring.

System 108 will also be continuously expanded to meet the needs of its users.



## 106

In the tried and tested System 106, a larger selection of broaching tools is now available. These are now available for internal hexagon processing of spanner sizes 4 to 10.

Where internal hole machining with micro-precision tools is concerned, the 106 tool system is already one of the most comprehensive ranges on the market.





# 110

Similarly, System 110 also opens up new and exciting opportunities. With a shank diameter of 10 mm, this special tool ensures maximum stability. We have blanks in stock measuring up to 112 mm in length to be able to provide the best possible solution for challenging applications. In addition, the standard range includes the most conventional round shank holders.

Gühring specialises in industry-specific tool and process solutions. We are also able to design custom-made special tools for grooving. As well as our comprehensive standard portfolio, we focus on tailored systems aimed specifically at our customers. This is based in particular on Gühring's substantial tool expertise and extensive consulting experience.



**GÜHRING**  
**GROOVING**  
SYSTEMS

Guhring R&D for innovative tool developments

Highest quality standard world-wide

Pooled expertise under one roof

Exceptionally high manufacturing depth

Machining technology with an edge



**GUHRING**

Production location  
Grooving tools









Dr. Jörg Gühring

President



Oliver Gühring

Sales and Marketing  
Director

8000

Employees  
world-wide



3500

Employees  
Germany



Internal training and further  
programme of education



International knowledge transfer thanks  
to world-wide exchange programme for  
employees





## Dietmar Pfränger

R&D, Logistics, Technical and  
Production Director



## Bernd Schatz

Financial and Commercial  
Director

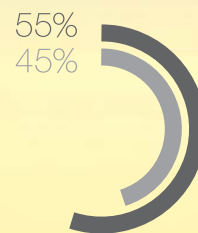


90000

Standard tools

4000

Tool types



■ Standard tools  
■ Special tools

# Everything from one supplier – comprehensive and global

With a global network of manufacturing sites Guhring develops and produces precision tools for all the important markets. Users from the automotive industry, the aerospace industry or the machine tool and general industry rely on the trend-setting tools manufactured world-wide at the highest level to uniform quality standards.

48  
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MORE THAN 70  
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With innovative technologies Guhring meets specific customer requirements from process proposal to series application of the precision tools – flexibly, promptly, globally. For this, experts are in action internationally looking after customers on site. Production, service and contact persons are available from one supplier world-wide.


Own carbide production      Own machine construction  
 Own coating plants      Highest quality standards world-wide



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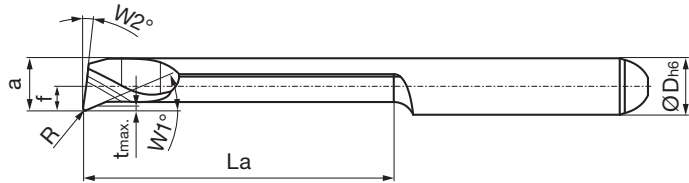


# GROOVING SYSTEMS

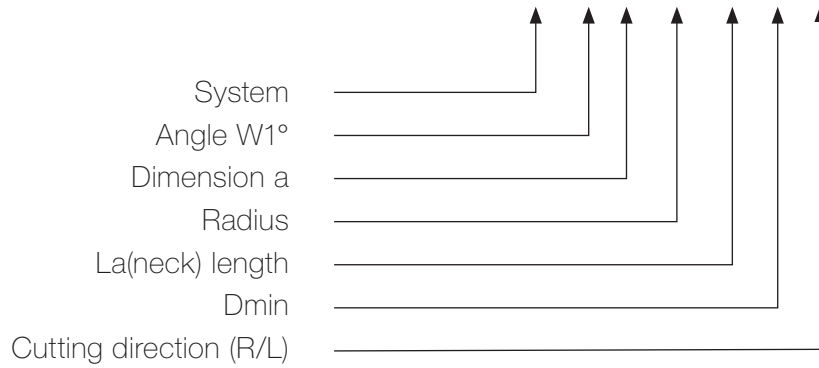
Explanation of the article description

## Article description

### System 104/106/108/110

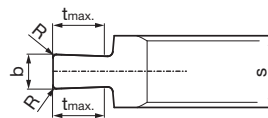
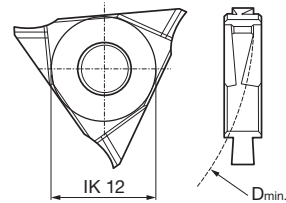


Tool description: Example: GT104.2326.010.22.30.R

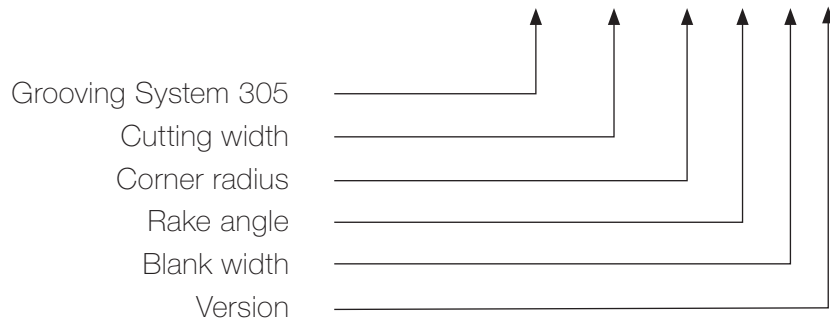


## Article description

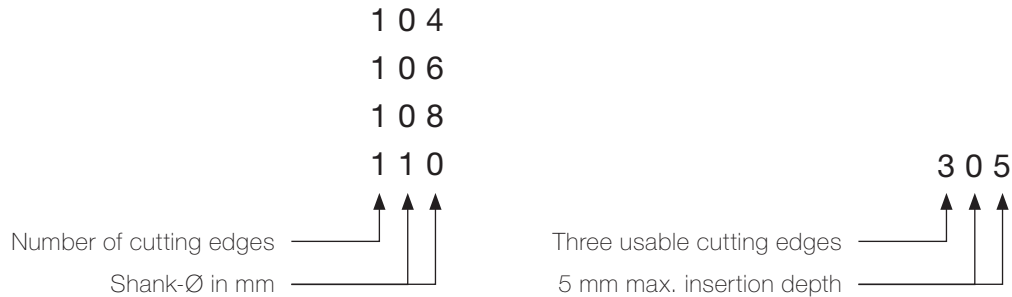
### System 305



Tool description: Example: GE305.0250.020.BA.04.N



## Explanation of the system



When ordering please always state the  
**Article No. and the Code No. i.e.:**  
Article GG104.VM02.040.04.15.R,  
TiN-coated = **25164 4.001**

## Ordering example

Micro-precision tools for internal threading

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



• pitch P = 0.4-0.8

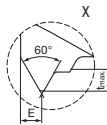
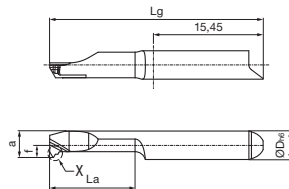
for tool holders type GH104/GB104 see from page 16

**GÜHRING** NAVIGATOR

Cutting data page 150

Tool material	Solid carbide		
Type	GG 104	GG 104	GG 104
Surface	Ⓢ	ⓐ	Ⓞ
	TiN	TiAlN-nanoA	bright

System 104



Right hand version shown  
Left hand version mirror image

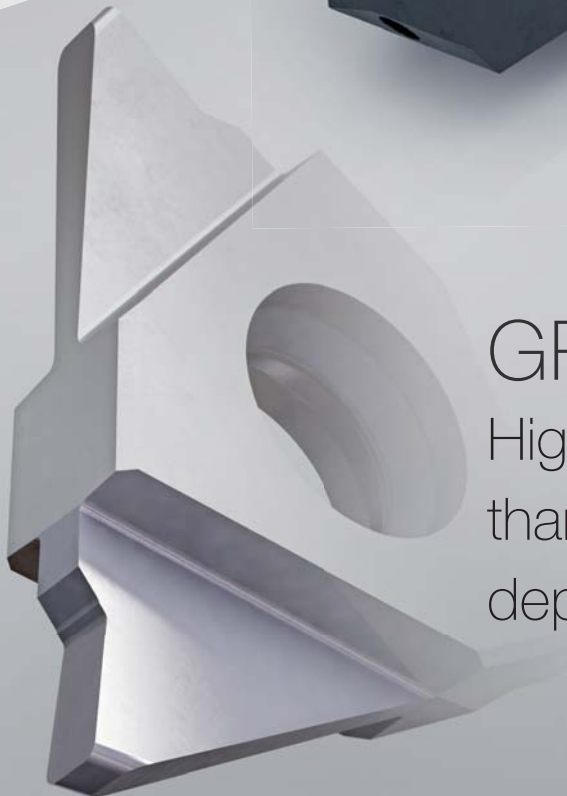
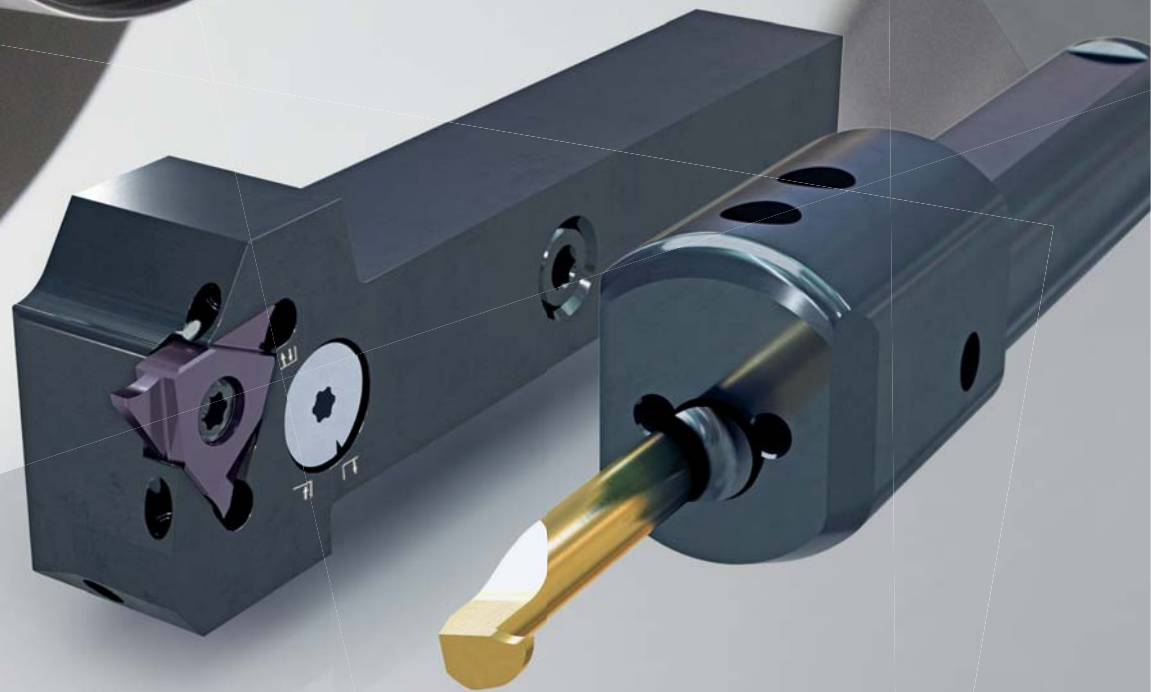
Article no. **25164** **25166** **25170**

Cutting direction (R) (R) (R)

Article No.

Code no.	Description	G	P	D min	f	E	a	t max	La	Lg	D h6
			mm	mm	mm	mm	mm	mm	mm	mm	mm
4.001	GG104.VM02.040.04.15.R	M2	0.40	1.50	1.95	0.20	1.35	0.25	4.00	25.00	4.00
4.002	GG104.VM02.040.07.15.R	M2	0.40	1.50	1.95	0.20	1.35	0.25	7.00	25.00	4.00
4.003	GG104.VM02.040.12.15.R	M2	0.40	1.50	1.95	0.20	1.35	0.25	12.00	30.00	4.00
4.004	GG104.VM03.050.04.24.R	M3	0.50	2.40	1.95	0.30	1.95	0.35	4.00	25.00	4.00
4.005	GG104.VM03.050.07.24.R	M3	0.50	2.40	1.95	0.30	1.95	0.35	7.00	25.00	4.00

Code No.



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Highest quality and flexibility  
thanks to maximum manufacturing  
depth. All from one supplier.





## SYSTEM 104

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## SYSTEM 110

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# 104





# SYSTEM 104

## MICRO-PRECISION TOOLS




Round shank holder  
from page 16



Square shank holder  
from page 23

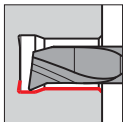


Modular holder  
from page 25

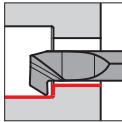


Round shank holder  
Broaching  
page 28

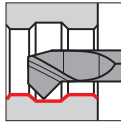
Tool holder



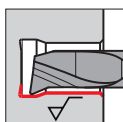
Boring out  
and profiling, type GT  
from page 29



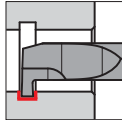
Back boring  
and profiling, type GT  
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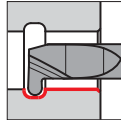
Boring out  
and chamfering, type GT  
page 42



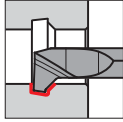
Boring out  
with Wiper, type GJ  
page 39



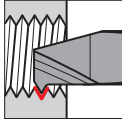
Internal grooving,  
straight slots, type GE  
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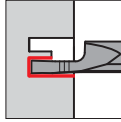
Internal grooving,  
full radius slots, type GE  
page 45



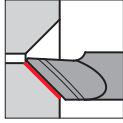
Internal grooving  
and chamfering, type GV  
page 46



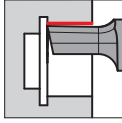
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Axial grooving bores,  
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Axial chamfering  
bores, type GA  
page 51



Broaching,  
type GN  
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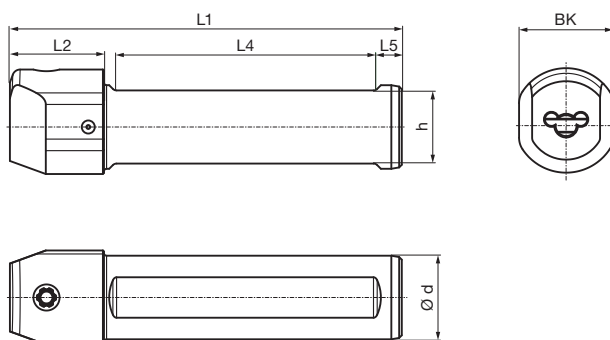
Cutting inserts from hole-Ø 0.7 mm



**Round shank holder, clamping screw top**

- for inserts type 104
- with internal coolant supply

Type GB 104



Article no. 25000

version left and right

Code no.	Description	d	h	L1	L2	L4	L5	BK
		mm	mm	mm	mm	mm	mm	mm
4.001	GB104.0010.075.00.15.N.IK	10.00	9.00	75.00	18.00	50.00	5.00	12.0
4.002	GB104.0012.075.00.15.N.IK	12.00	11.00	75.00	18.00	50.00	5.00	14.0
4.015	GB104.0500.354.00.15.N.IK	12.70	11.00	89.92	17.78	54.86	5.08	13.9
4.016	GB104.0625.354.00.15.N.IK	15.87	14.00	89.92	17.78	54.86	5.08	17.7
4.003	GB104.0016.075.00.15.N.IK	16.00	14.00	75.00	18.00	50.00	5.00	18.0
4.017	GB104.0750.380.00.15.N.IK	19.05	17.04	96.52	17.78	69.85	5.08	
4.004	GB104.0020.090.00.15.N.IK	20.00	18.00	90.00		55.00	5.00	
4.005	GB104.0022.090.00.15.N.IK	22.00	20.00	90.00		55.00	5.00	
4.006	GB104.0025.100.00.15.N.IK	25.00	23.00	100.00		55.00	5.00	
4.018	GB104.1000.380.00.15.N.IK	25.40	23.39	96.52		69.85	5.08	

**Spare parts**

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

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

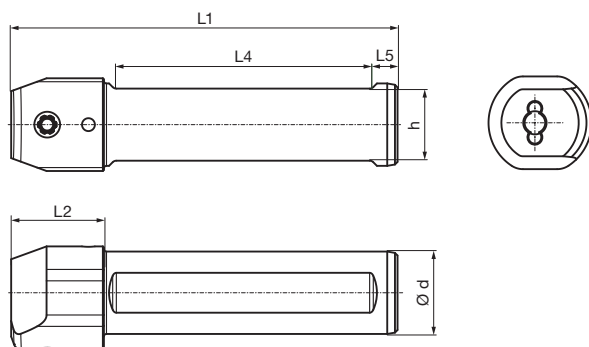


### Round shank holder, clamping screw lateral

- for inserts type 104
- with internal coolant supply

Type GB 104

System 104



Article no. **25001**

version left and right

Code no.	Description	d	h	L1	L2	L4	L5
		mm	mm	mm	mm	mm	mm
4.001	GB104.0010.075.00.15.N.IK.90	10.00	9.00	75.00	18.00	50.00	5.00
4.002	GB104.0012.075.00.15.N.IK.90	12.00	11.00	75.00	18.00	50.00	5.00
4.015	GB104.0500.354.00.15.N.IK.90	12.70	11.00	89.92	17.78	54.86	5.08
4.016	GB104.0625.354.00.15.N.IK.90	15.87	14.00	89.92	17.78	54.86	5.08
4.003	GB104.0016.075.00.15.N.IK.90	16.00	14.00	75.00	18.00	50.00	5.00
4.017	GB104.0750.380.00.15.N.IK.90	19.05	17.04	96.52	17.78	69.85	5.08
4.004	GB104.0020.090.00.15.N.IK.90	20.00	18.00	90.00		55.00	5.00
4.005	GB104.0022.090.00.15.N.IK.90	22.00	20.00	90.00		55.00	5.00
4.006	GB104.0025.100.00.15.N.IK.90	25.00	23.00	100.00		55.00	5.00
4.018	GB104.1000.380.00.15.N.IK.90	25.40	23.39	96.52		69.85	5.08

### Spare parts

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

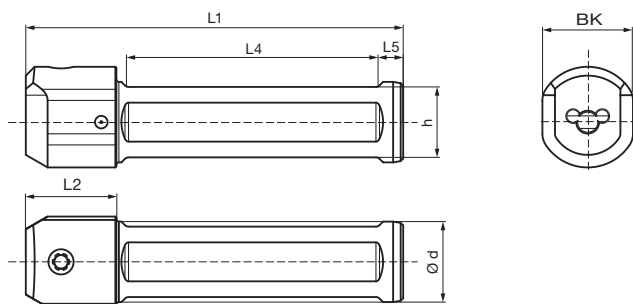
Article no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle



**Round shank holder, clamping screw above, four clamping surfaces**

- for inserts type 104
- with internal coolant supply

Type GB 104



Article no. **25018**

version left and right

Code no.	Description	d	h	L1	L2	L4	L5	BK
		mm	mm	mm	mm	mm	mm	mm
4.010	GB104.0016.075.00.15.N.IK.VSP	16.00	14.00	75.00	18.00	50.00	5.00	18.0
4.020	GB104.0020.090.00.15.N.IK.VSP	20.00	18.00	90.00		55.00	5.00	
4.030	GB104.0022.090.00.15.N.IK.VSP	22.00	20.00	90.00		55.00	5.00	
4.040	GB104.0025.100.00.15.N.IK.VSP	25.00	23.00	100.00		55.00	5.00	

**Spare parts**

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

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

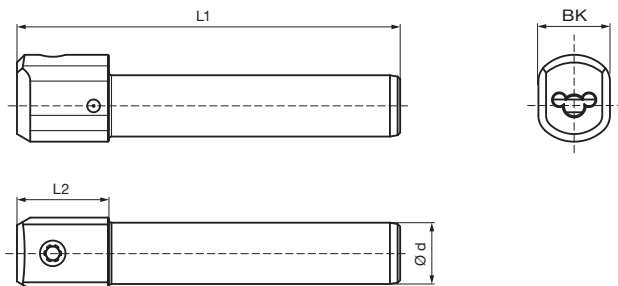




**Round shank holder, clamping screw above, without clamping surfaces**

- for inserts type 104
- with internal coolant supply

Type	GB 104
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Article no. **25017**  
version left and right

Code no.	Description	d	L1	L2	BK
		mm	mm	mm	mm
4.010	GB104.0010.075.00.15.N.IK.RND	10.00	75.00	18.00	12.0
4.020	GB104.0012.075.00.15.N.IK.RND	12.00	75.00	18.00	14.0
4.030	GB104.0016.075.00.15.N.IK.RND	16.00	75.00	18.00	18.0

**Spare parts**

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

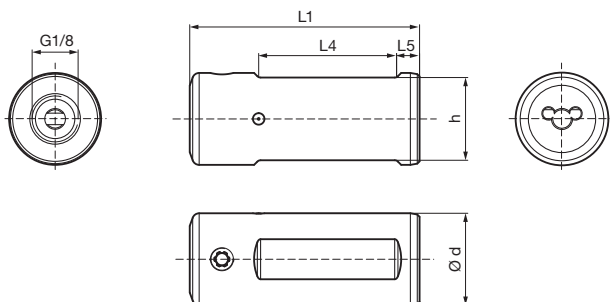
Article no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle



**Round shank holder, clamping screw above, for Citizen machine**

- for inserts type 104
- with internal coolant supply

Type GB 104



Article no. **25021**

version left and right

Code no.	Description	d	h	L1	L4	L5
		mm	mm	mm	mm	mm
4.110	GB104.0750.040.00.15.N.IK.CIT	19.05	17.04	40.00	20.32	5.08
4.120	GB104.0750.050.00.15.N.IK.CIT	19.05	17.04	50.00	31.75	5.08
4.130	GB104.0750.070.00.15.N.IK.CIT	19.05	17.04	70.00	44.45	5.08
4.140	GB104.0750.100.00.15.N.IK.CIT	19.05	17.04	100.00	76.20	5.08
4.010	GB104.0020.050.00.15.N.IK.CIT	20.00	18.00	50.00	30.00	5.00
4.020	GB104.0020.030.00.15.N.IK.CIT	20.00	18.00	30.00	13.00	5.00
4.150	GB104.1000.060.00.15.N.IK.CIT	25.40	23.39	60.00	38.10	5.08
4.160	GB104.1000.100.00.15.N.IK.CIT	25.40	23.39	100.00	76.20	5.08

**Spare parts**

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

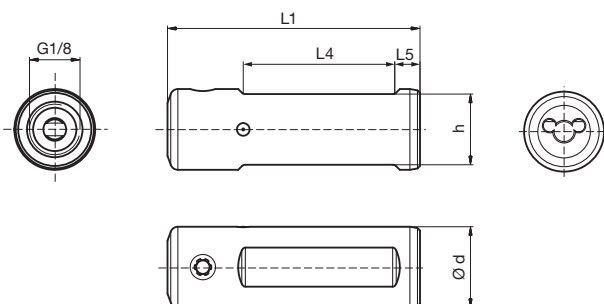
Article no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle


**Round shank holder, clamping screw above, for Star machine**

- for inserts type 104
- with internal coolant supply

Type GB 104

System 104


 Article no. **25022**

version left and right

Code no.	Description	d	h	L1	L4	L5
		mm	mm	mm	mm	mm
4.010	GB104.0016.030.00.15.N.IK.STA	16.00	14.00	30.00	13.00	5.00
4.020	GB104.0016.050.00.15.N.IK.STA	16.00	14.00	50.00	30.00	5.00
4.030	GB104.0016.070.00.15.N.IK.STA	16.00	14.00	70.00	50.00	5.00
4.040	GB104.0022.038.00.15.N.IK.STA	22.00	20.00	38.00	18.00	5.00
4.050	GB104.0022.050.00.15.N.IK.STA	22.00	20.00	50.00	30.00	5.00
4.060	GB104.0022.070.00.15.N.IK.STA	22.00	20.00	70.00	50.00	5.00
4.070	GB104.0022.100.00.15.N.IK.STA	22.00	20.00	100.00	80.00	5.00
4.080	GB104.0022.120.00.15.N.IK.STA	22.00	20.00	120.00	100.00	5.00

**Spare parts**

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

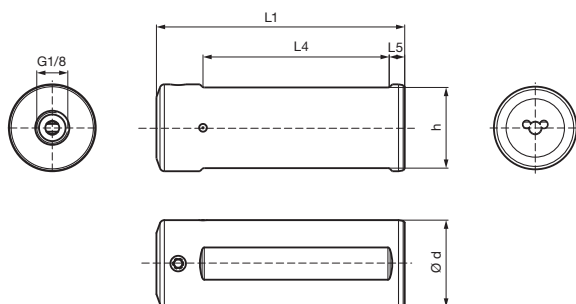
Article no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle



**Round shank holder, clamping screw above, for Tornos machine**

- for inserts type 104
- with internal coolant supply

Type GB 104



Article no. **25023**

version left and right

Code no.	Description	d	h	L1	L4	L5
		mm	mm	mm	mm	mm
4.010	GB104.0018.310.00.15.N.IK.TOR	18.00	16.00	310.00	290.00	5.00
4.020	GB104.0020.170.00.15.N.IK.TOR	20.00	18.00	170.00	150.00	5.00
4.030	GB104.0020.185.00.15.N.IK.TOR	20.00	18.00	185.00	165.00	5.00
4.040	GB104.0025.100.00.15.N.IK.TOR	25.00	23.00	100.00	80.00	5.00
4.050	GB104.0025.150.00.15.N.IK.TOR	25.00	23.00	150.00	130.00	5.00
4.060	GB104.0028.080.00.15.N.IK.TOR	28.00	26.00	80.00	60.00	5.00

**Spare parts**

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

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

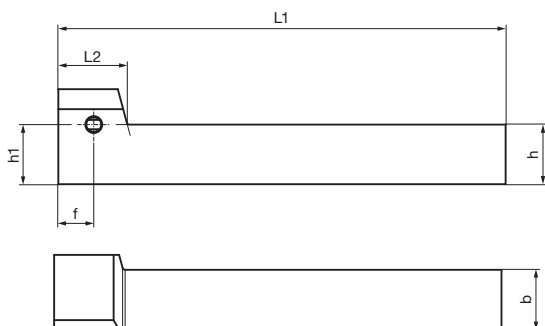




**Square shank holder, 90° offset**

- for inserts type 104
- without internal coolant supply

Type GH 104



Right hand version shown  
Left hand version mirror image

Article no. **25002**

version right-hand

Code no.	Description	b	h	h1	f	L1	L2
		mm	mm	mm	mm	mm	mm
4.001	GH104.0808.090.90.15.R	8.00	8.00	8.00	9.50	90.00	18.50
4.010	GH104.0375.350.90.15.R	9.52	9.52	9.52	7.62	88.90	16.51
4.002	GH104.1010.090.90.15.R	10.00	10.00	10.00	9.50	90.00	18.50
4.003	GH104.1212.090.90.15.R	12.00	12.00	12.00	9.50	90.00	18.50
4.011	GH104.0500.350.90.15.R	12.70	12.70	12.70	7.62	88.90	16.51
4.012	GH104.0625.400.90.15.R	15.87	15.87	15.87	7.62	101.60	16.51
4.004	GH104.1616.120.90.15.R	16.00	16.00	16.00	9.50	120.00	18.50

Article no. **25003**

version left-hand

Code no.	Description	b	h	h1	f	L1	L2
		mm	mm	mm	mm	mm	mm
4.001	GH104.0808.090.90.15.L	8.00	8.00	8.00	9.50	90.00	18.50
4.010	GH104.0375.350.90.15.L	9.52	9.52	9.52	7.62	88.90	16.51
4.002	GH104.1010.090.90.15.L	10.00	10.00	10.00	9.50	90.00	18.50
4.003	GH104.1212.090.90.15.L	12.00	12.00	12.00	9.50	90.00	18.50
4.011	GH104.0500.350.90.15.L	12.70	12.70	12.70	7.62	88.90	16.51
4.012	GH104.0625.400.90.15.L	15.87	15.87	15.87	7.62	101.60	16.51
4.004	GH104.1616.120.90.15.L	16.00	16.00	16.00	9.50	120.00	18.50

**Spare parts**

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

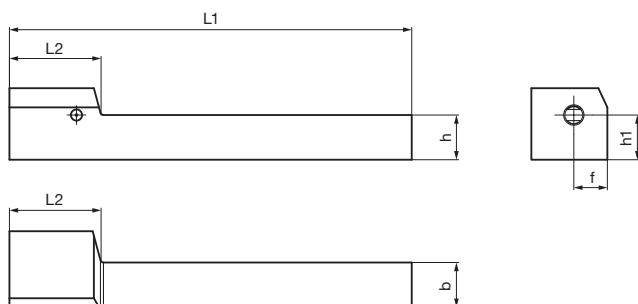
Article no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle



**Square shank holder, straight 0°**

- for inserts type 104
- without internal coolant supply

Type GH 104



Right hand version shown  
Left hand version mirror image

Article no. **25019**

version right-hand

Code no.	Description	b	h	h1	f	L1	L2
		mm	mm	mm	mm	mm	mm
4.010	GH104.0808.090.00.15.R	8.00	8.00	8.00	7.50	90.00	20.50
4.100	GH104.0375.350.00.15.R	9.52	9.52	9.52	7.62	88.90	20.00
4.020	GH104.1010.090.00.15.R	10.00	10.00	10.00	7.50	90.00	20.50
4.030	GH104.1212.090.00.15.R	12.00	12.00	12.00	7.50	90.00	20.50
4.110	GH104.0500.350.00.15.R	12.70	12.70	12.70	7.62	88.90	20.00
4.120	GH104.0625.400.00.15.R	15.87	15.87	15.87	7.62	101.60	20.00
4.040	GH104.1616.100.00.15.R	16.00	16.00	16.00	7.50	100.00	20.50

Article no. **25020**

version left-hand

Code no.	Description	b	h	h1	f	L1	L2
		mm	mm	mm	mm	mm	mm
4.010	GH104.0808.090.00.15.L	8.00	8.00	8.00	7.50	90.00	20.50
4.100	GH104.0375.350.00.15.L	9.52	9.52	9.52	7.62	88.90	20.00
4.020	GH104.1010.090.00.15.L	10.00	10.00	10.00	7.50	90.00	20.50
4.030	GH104.1212.090.00.15.L	12.00	12.00	12.00	7.50	90.00	20.50
4.110	GH104.0500.350.00.15.L	12.70	12.70	12.70	7.62	88.90	20.00
4.120	GH104.0625.400.00.15.L	15.87	15.87	15.87	7.62	101.60	20.00
4.040	GH104.1616.100.00.15.L	16.00	16.00	16.00	7.50	100.00	20.50

**Spare parts**

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

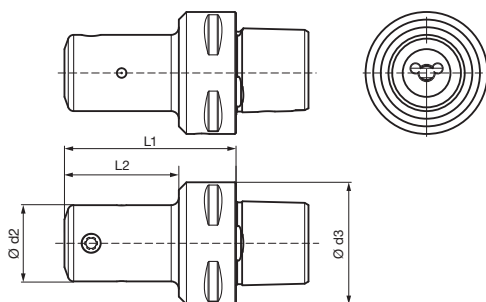
Article no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle



**Polygon shank holder, to ISO 26623, straight 0°**

- for inserts type 104
- with internal coolant supply

Type	GH 104
------	--------



Article no. **25010**  
version left and right

Code no.	Description	d2	d3	L1	L2
		mm		mm	mm
4.001	GH104.PO32.045.00.15.N.IK	20.00	PSC 32	45.00	30.00
4.002	GH104.PO40.050.00.15.N.IK	20.00	PSC 40	50.00	30.00
4.003	GH104.PO50.050.00.15.N.IK	20.00	PSC 50	50.00	30.00
4.004	GH104.PO63.052.00.15.N.IK	20.00	PSC 63	52.00	30.00

**Spare parts**

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

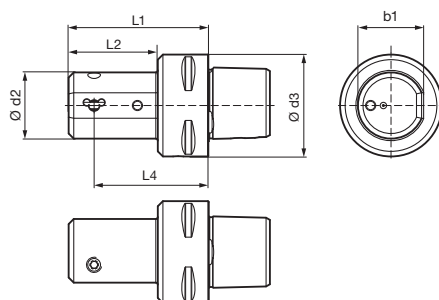
Article no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle



**Polygon shank holder, to ISO 26623, off-set 90°**

- for inserts type 104
- with internal coolant supply

Type GH 104



Right hand version shown  
Left hand version mirror image

Article no. **25012**

version right-hand

Code no.	Description	d2	d3	L1	L2	L4	b1
		mm		mm	mm	mm	mm
4.001	GH104.PO32.045.90.15.R.IK	26.00	PSC 32	55.00	40.00	45.00	25.00
4.002	GH104.PO40.050.90.15.R.IK	26.00	PSC 40	55.00	35.00	45.00	25.00
4.003	GH104.PO50.050.90.15.R.IK	26.00	PSC 50	55.00	35.00	45.00	25.00
4.004	GH104.PO63.052.90.15.R.IK	26.00	PSC 63	55.00	33.00	45.00	25.00

Article no. **25013**

version left-hand

Code no.	Description	d2	d3	L1	L2	L4	b1
		mm		mm	mm	mm	mm
4.001	GH104.PO32.045.90.15.L.IK	26.00	PSC 32	55.00	40.00	45.00	25.00
4.002	GH104.PO40.050.90.15.L.IK	26.00	PSC 40	55.00	35.00	45.00	25.00
4.003	GH104.PO50.050.90.15.L.IK	26.00	PSC 50	55.00	35.00	45.00	25.00
4.004	GH104.PO63.052.90.15.L.IK	26.00	PSC 63	55.00	33.00	45.00	25.00

**Spare parts**

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

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



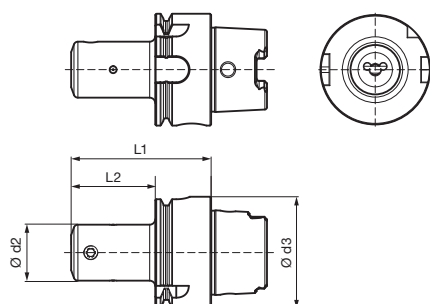


**HSK-T holder, to ISO 12164-3, straight 0°**

- for inserts type 104
- with internal coolant supply

Type	GH 104
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System 104



Article no. **25016**  
version left and right

Code no.	Description	d2	d3	L1	L2
		mm		mm	mm
4.001	GH104.HS40.050.00.15.N.IK	20.00	HSK-T 40	50.00	30.00
4.002	GH104.HS63.056.00.15.N.IK	20.00	HSK-T 63	56.00	30.00

**Spare parts**

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

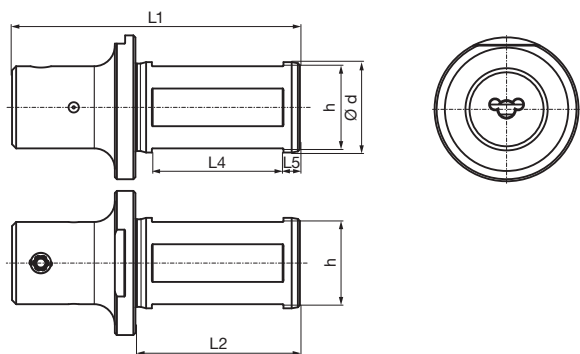
Article no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle



**Round shank holder, 4 clamping surfaces**

- for inserts type 104
- with internal coolant supply

Type GB 104



Article no. **25006**

Code no.	Description	d	h	L1	L2	L4	L5
		mm	mm	mm	mm	mm	mm
4.010	GB104.0750.275.00.15.S.IK	19.05	17.05	69.85	40.00	32.00	4.00
4.001	GB104.0020.070.00.15.S.IK	20.00	18.00	70.00	40.00	32.00	4.00
4.002	GB104.0022.070.00.15.S.IK	22.00	20.00	70.00	40.00	32.00	4.00
4.003	GB104.0025.070.00.15.S.IK	25.00	23.00	70.00	40.00	32.00	4.00
4.011	GB104.1000.275.00.15.S.IK	25.40	23.40	69.85	40.00	32.00	4.00

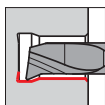
**Spare parts**

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

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



Cutting insert for boring out and profiling

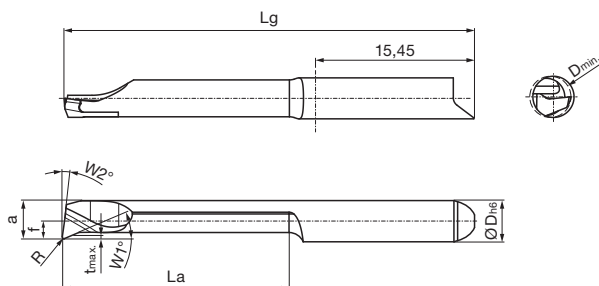


• radial free 23°

for tool holders type GH104/GB104 see from page 16

**GUHRING**NAVIGATOR

Cutting data page 184



Right hand version shown  
Left hand version mirror image

Article no.	<b>25050</b>	<b>25052</b>	<b>25056</b>
Cutting direction			

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
4.001	GT104.2306.005.03.07.R	0.70	0.05	23	8	1.95	0.60	0.05	3.00	25.00	4.00
4.002	GT104.2309.005.04.10.R	1.00	0.05	23	8	1.95	0.90	0.10	4.00	25.00	4.00
4.004	GT104.2314.005.04.15.R	1.50	0.05	23	8	1.95	1.40	0.15	4.00	25.00	4.00
4.010	GT104.2319.005.04.20.R	2.00	0.05	23	8	1.95	1.90	0.15	4.00	25.00	4.00
4.003	GT104.2309.005.07.10.R	1.00	0.05	23	8	1.95	0.90	0.10	7.00	25.00	4.00
4.005	GT104.2314.005.07.15.R	1.50	0.05	23	8	1.95	1.40	0.15	7.00	25.00	4.00
4.011	GT104.2319.005.07.20.R	2.00	0.05	23	8	1.95	1.90	0.15	7.00	25.00	4.00
4.022	GT104.2326.005.07.30.R	3.00	0.05	23	8	1.95	2.60	0.20	7.00	25.00	4.00
4.006	GT104.2314.005.12.15.R	1.50	0.05	23	8	1.95	1.40	0.15	12.00	30.00	4.00
4.012	GT104.2319.005.12.20.R	2.00	0.05	23	8	1.95	1.90	0.15	12.00	30.00	4.00
4.023	GT104.2326.005.12.30.R	3.00	0.05	23	8	1.95	2.60	0.20	12.00	30.00	4.00
4.034	GT104.2337.005.12.40.R	4.00	0.05	23	8	1.70	3.70	0.30	12.00	30.00	4.00
4.013	GT104.2319.005.17.20.R	2.00	0.05	23	8	1.95	1.90	0.15	17.00	35.00	4.00
4.024	GT104.2326.005.17.30.R	3.00	0.05	23	8	1.95	2.60	0.20	17.00	35.00	4.00
4.035	GT104.2337.005.17.40.R	4.00	0.05	23	8	1.70	3.70	0.30	17.00	35.00	4.00
4.025	GT104.2326.005.22.30.R	3.00	0.05	23	8	1.95	2.60	0.20	22.00	40.00	4.00
4.036	GT104.2337.005.22.40.R	4.00	0.05	23	8	1.70	3.70	0.30	22.00	40.00	4.00
4.037	GT104.2337.005.27.40.R	4.00	0.05	23	8	1.70	3.70	0.30	27.00	45.00	4.00
4.038	GT104.2337.005.32.40.R	4.00	0.05	23	8	1.70	3.70	0.30	32.00	50.00	4.00
4.007	GT104.2314.010.04.15.R	1.50	0.10	23	8	1.95	1.40	0.15	4.00	25.00	4.00
4.014	GT104.2319.010.04.20.R	2.00	0.10	23	8	1.95	1.90	0.15	4.00	25.00	4.00
4.008	GT104.2314.010.07.15.R	1.50	0.10	23	8	1.95	1.40	0.15	7.00	25.00	4.00
4.015	GT104.2319.010.07.20.R	2.00	0.10	23	8	1.95	1.90	0.15	7.00	25.00	4.00
4.026	GT104.2326.010.07.30.R	3.00	0.10	23	8	1.95	2.60	0.20	7.00	25.00	4.00
4.009	GT104.2314.010.12.15.R	1.50	0.10	23	8	1.95	1.40	0.15	12.00	30.00	4.00
4.016	GT104.2319.010.12.20.R	2.00	0.10	23	8	1.95	1.90	0.15	12.00	30.00	4.00
4.027	GT104.2326.010.12.30.R	3.00	0.10	23	8	1.95	2.60	0.20	12.00	30.00	4.00
4.017	GT104.2319.010.17.20.R	2.00	0.10	23	8	1.95	1.90	0.15	17.00	35.00	4.00
4.028	GT104.2326.010.17.30.R	3.00	0.10	23	8	1.95	2.60	0.20	17.00	35.00	4.00
4.029	GT104.2326.010.22.30.R	3.00	0.10	23	8	1.95	2.60	0.20	22.00	40.00	4.00
4.018	GT104.2319.015.04.20.R	2.00	0.15	23	8	1.95	1.90	0.15	4.00	25.00	4.00
4.019	GT104.2319.015.07.20.R	2.00	0.15	23	8	1.95	1.90	0.15	7.00	25.00	4.00
4.020	GT104.2319.015.12.20.R	2.00	0.15	23	8	1.95	1.90	0.15	12.00	30.00	4.00
4.039	GT104.2337.015.12.40.R	4.00	0.15	23	8	1.70	3.70	0.30	12.00	30.00	4.00
4.021	GT104.2319.015.17.20.R	2.00	0.15	23	8	1.95	1.90	0.15	17.00	35.00	4.00
4.040	GT104.2337.015.17.40.R	4.00	0.15	23	8	1.70	3.70	0.30	17.00	35.00	4.00
4.041	GT104.2337.015.22.40.R	4.00	0.15	23	8	1.70	3.70	0.30	22.00	40.00	4.00
4.042	GT104.2337.015.27.40.R	4.00	0.15	23	8	1.70	3.70	0.30	27.00	45.00	4.00
4.043	GT104.2337.015.32.40.R	4.00	0.15	23	8	1.70	3.70	0.30	32.00	50.00	4.00
4.030	GT104.2326.020.07.30.R	3.00	0.20	23	8	1.95	2.60	0.20	7.00	25.00	4.00
4.031	GT104.2326.020.12.30.R	3.00	0.20	23	8	1.95	2.60	0.20	12.00	30.00	4.00
4.032	GT104.2326.020.17.30.R	3.00	0.20	23	8	1.95	2.60	0.20	17.00	35.00	4.00

Article no. **25050** **25052** **25056**

Cutting direction   

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
4.033	GT104.2326.020.22.30.R	3.00	0.20	23	8	1.95	2.60	0.20	22.00	40.00	4.00
4.044	GT104.2337.025.12.40.R	4.00	0.25	23	8	1.70	3.70	0.30	12.00	30.00	4.00
4.045	GT104.2337.025.17.40.R	4.00	0.25	23	8	1.70	3.70	0.30	17.00	35.00	4.00
4.046	GT104.2337.025.22.40.R	4.00	0.25	23	8	1.70	3.70	0.30	22.00	40.00	4.00
4.047	GT104.2337.025.27.40.R	4.00	0.25	23	8	1.70	3.70	0.30	27.00	45.00	4.00
4.048	GT104.2337.025.32.40.R	4.00	0.25	23	8	1.70	3.70	0.30	32.00	50.00	4.00

Article no. **25051** **25053** **25057**

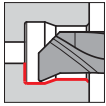
Cutting direction   

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
4.001	GT104.2306.005.03.07.L	0.70	0.05	23	8	1.95	0.60	0.05	3.00	25.00	4.00
4.002	GT104.2309.005.04.10.L	1.00	0.05	23	8	1.95	0.90	0.10	4.00	25.00	4.00
4.004	GT104.2314.005.04.15.L	1.50	0.05	23	8	1.95	1.40	0.15	4.00	25.00	4.00
4.010	GT104.2319.005.04.20.L	2.00	0.05	23	8	1.95	1.90	0.15	4.00	25.00	4.00
4.003	GT104.2309.005.07.10.L	1.00	0.05	23	8	1.95	0.90	0.10	7.00	25.00	4.00
4.005	GT104.2314.005.07.15.L	1.50	0.05	23	8	1.95	1.40	0.15	7.00	25.00	4.00
4.011	GT104.2319.005.07.20.L	2.00	0.05	23	8	1.95	1.90	0.15	7.00	25.00	4.00
4.022	GT104.2326.005.07.30.L	3.00	0.05	23	8	1.95	2.60	0.20	7.00	25.00	4.00
4.006	GT104.2314.005.12.15.L	1.50	0.05	23	8	1.95	1.40	0.15	12.00	30.00	4.00
4.012	GT104.2319.005.12.20.L	2.00	0.05	23	8	1.95	1.90	0.15	12.00	30.00	4.00
4.023	GT104.2326.005.12.30.L	3.00	0.05	23	8	1.95	2.60	0.20	12.00	30.00	4.00
4.034	GT104.2337.005.12.40.L	4.00	0.05	23	8	1.70	3.70	0.30	12.00	30.00	4.00
4.013	GT104.2319.005.17.20.L	2.00	0.05	23	8	1.95	1.90	0.15	17.00	35.00	4.00
4.024	GT104.2326.005.17.30.L	3.00	0.05	23	8	1.95	2.60	0.20	17.00	35.00	4.00
4.035	GT104.2337.005.17.40.L	4.00	0.05	23	8	1.70	3.70	0.30	17.00	35.00	4.00
4.025	GT104.2326.005.22.30.L	3.00	0.05	23	8	1.95	2.60	0.20	22.00	40.00	4.00
4.036	GT104.2337.005.22.40.L	4.00	0.05	23	8	1.70	3.70	0.30	22.00	40.00	4.00
4.037	GT104.2337.005.27.40.L	4.00	0.05	23	8	1.70	3.70	0.30	27.00	45.00	4.00
4.038	GT104.2337.005.32.40.L	4.00	0.05	23	8	1.70	3.70	0.30	32.00	50.00	4.00
4.007	GT104.2314.010.04.15.L	1.50	0.10	23	8	1.95	1.40	0.15	4.00	25.00	4.00
4.014	GT104.2319.010.04.20.L	2.00	0.10	23	8	1.95	1.90	0.15	4.00	25.00	4.00
4.008	GT104.2314.010.07.15.L	1.50	0.10	23	8	1.95	1.40	0.15	7.00	25.00	4.00
4.015	GT104.2319.010.07.20.L	2.00	0.10	23	8	1.95	1.90	0.15	7.00	25.00	4.00
4.026	GT104.2326.010.07.30.L	3.00	0.10	23	8	1.95	2.60	0.20	7.00	25.00	4.00
4.009	GT104.2314.010.12.15.L	1.50	0.10	23	8	1.95	1.40	0.15	12.00	30.00	4.00
4.016	GT104.2319.010.12.20.L	2.00	0.10	23	8	1.95	1.90	0.15	12.00	30.00	4.00
4.027	GT104.2326.010.12.30.L	3.00	0.10	23	8	1.95	2.60	0.20	12.00	30.00	4.00
4.017	GT104.2319.010.17.20.L	2.00	0.10	23	8	1.95	1.90	0.15	17.00	35.00	4.00
4.028	GT104.2326.010.17.30.L	3.00	0.10	23	8	1.95	2.60	0.20	17.00	35.00	4.00
4.029	GT104.2326.010.22.30.L	3.00	0.10	23	8	1.95	2.60	0.20	22.00	40.00	4.00
4.018	GT104.2319.015.04.20.L	2.00	0.15	23	8	1.95	1.90	0.15	4.00	25.00	4.00
4.019	GT104.2319.015.07.20.L	2.00	0.15	23	8	1.95	1.90	0.15	7.00	25.00	4.00
4.020	GT104.2319.015.12.20.L	2.00	0.15	23	8	1.95	1.90	0.15	12.00	30.00	4.00
4.039	GT104.2337.015.12.40.L	4.00	0.15	23	8	1.70	3.70	0.30	12.00	30.00	4.00
4.021	GT104.2319.015.17.20.L	2.00	0.15	23	8	1.95	1.90	0.15	17.00	35.00	4.00
4.040	GT104.2337.015.17.40.L	4.00	0.15	23	8	1.70	3.70	0.30	17.00	35.00	4.00
4.041	GT104.2337.015.22.40.L	4.00	0.15	23	8	1.70	3.70	0.30	22.00	40.00	4.00
4.042	GT104.2337.015.27.40.L	4.00	0.15	23	8	1.70	3.70	0.30	27.00	45.00	4.00
4.043	GT104.2337.015.32.40.L	4.00	0.15	23	8	1.70	3.70	0.30	32.00	50.00	4.00
4.030	GT104.2326.020.07.30.L	3.00	0.20	23	8	1.95	2.60	0.20	7.00	25.00	4.00
4.031	GT104.2326.020.12.30.L	3.00	0.20	23	8	1.95	2.60	0.20	12.00	30.00	4.00
4.032	GT104.2326.020.17.30.L	3.00	0.20	23	8	1.95	2.60	0.20	17.00	35.00	4.00
4.033	GT104.2326.020.22.30.L	3.00	0.20	23	8	1.95	2.60	0.20	22.00	40.00	4.00
4.044	GT104.2337.025.12.40.L	4.00	0.25	23	8	1.70	3.70	0.30	12.00	30.00	4.00
4.045	GT104.2337.025.17.40.L	4.00	0.25	23	8	1.70	3.70	0.30	17.00	35.00	4.00
4.046	GT104.2337.025.22.40.L	4.00	0.25	23	8	1.70	3.70	0.30	22.00	40.00	4.00
4.047	GT104.2337.025.27.40.L	4.00	0.25	23	8	1.70	3.70	0.30	27.00	45.00	4.00
4.048	GT104.2337.025.32.40.L	4.00	0.25	23	8	1.70	3.70	0.30	32.00	50.00	4.00





Cutting insert for boring out and profiling

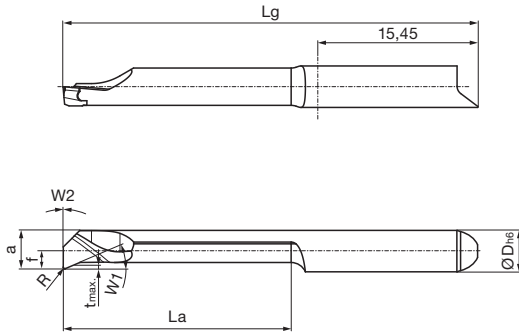


• face flat 90°

for tool holders type GH104/GB104 see from page 16

**GUHRING** NAVIGATOR

Cutting data page 184



Right hand version shown  
Left hand version mirror image

Article no.	<b>25058</b>	<b>25060</b>	<b>25064</b>
Cutting direction			

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
4.001	GT104.9006.005.03.07.R	0.70	0.05	23	0	1.95	0.60	0.05	3.00	25.00	4.00
4.002	GT104.9009.005.04.10.R	1.00	0.05	23	0	1.95	0.90	0.10	4.00	25.00	4.00
4.004	GT104.9014.005.04.15.R	1.50	0.05	23	0	1.95	1.40	0.15	4.00	25.00	4.00
4.010	GT104.9019.005.04.20.R	2.00	0.05	23	0	1.95	1.90	0.15	4.00	25.00	4.00
4.003	GT104.9009.005.07.10.R	1.00	0.05	23	0	1.95	0.90	0.10	7.00	25.00	4.00
4.005	GT104.9014.005.07.15.R	1.50	0.05	23	0	1.95	1.40	0.15	7.00	25.00	4.00
4.011	GT104.9019.005.07.20.R	2.00	0.05	23	0	1.95	1.90	0.15	7.00	25.00	4.00
4.022	GT104.9026.005.07.30.R	3.00	0.05	23	0	1.95	2.60	0.20	7.00	25.00	4.00
4.006	GT104.9014.005.12.15.R	1.50	0.05	23	0	1.95	1.40	0.15	12.00	30.00	4.00
4.012	GT104.9019.005.12.20.R	2.00	0.05	23	0	1.95	1.90	0.15	12.00	30.00	4.00
4.023	GT104.9026.005.12.30.R	3.00	0.05	23	0	1.95	2.60	0.20	12.00	30.00	4.00
4.034	GT104.9037.005.12.40.R	4.00	0.05	23	0	1.70	3.70	0.30	12.00	30.00	4.00
4.013	GT104.9019.005.17.20.R	2.00	0.05	23	0	1.95	1.90	0.15	17.00	35.00	4.00
4.024	GT104.9026.005.17.30.R	3.00	0.05	23	0	1.95	2.60	0.20	17.00	35.00	4.00
4.035	GT104.9037.005.17.40.R	4.00	0.05	23	0	1.70	3.70	0.30	17.00	35.00	4.00
4.025	GT104.9026.005.22.30.R	3.00	0.05	23	0	1.95	2.60	0.20	22.00	40.00	4.00
4.036	GT104.9037.005.22.40.R	4.00	0.05	23	0	1.70	3.70	0.30	22.00	40.00	4.00
4.037	GT104.9037.005.27.40.R	4.00	0.05	23	0	1.70	3.70	0.30	27.00	45.00	4.00
4.038	GT104.9037.005.32.40.R	4.00	0.05	23	0	1.70	3.70	0.30	32.00	50.00	4.00
4.007	GT104.9014.010.04.15.R	1.50	0.10	23	0	1.95	1.40	0.15	4.00	25.00	4.00
4.014	GT104.9019.010.04.20.R	2.00	0.10	23	0	1.95	1.90	0.15	4.00	25.00	4.00
4.008	GT104.9014.010.07.15.R	1.50	0.10	23	0	1.95	1.40	0.15	7.00	25.00	4.00
4.015	GT104.9019.010.07.20.R	2.00	0.10	23	0	1.95	1.90	0.15	7.00	25.00	4.00
4.026	GT104.9026.010.07.30.R	3.00	0.10	23	0	1.95	2.60	0.20	7.00	25.00	4.00
4.009	GT104.9014.010.12.15.R	1.50	0.10	23	0	1.95	1.40	0.15	12.00	30.00	4.00
4.016	GT104.9019.010.12.20.R	2.00	0.10	23	0	1.95	1.90	0.15	12.00	30.00	4.00
4.027	GT104.9026.010.12.30.R	3.00	0.10	23	0	1.95	2.60	0.20	12.00	30.00	4.00
4.017	GT104.9019.010.17.20.R	2.00	0.10	23	0	1.95	1.90	0.15	17.00	35.00	4.00
4.028	GT104.9026.010.17.30.R	3.00	0.10	23	0	1.95	2.60	0.20	17.00	35.00	4.00
4.029	GT104.9026.010.22.30.R	3.00	0.10	23	0	1.95	2.60	0.20	22.00	40.00	4.00
4.018	GT104.9019.015.04.20.R	2.00	0.15	23	0	1.95	1.90	0.15	4.00	25.00	4.00
4.019	GT104.9019.015.07.20.R	2.00	0.15	23	0	1.95	1.90	0.15	7.00	25.00	4.00
4.020	GT104.9019.015.12.20.R	2.00	0.15	23	0	1.95	1.90	0.15	12.00	30.00	4.00
4.039	GT104.9037.015.12.40.R	4.00	0.15	23	0	1.70	3.70	0.30	12.00	30.00	4.00
4.021	GT104.9019.015.17.20.R	2.00	0.15	23	0	1.95	1.90	0.15	17.00	35.00	4.00
4.040	GT104.9037.015.17.40.R	4.00	0.15	23	0	1.70	3.70	0.30	17.00	35.00	4.00
4.041	GT104.9037.015.22.40.R	4.00	0.15	23	0	1.70	3.70	0.30	22.00	40.00	4.00
4.042	GT104.9037.015.27.40.R	4.00	0.15	23	0	1.70	3.70	0.30	27.00	45.00	4.00
4.043	GT104.9037.015.32.40.R	4.00	0.15	23	0	1.70	3.70	0.30	32.00	50.00	4.00
4.030	GT104.9026.020.07.30.R	3.00	0.20	23	0	1.95	2.60	0.20	7.00	25.00	4.00
4.031	GT104.9026.020.12.30.R	3.00	0.20	23	0	1.95	2.60	0.20	12.00	30.00	4.00
4.032	GT104.9026.020.17.30.R	3.00	0.20	23	0	1.95	2.60	0.20	17.00	35.00	4.00

System 104

Article no. **25058** **25060** **25064**

Cutting direction   

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
4.033	GT104.9026.020.22.30.R	3.00	0.20	23	0	1.95	2.60	0.20	22.00	40.00	4.00
4.044	GT104.9037.025.12.40.R	4.00	0.25	23	0	1.70	3.70	0.30	12.00	30.00	4.00
4.045	GT104.9037.025.17.40.R	4.00	0.25	23	0	1.70	3.70	0.30	17.00	35.00	4.00
4.046	GT104.9037.025.22.40.R	4.00	0.25	23	0	1.70	3.70	0.30	22.00	40.00	4.00
4.047	GT104.9037.025.27.40.R	4.00	0.25	23	0	1.70	3.70	0.30	27.00	45.00	4.00
4.048	GT104.9037.025.32.40.R	4.00	0.25	23	0	1.70	3.70	0.30	32.00	50.00	4.00

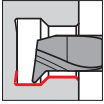
Article no. **25059** **25061** **25065**

Cutting direction   

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
4.001	GT104.9006.005.03.07.L	0.70	0.05	23	0	1.95	0.60	0.05	3.00	25.00	4.00
4.002	GT104.9009.005.04.10.L	1.00	0.05	23	0	1.95	0.90	0.10	4.00	25.00	4.00
4.004	GT104.9014.005.04.15.L	1.50	0.05	23	0	1.95	1.40	0.15	4.00	25.00	4.00
4.010	GT104.9019.005.04.20.L	2.00	0.05	23	0	1.95	1.90	0.15	4.00	25.00	4.00
4.003	GT104.9009.005.07.10.L	1.00	0.05	23	0	1.95	0.90	0.10	7.00	25.00	4.00
4.005	GT104.9014.005.07.15.L	1.50	0.05	23	0	1.95	1.40	0.15	7.00	25.00	4.00
4.011	GT104.9019.005.07.20.L	2.00	0.05	23	0	1.95	1.90	0.15	7.00	25.00	4.00
4.022	GT104.9026.005.07.30.L	3.00	0.05	23	0	1.95	2.60	0.20	7.00	25.00	4.00
4.006	GT104.9014.005.12.15.L	1.50	0.05	23	0	1.95	1.40	0.15	12.00	30.00	4.00
4.012	GT104.9019.005.12.20.L	2.00	0.05	23	0	1.95	1.90	0.15	12.00	30.00	4.00
4.023	GT104.9026.005.12.30.L	3.00	0.05	23	0	1.95	2.60	0.20	12.00	30.00	4.00
4.034	GT104.9037.005.12.40.L	4.00	0.05	23	0	1.70	3.70	0.30	12.00	30.00	4.00
4.013	GT104.9019.005.17.20.L	2.00	0.05	23	0	1.95	1.90	0.15	17.00	35.00	4.00
4.024	GT104.9026.005.17.30.L	3.00	0.05	23	0	1.95	2.60	0.20	17.00	35.00	4.00
4.035	GT104.9037.005.17.40.L	4.00	0.05	23	0	1.70	3.70	0.30	17.00	35.00	4.00
4.025	GT104.9026.005.22.30.L	3.00	0.05	23	0	1.95	2.60	0.20	22.00	40.00	4.00
4.036	GT104.9037.005.22.40.L	4.00	0.05	23	0	1.70	3.70	0.30	22.00	40.00	4.00
4.037	GT104.9037.005.27.40.L	4.00	0.05	23	0	1.70	3.70	0.30	27.00	45.00	4.00
4.038	GT104.9037.005.32.40.L	4.00	0.05	23	0	1.70	3.70	0.30	32.00	50.00	4.00
4.007	GT104.9014.010.04.15.L	1.50	0.10	23	0	1.95	1.40	0.15	4.00	25.00	4.00
4.014	GT104.9019.010.04.20.L	2.00	0.10	23	0	1.95	1.90	0.15	4.00	25.00	4.00
4.008	GT104.9014.010.07.15.L	1.50	0.10	23	0	1.95	1.40	0.15	7.00	25.00	4.00
4.015	GT104.9019.010.07.20.L	2.00	0.10	23	0	1.95	1.90	0.15	7.00	25.00	4.00
4.026	GT104.9026.010.07.30.L	3.00	0.10	23	0	1.95	2.60	0.20	7.00	25.00	4.00
4.009	GT104.9014.010.12.15.L	1.50	0.10	23	0	1.95	1.40	0.15	12.00	30.00	4.00
4.016	GT104.9019.010.12.20.L	2.00	0.10	23	0	1.95	1.90	0.15	12.00	30.00	4.00
4.027	GT104.9026.010.12.30.L	3.00	0.10	23	0	1.95	2.60	0.20	12.00	30.00	4.00
4.017	GT104.9019.010.17.20.L	2.00	0.10	23	0	1.95	1.90	0.15	17.00	35.00	4.00
4.028	GT104.9026.010.17.30.L	3.00	0.10	23	0	1.95	2.60	0.20	17.00	35.00	4.00
4.029	GT104.9026.010.22.30.L	3.00	0.10	23	0	1.95	2.60	0.20	22.00	40.00	4.00
4.018	GT104.9019.015.04.20.L	2.00	0.15	23	0	1.95	1.90	0.15	4.00	25.00	4.00
4.019	GT104.9019.015.07.20.L	2.00	0.15	23	0	1.95	1.90	0.15	7.00	25.00	4.00
4.020	GT104.9019.015.12.20.L	2.00	0.15	23	0	1.95	1.90	0.15	12.00	30.00	4.00
4.039	GT104.9037.015.12.40.L	4.00	0.15	23	0	1.70	3.70	0.30	12.00	30.00	4.00
4.021	GT104.9019.015.17.20.L	2.00	0.15	23	0	1.95	1.90	0.15	17.00	35.00	4.00
4.040	GT104.9037.015.17.40.L	4.00	0.15	23	0	1.70	3.70	0.30	17.00	35.00	4.00
4.041	GT104.9037.015.22.40.L	4.00	0.15	23	0	1.70	3.70	0.30	22.00	40.00	4.00
4.042	GT104.9037.015.27.40.L	4.00	0.15	23	0	1.70	3.70	0.30	27.00	45.00	4.00
4.043	GT104.9037.015.32.40.L	4.00	0.15	23	0	1.70	3.70	0.30	32.00	50.00	4.00
4.030	GT104.9026.020.07.30.L	3.00	0.20	23	0	1.95	2.60	0.20	7.00	25.00	4.00
4.031	GT104.9026.020.12.30.L	3.00	0.20	23	0	1.95	2.60	0.20	12.00	30.00	4.00
4.032	GT104.9026.020.17.30.L	3.00	0.20	23	0	1.95	2.60	0.20	17.00	35.00	4.00
4.033	GT104.9026.020.22.30.L	3.00	0.20	23	0	1.95	2.60	0.20	22.00	40.00	4.00
4.044	GT104.9037.025.12.40.L	4.00	0.25	23	0	1.70	3.70	0.30	12.00	30.00	4.00
4.045	GT104.9037.025.17.40.L	4.00	0.25	23	0	1.70	3.70	0.30	17.00	35.00	4.00
4.046	GT104.9037.025.22.40.L	4.00	0.25	23	0	1.70	3.70	0.30	22.00	40.00	4.00
4.047	GT104.9037.025.27.40.L	4.00	0.25	23	0	1.70	3.70	0.30	27.00	45.00	4.00
4.048	GT104.9037.025.32.40.L	4.00	0.25	23	0	1.70	3.70	0.30	32.00	50.00	4.00



Cutting insert for boring out and profiling

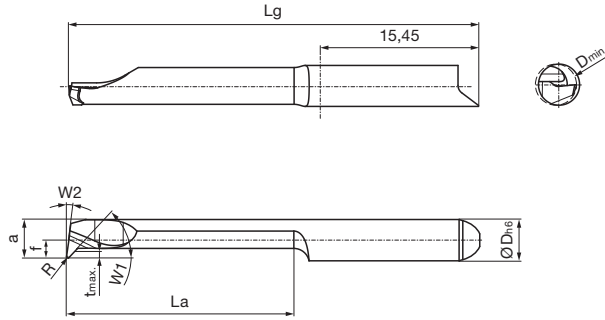


• radial free 47°

for tool holders type GH104/GB104 see from page 16

**GUHRING** NAVIGATOR

Cutting data page 184



Right hand version shown  
Left hand version mirror image



Article no. **25066** **25068** **25072**

Cutting direction

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
4.001	GT104.4717.005.04.20.R	2.00	0.05	47	8	1.95	1.70	0.35	4.00	25.00	4.00
4.002	GT104.4717.005.07.20.R	2.00	0.05	47	8	1.95	1.70	0.35	7.00	25.00	4.00
4.013	GT104.4727.005.07.30.R	3.00	0.05	47	8	1.95	2.70	0.55	7.00	25.00	4.00
4.003	GT104.4717.005.12.20.R	2.00	0.05	47	8	1.95	1.70	0.35	12.00	30.00	4.00
4.014	GT104.4727.005.12.30.R	3.00	0.05	47	8	1.95	2.70	0.55	12.00	30.00	4.00
4.025	GT104.4737.005.12.40.R	4.00	0.05	47	8	1.70	3.70	0.60	12.00	30.00	4.00
4.004	GT104.4717.005.17.20.R	2.00	0.05	47	8	1.95	1.70	0.35	17.00	35.00	4.00
4.015	GT104.4727.005.17.30.R	3.00	0.05	47	8	1.95	2.70	0.55	17.00	35.00	4.00
4.026	GT104.4737.005.17.40.R	4.00	0.05	47	8	1.70	3.70	0.60	17.00	35.00	4.00
4.016	GT104.4727.005.22.30.R	3.00	0.05	47	8	1.95	2.70	0.55	22.00	40.00	4.00
4.027	GT104.4737.005.22.40.R	4.00	0.05	47	8	1.70	3.70	0.60	22.00	40.00	4.00
4.028	GT104.4737.005.27.40.R	4.00	0.05	47	8	1.70	3.70	0.60	27.00	45.00	4.00
4.029	GT104.4737.005.32.40.R	4.00	0.05	47	8	1.70	3.70	0.60	32.00	50.00	4.00
4.005	GT104.4717.010.04.20.R	2.00	0.10	47	8	1.95	1.70	0.35	4.00	25.00	4.00
4.006	GT104.4717.010.07.20.R	2.00	0.10	47	8	1.95	1.70	0.35	7.00	25.00	4.00
4.017	GT104.4727.010.07.30.R	3.00	0.10	47	8	1.95	2.70	0.55	7.00	25.00	4.00
4.007	GT104.4717.010.12.20.R	2.00	0.10	47	8	1.95	1.70	0.35	12.00	30.00	4.00
4.018	GT104.4727.010.12.30.R	3.00	0.10	47	8	1.95	2.70	0.55	12.00	30.00	4.00
4.008	GT104.4717.010.17.20.R	2.00	0.10	47	8	1.95	1.70	0.35	17.00	35.00	4.00
4.019	GT104.4727.010.17.30.R	3.00	0.10	47	8	1.95	2.70	0.55	17.00	35.00	4.00
4.020	GT104.4727.010.22.30.R	3.00	0.10	47	8	1.95	2.70	0.55	22.00	40.00	4.00
4.009	GT104.4717.015.04.20.R	2.00	0.15	47	8	1.95	1.70	0.35	4.00	25.00	4.00
4.010	GT104.4717.015.07.20.R	2.00	0.15	47	8	1.95	1.70	0.35	7.00	25.00	4.00
4.011	GT104.4717.015.12.20.R	2.00	0.15	47	8	1.95	1.70	0.35	12.00	30.00	4.00
4.030	GT104.4737.015.12.40.R	4.00	0.15	47	8	1.70	3.70	0.60	12.00	30.00	4.00
4.012	GT104.4717.015.17.20.R	2.00	0.15	47	8	1.95	1.70	0.35	17.00	35.00	4.00
4.031	GT104.4737.015.17.40.R	4.00	0.15	47	8	1.70	3.70	0.60	17.00	35.00	4.00
4.032	GT104.4737.015.22.40.R	4.00	0.15	47	8	1.70	3.70	0.60	22.00	40.00	4.00
4.033	GT104.4737.015.27.40.R	4.00	0.15	47	8	1.70	3.70	0.60	27.00	45.00	4.00
4.034	GT104.4737.015.32.40.R	4.00	0.15	47	8	1.70	3.70	0.60	32.00	50.00	4.00
4.021	GT104.4727.025.07.30.R	3.00	0.25	47	8	1.95	2.70	0.55	7.00	25.00	4.00
4.022	GT104.4727.025.12.30.R	3.00	0.25	47	8	1.95	2.70	0.55	12.00	30.00	4.00
4.035	GT104.4737.025.12.40.R	4.00	0.25	47	8	1.70	3.70	0.60	12.00	30.00	4.00
4.023	GT104.4727.025.17.30.R	3.00	0.25	47	8	1.95	2.70	0.55	17.00	35.00	4.00
4.036	GT104.4737.025.17.40.R	4.00	0.25	47	8	1.70	3.70	0.60	17.00	35.00	4.00
4.024	GT104.4727.025.22.30.R	3.00	0.25	47	8	1.95	2.70	0.55	22.00	40.00	4.00
4.037	GT104.4737.025.22.40.R	4.00	0.25	47	8	1.70	3.70	0.60	22.00	40.00	4.00
4.038	GT104.4737.025.27.40.R	4.00	0.25	47	8	1.70	3.70	0.60	27.00	45.00	4.00
4.039	GT104.4737.025.32.40.R	4.00	0.25	47	8	1.70	3.70	0.60	32.00	50.00	4.00

Article no. **25067** **25069** **25073**

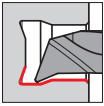
Cutting direction   

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
4.001	GT104.4717.005.04.20.L	2.00	0.05	47	8	1.95	1.70	0.35	4.00	25.00	4.00
4.002	GT104.4717.005.07.20.L	2.00	0.05	47	8	1.95	1.70	0.35	7.00	25.00	4.00
4.013	GT104.4727.005.07.30.L	3.00	0.05	47	8	1.95	2.70	0.55	7.00	25.00	4.00
4.003	GT104.4717.005.12.20.L	2.00	0.05	47	8	1.95	1.70	0.35	12.00	30.00	4.00
4.014	GT104.4727.005.12.30.L	3.00	0.05	47	8	1.95	2.70	0.55	12.00	30.00	4.00
4.025	GT104.4737.005.12.40.L	4.00	0.05	47	8	1.70	3.70	0.60	12.00	30.00	4.00
4.004	GT104.4717.005.17.20.L	2.00	0.05	47	8	1.95	1.70	0.35	17.00	35.00	4.00
4.015	GT104.4727.005.17.30.L	3.00	0.05	47	8	1.95	2.70	0.55	17.00	35.00	4.00
4.026	GT104.4737.005.17.40.L	4.00	0.05	47	8	1.70	3.70	0.60	17.00	35.00	4.00
4.016	GT104.4727.010.22.30.L	3.00	0.05	47	8	1.95	2.70	0.55	22.00	40.00	4.00
4.027	GT104.4737.005.22.40.L	4.00	0.05	47	8	1.70	3.70	0.60	22.00	40.00	4.00
4.028	GT104.4737.005.27.40.L	4.00	0.05	47	8	1.70	3.70	0.60	27.00	45.00	4.00
4.029	GT104.4737.005.32.40.L	4.00	0.05	47	8	1.70	3.70	0.60	32.00	50.00	4.00
4.005	GT104.4717.010.04.20.L	2.00	0.10	47	8	1.95	1.70	0.35	4.00	25.00	4.00
4.006	GT104.4717.010.07.20.L	2.00	0.10	47	8	1.95	1.70	0.35	7.00	25.00	4.00
4.017	GT104.4727.010.07.30.L	3.00	0.10	47	8	1.95	2.70	0.55	7.00	25.00	4.00
4.007	GT104.4717.010.12.20.L	2.00	0.10	47	8	1.95	1.70	0.35	12.00	30.00	4.00
4.018	GT104.4727.010.12.30.L	3.00	0.10	47	8	1.95	2.70	0.55	12.00	30.00	4.00
4.008	GT104.4717.010.17.20.L	2.00	0.10	47	8	1.95	1.70	0.35	17.00	35.00	4.00
4.019	GT104.4727.010.17.30.L	3.00	0.10	47	8	1.95	2.70	0.55	17.00	35.00	4.00
4.020	GT104.4727.010.22.30.L	3.00	0.10	47	8	1.95	2.70	0.55	22.00	40.00	4.00
4.009	GT104.4717.015.04.20.L	2.00	0.15	47	8	1.95	1.70	0.35	4.00	25.00	4.00
4.010	GT104.4717.015.07.20.L	2.00	0.15	47	8	1.95	1.70	0.35	7.00	25.00	4.00
4.011	GT104.4717.015.12.20.L	2.00	0.15	47	8	1.95	1.70	0.35	12.00	30.00	4.00
4.030	GT104.4737.015.12.40.L	4.00	0.15	47	8	1.70	3.70	0.60	12.00	30.00	4.00
4.012	GT104.4717.015.17.20.L	2.00	0.15	47	8	1.95	1.70	0.35	17.00	35.00	4.00
4.031	GT104.4737.015.17.40.L	4.00	0.15	47	8	1.70	3.70	0.60	17.00	35.00	4.00
4.032	GT104.4737.015.22.40.L	4.00	0.15	47	8	1.70	3.70	0.60	22.00	40.00	4.00
4.033	GT104.4737.015.27.40.L	4.00	0.15	47	8	1.70	3.70	0.60	27.00	45.00	4.00
4.034	GT104.4737.015.32.40.L	4.00	0.15	47	8	1.70	3.70	0.60	32.00	50.00	4.00
4.021	GT104.4727.025.07.30.L	3.00	0.25	47	8	1.95	2.70	0.55	7.00	25.00	4.00
4.022	GT104.4727.025.12.30.L	3.00	0.25	47	8	1.95	2.70	0.55	12.00	30.00	4.00
4.035	GT104.4737.025.12.40.L	4.00	0.25	47	8	1.70	3.70	0.60	12.00	30.00	4.00
4.023	GT104.4727.025.17.30.L	3.00	0.25	47	8	1.95	2.70	0.55	17.00	35.00	4.00
4.036	GT104.4737.025.17.40.L	4.00	0.25	47	8	1.70	3.70	0.60	17.00	35.00	4.00
4.024	GT104.4727.025.22.30.L	3.00	0.25	47	8	1.95	2.70	0.55	22.00	40.00	4.00
4.037	GT104.4737.025.22.40.L	4.00	0.25	47	8	1.70	3.70	0.60	22.00	40.00	4.00
4.038	GT104.4737.025.27.40.L	4.00	0.25	47	8	1.70	3.70	0.60	27.00	45.00	4.00
4.039	GT104.4737.025.32.40.L	4.00	0.25	47	8	1.70	3.70	0.60	32.00	50.00	4.00





**Cutting insert for boring out and profiling**

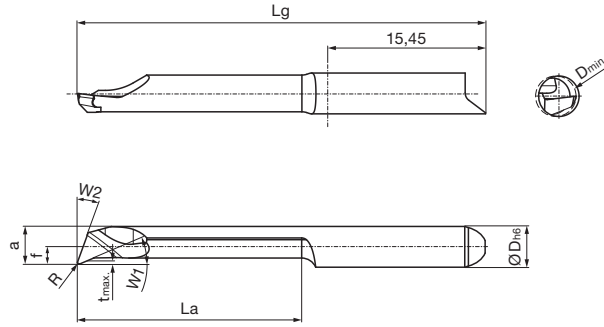


• face free 20°

for tool holders type GH104/GB104 see from page 16

**GUHRING NAVIGATOR**

Cutting data page 184



Right hand version shown  
Left hand version mirror image

Article no. **25074**    **25076**    **25080**

Cutting direction

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
4.001	GT104.2026.005.07.30.R	3.00	0.05	23	20	1.95	2.60	0.20	7.00	25.00	4.00
4.002	GT104.2026.005.12.30.R	3.00	0.05	23	20	1.95	2.60	0.20	12.00	30.00	4.00
4.013	GT104.2037.005.12.40.R	4.00	0.05	23	20	1.70	3.70	0.30	12.00	30.00	4.00
4.003	GT104.2026.005.17.30.R	3.00	0.05	23	20	1.95	2.60	0.20	17.00	35.00	4.00
4.014	GT104.2037.005.17.40.R	4.00	0.05	23	20	1.70	3.70	0.30	17.00	35.00	4.00
4.004	GT104.2026.005.22.30.R	3.00	0.05	23	20	1.95	2.60	0.20	22.00	40.00	4.00
4.015	GT104.2037.005.22.40.R	4.00	0.05	23	20	1.70	3.70	0.30	22.00	40.00	4.00
4.016	GT104.2037.005.27.40.R	4.00	0.05	23	20	1.70	3.70	0.30	27.00	45.00	4.00
4.017	GT104.2037.005.32.40.R	4.00	0.05	23	20	1.70	3.70	0.30	32.00	50.00	4.00
4.005	GT104.2026.010.07.30.R	3.00	0.10	23	20	1.95	2.60	0.20	7.00	25.00	4.00
4.006	GT104.2026.010.12.30.R	3.00	0.10	23	20	1.95	2.60	0.20	12.00	30.00	4.00
4.007	GT104.2026.010.17.30.R	3.00	0.10	23	20	1.95	2.60	0.20	17.00	35.00	4.00
4.008	GT104.2026.010.22.30.R	3.00	0.10	23	20	1.95	2.60	0.20	22.00	40.00	4.00
4.018	GT104.2037.015.12.40.R	4.00	0.15	23	20	1.70	3.70	0.30	12.00	30.00	4.00
4.019	GT104.2037.015.17.40.R	4.00	0.15	23	20	1.70	3.70	0.30	17.00	35.00	4.00
4.020	GT104.2037.015.22.40.R	4.00	0.15	23	20	1.70	3.70	0.30	22.00	40.00	4.00
4.021	GT104.2037.015.27.40.R	4.00	0.15	23	20	1.70	3.70	0.30	27.00	45.00	4.00
4.022	GT104.2037.015.32.40.R	4.00	0.15	23	20	1.70	3.70	0.30	32.00	50.00	4.00
4.009	GT104.2026.020.07.30.R	3.00	0.20	23	20	1.95	2.60	0.20	7.00	25.00	4.00
4.010	GT104.2026.020.12.30.R	3.00	0.20	23	20	1.95	2.60	0.20	12.00	30.00	4.00
4.011	GT104.2026.020.17.30.R	3.00	0.20	23	20	1.95	2.60	0.20	17.00	35.00	4.00
4.012	GT104.2026.020.22.30.R	3.00	0.20	23	20	1.95	2.60	0.20	22.00	40.00	4.00
4.023	GT104.2037.025.12.40.R	4.00	0.25	23	20	1.70	3.70	0.30	12.00	30.00	4.00
4.024	GT104.2037.025.17.40.R	4.00	0.25	23	20	1.70	3.70	0.30	17.00	35.00	4.00
4.025	GT104.2037.025.22.40.R	4.00	0.25	23	20	1.70	3.70	0.30	22.00	40.00	4.00
4.026	GT104.2037.025.27.40.R	4.00	0.25	23	20	1.70	3.70	0.30	27.00	45.00	4.00
4.027	GT104.2037.025.32.40.R	4.00	0.25	23	20	1.70	3.70	0.30	32.00	50.00	4.00

Article no. **25075**    **25077**    **25081**

Cutting direction

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
4.001	GT104.2026.005.07.30.L	3.00	0.05	23	20	1.95	2.60	0.20	7.00	25.00	4.00
4.002	GT104.2026.005.12.30.L	3.00	0.05	23	20	1.95	2.60	0.20	12.00	30.00	4.00
4.013	GT104.2037.005.12.40.L	4.00	0.05	23	20	1.70	3.70	0.30	12.00	30.00	4.00
4.003	GT104.2026.005.17.30.L	3.00	0.05	23	20	1.95	2.60	0.20	17.00	35.00	4.00
4.014	GT104.2037.005.17.40.L	4.00	0.05	23	20	1.70	3.70	0.30	17.00	35.00	4.00
4.004	GT104.2026.005.22.30.L	3.00	0.05	23	20	1.95	2.60	0.20	22.00	40.00	4.00



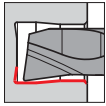
Article no. **25075** **25077** **25081**

Cutting direction

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
4.015	GT104.2037.005.22.40.L	4.00	0.05	23	20	1.70	3.70	0.30	22.00	40.00	4.00
4.016	GT104.2037.005.27.40.L	4.00	0.05	23	20	1.70	3.70	0.30	27.00	45.00	4.00
4.017	GT104.2037.005.32.40.L	4.00	0.05	23	20	1.70	3.70	0.30	32.00	50.00	4.00
4.005	GT104.2026.010.07.30.L	3.00	0.10	23	20	1.95	2.60	0.20	7.00	25.00	4.00
4.006	GT104.2026.010.12.30.L	3.00	0.10	23	20	1.95	2.60	0.20	12.00	30.00	4.00
4.007	GT104.2026.010.17.30.L	3.00	0.10	23	20	1.95	2.60	0.20	17.00	35.00	4.00
4.008	GT104.2026.010.22.30.L	3.00	0.10	23	20	1.95	2.60	0.20	22.00	40.00	4.00
4.018	GT104.2037.015.12.40.L	4.00	0.15	23	20	1.70	3.70	0.30	12.00	30.00	4.00
4.019	GT104.2037.015.17.40.L	4.00	0.15	23	20	1.70	3.70	0.30	17.00	35.00	4.00
4.020	GT104.2037.015.22.40.L	4.00	0.15	23	20	1.70	3.70	0.30	22.00	40.00	4.00
4.021	GT104.2037.015.27.40.L	4.00	0.15	23	20	1.70	3.70	0.30	27.00	45.00	4.00
4.022	GT104.2037.015.32.40.L	4.00	0.15	23	20	1.70	3.70	0.30	32.00	50.00	4.00
4.009	GT104.2026.020.07.30.L	3.00	0.20	23	20	1.95	2.60	0.20	7.00	25.00	4.00
4.010	GT104.2026.020.12.30.L	3.00	0.20	23	20	1.95	2.60	0.20	12.00	30.00	4.00
4.011	GT104.2026.020.17.30.L	3.00	0.20	23	20	1.95	2.60	0.20	17.00	35.00	4.00
4.012	GT104.2026.020.22.30.L	3.00	0.20	23	20	1.95	2.60	0.20	22.00	40.00	4.00
4.023	GT104.2037.025.12.40.L	4.00	0.25	23	20	1.70	3.70	0.30	12.00	30.00	4.00
4.024	GT104.2037.025.17.40.L	4.00	0.25	23	20	1.70	3.70	0.30	17.00	35.00	4.00
4.025	GT104.2037.025.22.40.L	4.00	0.25	23	20	1.70	3.70	0.30	22.00	40.00	4.00
4.026	GT104.2037.025.27.40.L	4.00	0.25	23	20	1.70	3.70	0.30	27.00	45.00	4.00
4.027	GT104.2037.025.32.40.L	4.00	0.25	23	20	1.70	3.70	0.30	32.00	50.00	4.00



**Cutting insert for boring out and profiling**

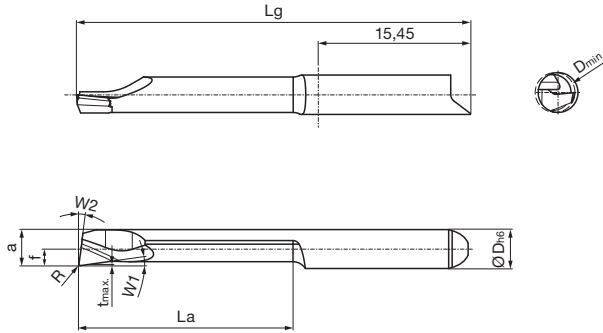


• radial free 8°

for tool holders type GH104/GB104 see from page 16

**GUHRING NAVIGATOR**

Cutting data page 184



Right hand version shown  
Left hand version mirror image



Article no. **25082** **25084** **25088**

Cutting direction

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
4.001	GT104.0827.005.07.30.R	3.00	0.05	8	8	1.95	2.70	0.15	7.00	25.00	4.00
4.002	GT104.0827.005.12.30.R	3.00	0.05	8	8	1.95	2.70	0.15	12.00	30.00	4.00
4.013	GT104.0837.005.12.40.R	4.00	0.05	8	8	1.70	3.70	0.15	12.00	30.00	4.00
4.003	GT104.0827.005.17.30.R	3.00	0.05	8	8	1.95	2.70	0.15	17.00	35.00	4.00
4.014	GT104.0837.005.17.40.R	4.00	0.05	8	8	1.70	3.70	0.15	17.00	35.00	4.00
4.004	GT104.0827.005.22.30.R	3.00	0.05	8	8	1.95	2.70	0.15	22.00	40.00	4.00
4.015	GT104.0837.005.22.40.R	4.00	0.05	8	8	1.70	3.70	0.15	22.00	40.00	4.00
4.016	GT104.0837.005.27.40.R	4.00	0.05	8	8	1.70	3.70	0.15	27.00	45.00	4.00
4.017	GT104.0837.005.32.40.R	4.00	0.05	8	8	1.70	3.70	0.15	32.00	50.00	4.00
4.005	GT104.0827.010.07.30.R	3.00	0.10	8	8	1.95	2.70	0.15	7.00	25.00	4.00
4.006	GT104.0827.010.12.30.R	3.00	0.10	8	8	1.95	2.70	0.15	12.00	30.00	4.00
4.007	GT104.0827.010.17.30.R	3.00	0.10	8	8	1.95	2.70	0.15	17.00	35.00	4.00
4.008	GT104.0827.010.22.30.R	3.00	0.10	8	8	1.95	2.70	0.15	22.00	40.00	4.00
4.018	GT104.0837.015.12.40.R	4.00	0.15	8	8	1.70	3.70	0.15	12.00	30.00	4.00
4.019	GT104.0837.015.17.40.R	4.00	0.15	8	8	1.70	3.70	0.15	17.00	35.00	4.00
4.020	GT104.0837.015.22.40.R	4.00	0.15	8	8	1.70	3.70	0.15	22.00	40.00	4.00
4.021	GT104.0837.015.27.40.R	4.00	0.15	8	8	1.70	3.70	0.15	27.00	45.00	4.00
4.022	GT104.0837.015.32.40.R	4.00	0.15	8	8	1.70	3.70	0.15	32.00	50.00	4.00
4.009	GT104.0827.020.07.30.R	3.00	0.20	8	8	1.95	2.70	0.15	7.00	25.00	4.00
4.010	GT104.0827.020.12.30.R	3.00	0.20	8	8	1.95	2.70	0.15	12.00	30.00	4.00
4.011	GT104.0827.020.17.30.R	3.00	0.20	8	8	1.95	2.70	0.15	17.00	35.00	4.00
4.012	GT104.0827.020.22.30.R	3.00	0.20	8	8	1.95	2.70	0.15	22.00	40.00	4.00
4.023	GT104.0837.025.12.40.R	4.00	0.25	8	8	1.70	3.70	0.15	12.00	30.00	4.00
4.024	GT104.0837.025.17.40.R	4.00	0.25	8	8	1.70	3.70	0.15	17.00	35.00	4.00
4.025	GT104.0837.025.22.40.R	4.00	0.25	8	8	1.70	3.70	0.15	22.00	40.00	4.00
4.026	GT104.0837.025.27.40.R	4.00	0.25	8	8	1.70	3.70	0.15	27.00	45.00	4.00
4.027	GT104.0837.025.32.40.R	4.00	0.25	8	8	1.70	3.70	0.15	32.00	50.00	4.00

Article no. **25083** **25085** **25089**

Cutting direction

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
4.001	GT104.0827.005.07.30.L	3.00	0.05	8	8	1.95	2.70	0.15	7.00	25.00	4.00
4.002	GT104.0827.005.12.30.L	3.00	0.05	8	8	1.95	2.70	0.15	12.00	30.00	4.00
4.013	GT104.0837.005.12.40.L	4.00	0.05	8	8	1.70	3.70	0.15	12.00	30.00	4.00
4.003	GT104.0827.005.17.30.L	3.00	0.05	8	8	1.95	2.70	0.15	17.00	35.00	4.00
4.014	GT104.0837.005.17.40.L	4.00	0.05	8	8	1.70	3.70	0.15	17.00	35.00	4.00
4.004	GT104.0827.005.22.30.L	3.00	0.05	8	8	1.95	2.70	0.15	22.00	40.00	4.00

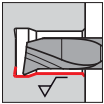
Article no. **25083** **25085** **25089**

Cutting direction   

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
4.015	GT104.0837.005.22.40.L	4.00	0.05	8	8	1.70	3.70	0.15	22.00	40.00	4.00
4.016	GT104.0837.005.27.40.L	4.00	0.05	8	8	1.70	3.70	0.15	27.00	45.00	4.00
4.017	GT104.0837.005.32.40.L	4.00	0.05	8	8	1.70	3.70	0.15	32.00	50.00	4.00
4.005	GT104.0827.010.07.30.L	3.00	0.10	8	8	1.95	2.70	0.15	7.00	25.00	4.00
4.006	GT104.0827.010.12.30.L	3.00	0.10	8	8	1.95	2.70	0.15	12.00	30.00	4.00
4.007	GT104.0827.010.17.30.L	3.00	0.10	8	8	1.95	2.70	0.15	17.00	35.00	4.00
4.008	GT104.0827.010.22.30.L	3.00	0.10	8	8	1.95	2.70	0.15	22.00	40.00	4.00
4.018	GT104.0837.015.12.40.L	4.00	0.15	8	8	1.70	3.70	0.15	12.00	30.00	4.00
4.019	GT104.0837.015.17.40.L	4.00	0.15	8	8	1.70	3.70	0.15	17.00	35.00	4.00
4.020	GT104.0837.015.22.40.L	4.00	0.15	8	8	1.70	3.70	0.15	22.00	40.00	4.00
4.021	GT104.0837.015.27.40.L	4.00	0.15	8	8	1.70	3.70	0.15	27.00	45.00	4.00
4.022	GT104.0837.015.32.40.L	4.00	0.15	8	8	1.70	3.70	0.15	32.00	50.00	4.00
4.009	GT104.0827.020.07.30.L	3.00	0.20	8	8	1.95	2.70	0.15	7.00	25.00	4.00
4.010	GT104.0827.020.12.30.L	3.00	0.20	8	8	1.95	2.70	0.15	12.00	30.00	4.00
4.011	GT104.0827.020.17.30.L	3.00	0.20	8	8	1.95	2.70	0.15	17.00	35.00	4.00
4.012	GT104.0827.020.22.30.L	3.00	0.20	8	8	1.95	2.70	0.15	22.00	40.00	4.00
4.023	GT104.0837.025.12.40.L	4.00	0.25	8	8	1.70	3.70	0.15	12.00	30.00	4.00
4.024	GT104.0837.025.17.40.L	4.00	0.25	8	8	1.70	3.70	0.15	17.00	35.00	4.00
4.025	GT104.0837.025.22.40.L	4.00	0.25	8	8	1.70	3.70	0.15	22.00	40.00	4.00
4.026	GT104.0837.025.27.40.L	4.00	0.25	8	8	1.70	3.70	0.15	27.00	45.00	4.00
4.027	GT104.0837.025.32.40.L	4.00	0.25	8	8	1.70	3.70	0.15	32.00	50.00	4.00



Cutting insert for boring out and profiling

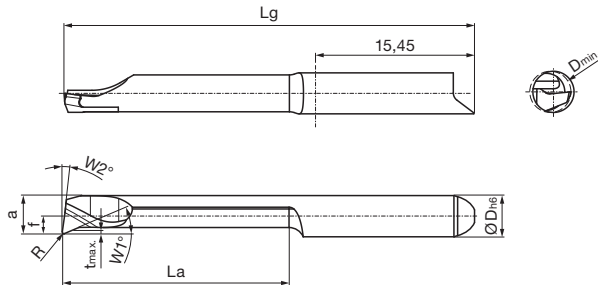


• WIPER-geometry

for tool holders type GH104/GB104 see from page 16

**GUHRING** NAVIGATOR

Cutting data page 184



Right hand version shown  
Left hand version mirror image

Article no. **25090** **25092** **25096**

Cutting direction

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
4.001	GJ104.2319.010.04.20.R	2.00	0.10	23	8	1.95	1.90	0.15	4.00	25.00	4.00
4.002	GJ104.2319.010.07.20.R	2.00	0.10	23	8	1.95	1.90	0.15	7.00	25.00	4.00
4.003	GJ104.2319.010.12.20.R	2.00	0.10	23	8	1.95	1.90	0.15	12.00	30.00	4.00
4.004	GJ104.2319.010.17.20.R	2.00	0.10	23	8	1.95	1.90	0.15	17.00	35.00	4.00
4.005	GJ104.2326.015.07.30.R	3.00	0.15	23	8	1.95	2.60	0.20	7.00	25.00	4.00
4.006	GJ104.2326.015.12.30.R	3.00	0.15	23	8	1.95	2.60	0.20	12.00	30.00	4.00
4.007	GJ104.2326.015.17.30.R	3.00	0.15	23	8	1.95	2.60	0.20	17.00	35.00	4.00
4.008	GJ104.2326.015.22.30.R	3.00	0.15	23	8	1.95	2.60	0.20	22.00	40.00	4.00
4.009	GJ104.2337.020.12.40.R	4.00	0.20	23	8	1.70	3.70	0.30	12.00	30.00	4.00
4.010	GJ104.2337.020.17.40.R	4.00	0.20	23	8	1.70	3.70	0.30	17.00	35.00	4.00
4.011	GJ104.2337.020.22.40.R	4.00	0.20	23	8	1.70	3.70	0.30	22.00	40.00	4.00
4.012	GJ104.2337.020.27.40.R	4.00	0.20	23	8	1.70	3.70	0.30	27.00	45.00	4.00
4.013	GJ104.2337.020.32.40.R	4.00	0.20	23	8	1.70	3.70	0.30	32.00	50.00	4.00

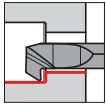
Article no. **25091** **25093** **25097**

Cutting direction

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
4.001	GJ104.2319.010.04.20.L	2.00	0.10	23	8	1.95	1.90	0.15	4.00	25.00	4.00
4.002	GJ104.2319.010.07.20.L	2.00	0.10	23	8	1.95	1.90	0.15	7.00	25.00	4.00
4.003	GJ104.2319.010.12.20.L	2.00	0.10	23	8	1.95	1.90	0.15	12.00	30.00	4.00
4.004	GJ104.2319.010.17.20.L	2.00	0.10	23	8	1.95	1.90	0.15	17.00	35.00	4.00
4.005	GJ104.2326.015.07.30.L	3.00	0.15	23	8	1.95	2.60	0.20	7.00	25.00	4.00
4.006	GJ104.2326.015.12.30.L	3.00	0.15	23	8	1.95	2.60	0.20	12.00	30.00	4.00
4.007	GJ104.2326.015.17.30.L	3.00	0.15	23	8	1.95	2.60	0.20	17.00	35.00	4.00
4.008	GJ104.2326.015.22.30.L	3.00	0.15	23	8	1.95	2.60	0.20	22.00	40.00	4.00
4.009	GJ104.2337.020.12.40.L	4.00	0.20	23	8	1.70	3.70	0.30	12.00	30.00	4.00
4.010	GJ104.2337.020.17.40.L	4.00	0.20	23	8	1.70	3.70	0.30	17.00	35.00	4.00
4.011	GJ104.2337.020.22.40.L	4.00	0.20	23	8	1.70	3.70	0.30	22.00	40.00	4.00
4.012	GJ104.2337.020.27.40.L	4.00	0.20	23	8	1.70	3.70	0.30	27.00	45.00	4.00
4.013	GJ104.2337.020.32.40.L	4.00	0.20	23	8	1.70	3.70	0.30	32.00	50.00	4.00



Cutting insert for back boring and profiling

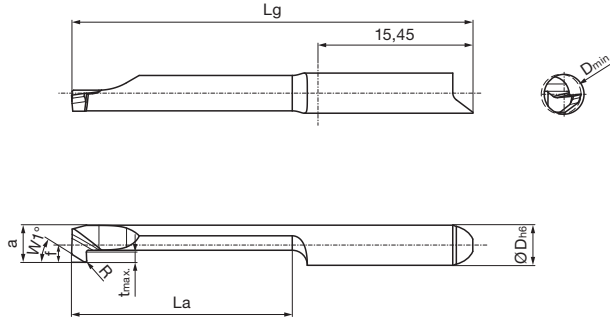


• radial free 32°

for tool holders type GH104/GB104 see from page 16

**GUHRING NAVIGATOR**

Cutting data page 184



Right hand version shown  
Left hand version mirror image



Article no. **25106** **25108** **25112**

Cutting direction

Code no.	Description	D min	R	W1	f	a	t max	La	Lg	D h6
		mm	mm	°	mm	mm	mm	mm	mm	mm
4.001	GT104.3217.010.04.20.R	2.00	0.10	32	1.95	1.70	0.30	4.00	25.00	4.00
4.002	GT104.3217.010.07.20.R	2.00	0.10	32	1.95	1.70	0.30	7.00	25.00	4.00
4.003	GT104.3217.010.12.20.R	2.00	0.10	32	1.95	1.70	0.30	12.00	30.00	4.00
4.004	GT104.3217.010.17.20.R	2.00	0.10	32	1.95	1.70	0.70	17.00	35.00	4.00
4.005	GT104.3226.005.07.30.R	3.00	0.05	32	1.95	2.60	0.70	7.00	25.00	4.00
4.006	GT104.3226.005.12.30.R	3.00	0.05	32	1.95	2.60	0.70	12.00	30.00	4.00
4.007	GT104.3226.005.17.30.R	3.00	0.05	32	1.95	2.60	0.70	17.00	35.00	4.00
4.008	GT104.3226.005.22.30.R	3.00	0.05	32	1.95	2.60	0.70	22.00	40.00	4.00
4.009	GT104.3226.010.07.30.R	3.00	0.10	32	1.95	2.60	0.70	7.00	25.00	4.00
4.010	GT104.3226.010.12.30.R	3.00	0.10	32	1.95	2.60	0.70	12.00	30.00	4.00
4.011	GT104.3226.010.17.30.R	3.00	0.10	32	1.95	2.60	0.70	17.00	35.00	4.00
4.012	GT104.3226.010.22.30.R	3.00	0.10	32	1.95	2.60	0.70	22.00	40.00	4.00
4.013	GT104.3237.010.12.40.R	4.00	0.10	32	1.70	3.70	1.00	12.00	30.00	4.00
4.014	GT104.3237.010.17.40.R	4.00	0.10	32	1.70	3.70	1.00	17.00	35.00	4.00
4.015	GT104.3237.010.22.40.R	4.00	0.10	32	1.70	3.70	1.00	22.00	40.00	4.00
4.016	GT104.3237.010.27.40.R	4.00	0.10	32	1.70	3.70	1.00	27.00	45.00	4.00
4.017	GT104.3237.010.32.40.R	4.00	0.10	32	1.70	3.70	1.00	32.00	50.00	4.00
4.018	GT104.3237.015.12.40.R	4.00	0.15	32	1.70	3.70	1.00	12.00	30.00	4.00
4.019	GT104.3237.015.17.40.R	4.00	0.15	32	1.70	3.70	1.00	17.00	35.00	4.00
4.020	GT104.3237.015.22.40.R	4.00	0.15	32	1.70	3.70	1.00	22.00	40.00	4.00
4.021	GT104.3237.015.27.40.R	4.00	0.15	32	1.70	3.70	1.00	27.00	45.00	4.00
4.022	GT104.3237.015.32.40.R	4.00	0.15	32	1.70	3.70	1.00	32.00	50.00	4.00

Article no. **25107** **25109** **25113**

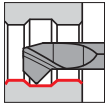
Cutting direction

Code no.	Description	D min	R	W1	f	a	t max	La	Lg	D h6
		mm	mm	°	mm	mm	mm	mm	mm	mm
4.001	GT104.3217.010.04.20.L	2.00	0.10	32	1.95	1.70	0.30	4.00	25.00	4.00
4.002	GT104.3217.010.07.20.L	2.00	0.10	32	1.95	1.70	0.30	7.00	25.00	4.00
4.003	GT104.3217.010.12.20.L	2.00	0.10	32	1.95	1.70	0.30	12.00	30.00	4.00
4.004	GT104.3217.010.17.20.L	2.00	0.10	32	1.95	1.70	0.70	17.00	35.00	4.00
4.005	GT104.3226.005.07.30.L	3.00	0.05	32	1.95	2.60	0.70	7.00	25.00	4.00
4.006	GT104.3226.005.12.30.L	3.00	0.05	32	1.95	2.60	0.70	12.00	30.00	4.00
4.007	GT104.3226.005.17.30.L	3.00	0.05	32	1.95	2.60	0.70	17.00	35.00	4.00
4.008	GT104.3226.005.22.30.L	3.00	0.05	32	1.95	2.60	0.70	22.00	40.00	4.00
4.009	GT104.3226.010.07.30.L	3.00	0.10	32	1.95	2.60	0.70	7.00	25.00	4.00
4.010	GT104.3226.010.12.30.L	3.00	0.10	32	1.95	2.60	0.70	12.00	30.00	4.00
4.011	GT104.3226.010.17.30.L	3.00	0.10	32	1.95	2.60	0.70	17.00	35.00	4.00
4.012	GT104.3226.010.22.30.L	3.00	0.10	32	1.95	2.60	0.70	22.00	40.00	4.00

Article no. **25107** **25109** **25113**Cutting direction   

Code no.	Description	D min	R	W1	f	a	t max	La	Lg	D h6
		mm	mm	°	mm	mm	mm	mm	mm	mm
4.013	GT104.3237.010.12.40.L	4.00	0.10	32	1.70	3.70	1.00	12.00	30.00	4.00
4.014	GT104.3237.010.17.40.L	4.00	0.10	32	1.70	3.70	1.00	17.00	35.00	4.00
4.015	GT104.3237.010.22.40.L	4.00	0.10	32	1.70	3.70	1.00	22.00	40.00	4.00
4.016	GT104.3237.010.27.40.L	4.00	0.10	32	1.70	3.70	1.00	27.00	45.00	4.00
4.017	GT104.3237.010.32.40.L	4.00	0.10	32	1.70	3.70	1.00	32.00	50.00	4.00
4.018	GT104.3237.015.12.40.L	4.00	0.15	32	1.70	3.70	1.00	12.00	30.00	4.00
4.019	GT104.3237.015.17.40.L	4.00	0.15	32	1.70	3.70	1.00	17.00	35.00	4.00
4.020	GT104.3237.015.22.40.L	4.00	0.15	32	1.70	3.70	1.00	22.00	40.00	4.00
4.021	GT104.3237.015.27.40.L	4.00	0.15	32	1.70	3.70	1.00	27.00	45.00	4.00
4.022	GT104.3237.015.32.40.L	4.00	0.15	32	1.70	3.70	1.00	32.00	50.00	4.00

**Cutting insert for boring out and chamfering**

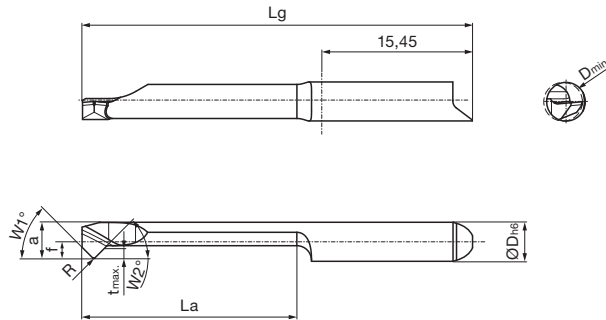


• 45° both sides

for tool holders type GH104/GB104 see from page 16

**GUHRING NAVIGATOR**

Cutting data page 184



Right hand version shown  
Left hand version mirror image



Tool material	Solid carbide		
Type	GT 104	GT 104	GT 104
Surface	<b>S</b>	<b>a</b>	○
	TiN	TiAlN-nanoA	bright

Article no. **25114**    **25116**    **25120**

Cutting direction

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
4.001	GT104.4518.010.04.20.R	2.00	0.10	45	45	1.95	1.80	0.50	4.00	25.00	4.00
4.002	GT104.4518.010.07.20.R	2.00	0.10	45	45	1.95	1.80	0.50	7.00	25.00	4.00
4.005	GT104.4527.010.07.30.R	3.00	0.10	45	45	1.95	2.70	0.70	7.00	25.00	4.00
4.003	GT104.4518.010.12.20.R	2.00	0.10	45	45	1.95	1.80	0.50	12.00	30.00	4.00
4.006	GT104.4527.010.12.30.R	3.00	0.10	45	45	1.95	2.70	0.70	12.00	30.00	4.00
4.004	GT104.4518.010.17.20.R	2.00	0.10	45	45	1.95	1.80	0.50	17.00	35.00	4.00
4.007	GT104.4527.010.17.30.R	3.00	0.10	45	45	1.95	2.70	0.70	17.00	35.00	4.00
4.008	GT104.4527.010.22.30.R	3.00	0.10	45	45	1.95	2.70	0.70	22.00	40.00	4.00
4.009	GT104.4537.015.12.40.R	4.00	0.15	45	45	1.70	3.70	1.00	12.00	30.00	4.00
4.010	GT104.4537.015.17.40.R	4.00	0.15	45	45	1.70	3.70	1.00	17.00	35.00	4.00
4.011	GT104.4537.015.22.40.R	4.00	0.15	45	45	1.70	3.70	1.00	22.00	40.00	4.00
4.012	GT104.4537.015.27.40.R	4.00	0.15	45	45	1.70	3.70	1.00	27.00	45.00	4.00
4.013	GT104.4537.015.32.40.R	4.00	0.15	45	45	1.70	3.70	1.00	32.00	50.00	4.00

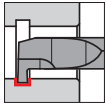
Article no. **25115**    **25117**    **25121**

Cutting direction

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
4.001	GT104.4518.010.04.20.L	2.00	0.10	45	45	1.95	1.80	0.50	4.00	25.00	4.00
4.002	GT104.4518.010.07.20.L	2.00	0.10	45	45	1.95	1.80	0.50	7.00	25.00	4.00
4.005	GT104.4527.010.07.30.L	3.00	0.10	45	45	1.95	2.70	0.70	7.00	25.00	4.00
4.003	GT104.4518.010.12.20.L	2.00	0.10	45	45	1.95	1.80	0.50	12.00	30.00	4.00
4.006	GT104.4527.010.12.30.L	3.00	0.10	45	45	1.95	2.70	0.70	12.00	30.00	4.00
4.004	GT104.4518.010.17.20.L	2.00	0.10	45	45	1.95	1.80	0.50	17.00	35.00	4.00
4.007	GT104.4527.010.17.30.L	3.00	0.10	45	45	1.95	2.70	0.70	17.00	35.00	4.00
4.008	GT104.4527.010.22.30.L	3.00	0.10	45	45	1.95	2.70	0.70	22.00	40.00	4.00
4.009	GT104.4537.015.12.40.L	4.00	0.15	45	45	1.70	3.70	1.00	12.00	30.00	4.00
4.010	GT104.4537.015.17.40.L	4.00	0.15	45	45	1.70	3.70	1.00	17.00	35.00	4.00
4.011	GT104.4537.015.22.40.L	4.00	0.15	45	45	1.70	3.70	1.00	22.00	40.00	4.00
4.012	GT104.4537.015.27.40.L	4.00	0.15	45	45	1.70	3.70	1.00	27.00	45.00	4.00
4.013	GT104.4537.015.32.40.L	4.00	0.15	45	45	1.70	3.70	1.00	32.00	50.00	4.00



**Cutting insert for internal grooving, straight slots**

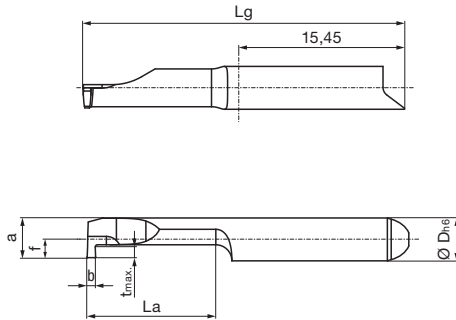


- grooving depth up to 1 mm

for tool holders type GH104/GB104 see from page 16

**GUHRING NAVIGATOR**

Cutting data page 184



Right hand version shown  
Left hand version mirror image

Tool material	Solid carbide		
	GE 104	GE 104	GE 104
Type			
Surface	<b>S</b>	<b>a</b>	○
	TiN	TiAlN-nanoA	bright

System 104

Article no. **25124** **25126** **25130**

Cutting direction

Code no.	Description	D min	b	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
4.001	GE104.0030.000.04.10.R	1.00	0.30	1.95	0.85	0.20	4.00	25.00	4.00
4.002	GE104.0030.000.07.10.R	1.00	0.30	1.95	0.85	0.20	7.00	25.00	4.00
4.003	GE104.0040.000.04.15.R	1.50	0.40	1.95	1.30	0.40	4.00	25.00	4.00
4.004	GE104.0040.000.07.15.R	1.50	0.40	1.95	1.30	0.40	7.00	25.00	4.00
4.005	GE104.0040.000.12.15.R	1.50	0.40	1.95	1.30	0.40	12.00	30.00	4.00
4.006	GE104.0050.000.04.20.R	2.00	0.50	1.95	1.80	0.50	4.00	25.00	4.00
4.007	GE104.0050.000.07.20.R	2.00	0.50	1.95	1.80	0.50	7.00	25.00	4.00
4.008	GE104.0050.000.12.20.R	2.00	0.50	1.95	1.80	0.50	12.00	30.00	4.00
4.009	GE104.0050.000.17.20.R	2.00	0.50	1.95	1.80	0.50	17.00	35.00	4.00
4.010	GE104.0070.000.07.30.R	3.00	0.70	1.95	2.70	0.70	7.00	25.00	4.00
4.011	GE104.0070.000.12.30.R	3.00	0.70	1.95	2.70	0.70	12.00	30.00	4.00
4.012	GE104.0070.000.17.30.R	3.00	0.70	1.95	2.70	0.70	17.00	35.00	4.00
4.013	GE104.0070.000.22.30.R	3.00	0.70	1.95	2.70	0.70	22.00	40.00	4.00
4.014	GE104.0079.000.12.40.R	4.00	0.79	1.70	3.70	1.00	12.00	30.00	4.00
4.015	GE104.0079.000.17.40.R	4.00	0.79	1.70	3.70	1.00	17.00	35.00	4.00
4.016	GE104.0079.000.22.40.R	4.00	0.79	1.70	3.70	1.00	22.00	40.00	4.00
4.017	GE104.0079.000.27.40.R	4.00	0.79	1.70	3.70	1.00	27.00	45.00	4.00
4.018	GE104.0079.000.32.40.R	4.00	0.79	1.70	3.70	1.00	32.00	50.00	4.00
4.019	GE104.0100.000.12.40.R	4.00	1.00	1.70	3.70	1.00	12.00	30.00	4.00
4.020	GE104.0100.000.17.40.R	4.00	1.00	1.70	3.70	1.00	17.00	35.00	4.00
4.021	GE104.0100.000.22.40.R	4.00	1.00	1.70	3.70	1.00	22.00	40.00	4.00
4.022	GE104.0100.000.27.40.R	4.00	1.00	1.70	3.70	1.00	27.00	45.00	4.00
4.023	GE104.0100.000.32.40.R	4.00	1.00	1.70	3.70	1.00	32.00	50.00	4.00
4.024	GE104.0150.000.12.40.R	4.00	1.50	1.70	3.70	1.00	12.00	30.00	4.00
4.025	GE104.0150.000.17.40.R	4.00	1.50	1.70	3.70	1.00	17.00	35.00	4.00
4.026	GE104.0150.000.22.40.R	4.00	1.50	1.70	3.70	1.00	22.00	40.00	4.00
4.027	GE104.0150.000.27.40.R	4.00	1.50	1.70	3.70	1.00	27.00	45.00	4.00
4.028	GE104.0150.000.32.40.R	4.00	1.50	1.70	3.70	1.00	32.00	50.00	4.00

Article no. **25125** **25127** **25131**

Cutting direction

Code no.	Description	D min	b	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
4.001	GE104.0030.000.04.10.L	1.00	0.30	1.95	0.85	0.20	4.00	25.00	4.00
4.002	GE104.0030.000.07.10.L	1.00	0.30	1.95	0.85	0.20	7.00	25.00	4.00
4.003	GE104.0040.000.04.15.L	1.50	0.40	1.95	1.30	0.40	4.00	25.00	4.00
4.004	GE104.0040.000.07.15.L	1.50	0.40	1.95	1.30	0.40	7.00	25.00	4.00
4.005	GE104.0040.000.12.15.L	1.50	0.40	1.95	1.30	0.40	12.00	30.00	4.00
4.006	GE104.0050.000.04.20.L	2.00	0.50	1.95	1.80	0.50	4.00	25.00	4.00



Article no. **25125** **25127** **25131**

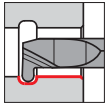
Cutting direction   

Code no.	Description	D min	b	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
4.007	GE104.0050.000.07.20.L	2.00	0.50	1.95	1.80	0.50	7.00	25.00	4.00
4.008	GE104.0050.000.12.20.L	2.00	0.50	1.95	1.80	0.50	12.00	30.00	4.00
4.009	GE104.0050.000.17.20.L	2.00	0.50	1.95	1.80	0.50	17.00	35.00	4.00
4.010	GE104.0070.000.07.30.L	3.00	0.70	1.95	2.70	0.70	7.00	25.00	4.00
4.011	GE104.0070.000.12.30.L	3.00	0.70	1.95	2.70	0.70	12.00	30.00	4.00
4.012	GE104.0070.000.17.30.L	3.00	0.70	1.95	2.70	0.70	17.00	35.00	4.00
4.013	GE104.0070.000.22.30.L	3.00	0.70	1.95	2.70	0.70	22.00	40.00	4.00
4.014	GE104.0079.000.12.40.L	4.00	0.79	1.70	3.70	1.00	12.00	30.00	4.00
4.015	GE104.0079.000.17.40.L	4.00	0.79	1.70	3.70	1.00	17.00	35.00	4.00
4.016	GE104.0079.000.22.40.L	4.00	0.79	1.70	3.70	1.00	22.00	40.00	4.00
4.017	GE104.0079.000.27.40.L	4.00	0.79	1.70	3.70	1.00	27.00	45.00	4.00
4.018	GE104.0079.000.32.40.L	4.00	0.79	1.70	3.70	1.00	32.00	50.00	4.00
4.019	GE104.0100.000.12.40.L	4.00	1.00	1.70	3.70	1.00	12.00	30.00	4.00
4.020	GE104.0100.000.17.40.L	4.00	1.00	1.70	3.70	1.00	17.00	35.00	4.00
4.021	GE104.0100.000.22.40.L	4.00	1.00	1.70	3.70	1.00	22.00	40.00	4.00
4.022	GE104.0100.000.27.40.L	4.00	1.00	1.70	3.70	1.00	27.00	45.00	4.00
4.023	GE104.0100.000.32.40.L	4.00	1.00	1.70	3.70	1.00	32.00	50.00	4.00
4.024	GE104.0150.000.12.40.L	4.00	1.50	1.70	3.70	1.00	12.00	30.00	4.00
4.025	GE104.0150.000.17.40.L	4.00	1.50	1.70	3.70	1.00	17.00	35.00	4.00
4.026	GE104.0150.000.22.40.L	4.00	1.50	1.70	3.70	1.00	22.00	40.00	4.00
4.027	GE104.0150.000.27.40.L	4.00	1.50	1.70	3.70	1.00	27.00	45.00	4.00
4.028	GE104.0150.000.32.40.L	4.00	1.50	1.70	3.70	1.00	32.00	50.00	4.00





Cutting insert for internal grooving, full radius slots

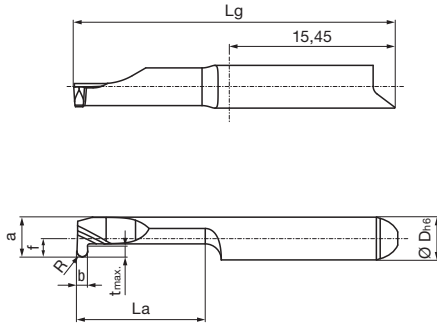


• full radius R0.4-R0.58

for tool holders type GH104/GB104 see from page 16

**GUHRING** NAVIGATOR

Cutting data page 184



Right hand version shown  
Left hand version mirror image

Article no. **25132** **25134** **25138**

Cutting direction

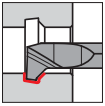
Code no.	Description	D min	b	R	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm	mm
4.001	GE104.0080.040.07.30.R	3.00	0.80	0.40	1.95	2.70	0.70	7.00	25.00	4.00
4.002	GE104.0080.040.12.30.R	3.00	0.80	0.40	1.95	2.70	0.70	12.00	30.00	4.00
4.003	GE104.0080.040.17.30.R	3.00	0.80	0.40	1.95	2.70	0.70	17.00	35.00	4.00
4.004	GE104.0080.040.22.30.R	3.00	0.80	0.40	1.95	2.70	0.70	22.00	40.00	4.00
4.005	GE104.0100.050.12.40.R	4.00	1.00	0.50	1.70	3.70	1.00	12.00	30.00	4.00
4.006	GE104.0100.050.17.40.R	4.00	1.00	0.50	1.70	3.70	1.00	17.00	35.00	4.00
4.007	GE104.0100.050.22.40.R	4.00	1.00	0.50	1.70	3.70	1.00	22.00	40.00	4.00
4.008	GE104.0100.050.27.40.R	4.00	1.00	0.50	1.70	3.70	1.00	27.00	45.00	4.00
4.009	GE104.0100.050.32.40.R	4.00	1.00	0.50	1.70	3.70	1.00	32.00	50.00	4.00
4.010	GE104.0117.058.12.40.R	4.00	1.17	0.58	1.70	3.70	1.00	12.00	30.00	4.00
4.011	GE104.0117.058.17.40.R	4.00	1.17	0.58	1.70	3.70	1.00	17.00	35.00	4.00
4.012	GE104.0117.058.22.40.R	4.00	1.17	0.58	1.70	3.70	1.00	22.00	40.00	4.00
4.013	GE104.0117.058.27.40.R	4.00	1.17	0.58	1.70	3.70	1.00	27.00	45.00	4.00
4.014	GE104.0117.058.32.40.R	4.00	1.17	0.58	1.70	3.70	1.00	32.00	50.00	4.00

Article no. **25133** **25135** **25139**

Cutting direction

Code no.	Description	D min	b	R	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm	mm
4.001	GE104.0080.040.07.30.L	3.00	0.80	0.40	1.95	2.70	0.70	7.00	25.00	4.00
4.002	GE104.0080.040.12.30.L	3.00	0.80	0.40	1.95	2.70	0.70	12.00	30.00	4.00
4.003	GE104.0080.040.17.30.L	3.00	0.80	0.40	1.95	2.70	0.70	17.00	35.00	4.00
4.004	GE104.0080.040.22.30.L	3.00	0.80	0.40	1.95	2.70	0.70	22.00	40.00	4.00
4.005	GE104.0100.050.12.40.L	4.00	1.00	0.50	1.70	3.70	1.00	12.00	30.00	4.00
4.006	GE104.0100.050.17.40.L	4.00	1.00	0.50	1.70	3.70	1.00	17.00	35.00	4.00
4.007	GE104.0100.050.22.40.L	4.00	1.00	0.50	1.70	3.70	1.00	22.00	40.00	4.00
4.008	GE104.0100.050.27.40.L	4.00	1.00	0.50	1.70	3.70	1.00	27.00	45.00	4.00
4.009	GE104.0100.050.32.40.L	4.00	1.00	0.50	1.70	3.70	1.00	32.00	50.00	4.00
4.010	GE104.0117.058.12.40.L	4.00	1.17	0.58	1.70	3.70	1.00	12.00	30.00	4.00
4.011	GE104.0117.058.17.40.L	4.00	1.17	0.58	1.70	3.70	1.00	17.00	35.00	4.00
4.012	GE104.0117.058.22.40.L	4.00	1.17	0.58	1.70	3.70	1.00	22.00	40.00	4.00
4.013	GE104.0117.058.27.40.L	4.00	1.17	0.58	1.70	3.70	1.00	27.00	45.00	4.00
4.014	GE104.0117.058.32.40.L	4.00	1.17	0.58	1.70	3.70	1.00	32.00	50.00	4.00

Cutting insert for internal pre-grooving and chamfering



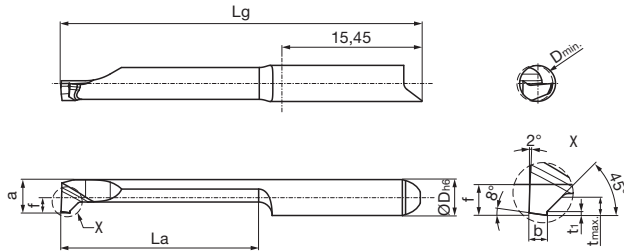
• 45° chamfer

for tool holders type GH104/GB104 see from page 16

**GUHRING NAVIGATOR**

Cutting data page 184

Tool material	Solid carbide		
Type	GV 104	GV 104	GV 104
Surface	<b>S</b>	<b>a</b>	○
	TiN	TiAlN-nanoA	bright



Right hand version shown  
Left hand version mirror image

Article no. **25140** **25142** **25146**

Cutting direction **(R)** **(R)** **(R)**

Code no.	Description	D min	b	f	t1	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm	mm
4.001	GV104.0807.045.04.20.R	2.00	0.70	1.95	0.20	1.80	0.50	4.00	25.00	4.00
4.002	GV104.0807.045.07.20.R	2.00	0.70	1.95	0.20	1.80	0.50	7.00	25.00	4.00
4.003	GV104.0807.045.12.20.R	2.00	0.70	1.95	0.20	1.80	0.50	12.00	30.00	4.00
4.004	GV104.0807.045.17.20.R	2.00	0.70	1.95	0.20	1.80	0.50	17.00	35.00	4.00
4.005	GV104.0807.045.07.30.R	3.00	0.70	1.95	0.20	2.70	0.70	7.00	25.00	4.00
4.006	GV104.0807.045.12.30.R	3.00	0.70	1.95	0.20	2.70	0.70	12.00	30.00	4.00
4.007	GV104.0807.045.17.30.R	3.00	0.70	1.95	0.20	2.70	0.70	17.00	35.00	4.00
4.008	GV104.0807.045.22.30.R	3.00	0.70	1.95	0.20	2.70	0.70	22.00	40.00	4.00
4.009	GV104.0810.045.12.40.R	4.00	1.00	1.70	0.20	3.70	1.00	12.00	30.00	4.00
4.010	GV104.0810.045.17.40.R	4.00	1.00	1.70	0.20	3.70	1.00	17.00	35.00	4.00
4.011	GV104.0810.045.22.40.R	4.00	1.00	1.70	0.20	3.70	1.00	22.00	40.00	4.00
4.012	GV104.0810.045.27.40.R	4.00	1.00	1.70	0.20	3.70	1.00	27.00	45.00	4.00
4.013	GV104.0810.045.32.40.R	4.00	1.00	1.70	0.20	3.70	1.00	32.00	50.00	4.00

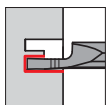
Article no. **25141** **25143** **25147**

Cutting direction **(L)** **(L)** **(L)**

Code no.	Description	D min	b	f	t1	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm	mm
4.001	GV104.0807.045.04.20.L	2.00	0.70	1.95	0.20	1.80	0.50	4.00	25.00	4.00
4.002	GV104.0807.045.07.20.L	2.00	0.70	1.95	0.20	1.80	0.50	7.00	25.00	4.00
4.003	GV104.0807.045.12.20.L	2.00	0.70	1.95	0.20	1.80	0.50	12.00	30.00	4.00
4.004	GV104.0807.045.17.20.L	2.00	0.70	1.95	0.20	1.80	0.50	17.00	35.00	4.00
4.005	GV104.0807.045.07.30.L	3.00	0.70	1.95	0.20	2.70	0.70	7.00	25.00	4.00
4.006	GV104.0807.045.12.30.L	3.00	0.70	1.95	0.20	2.70	0.70	12.00	30.00	4.00
4.007	GV104.0807.045.17.30.L	3.00	0.70	1.95	0.20	2.70	0.70	17.00	35.00	4.00
4.008	GV104.0807.045.22.30.L	3.00	0.70	1.95	0.20	2.70	0.70	22.00	40.00	4.00
4.009	GV104.0810.045.12.40.L	4.00	1.00	1.70	0.20	3.70	1.00	12.00	30.00	4.00
4.010	GV104.0810.045.17.40.L	4.00	1.00	1.70	0.20	3.70	1.00	17.00	35.00	4.00
4.011	GV104.0810.045.22.40.L	4.00	1.00	1.70	0.20	3.70	1.00	22.00	40.00	4.00
4.012	GV104.0810.045.27.40.L	4.00	1.00	1.70	0.20	3.70	1.00	27.00	45.00	4.00
4.013	GV104.0810.045.32.40.L	4.00	1.00	1.70	0.20	3.70	1.00	32.00	50.00	4.00



**Cutting insert for axial grooving bores, straight slots**

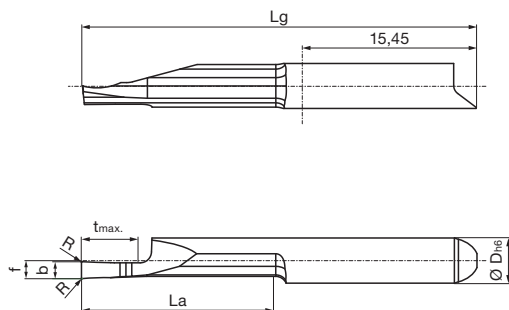


- grooving depth up to 5 mm

for tool holders type GH104/GB104 see from page 16

**GUHRING NAVIGATOR**

Cutting data page 184



Right hand version shown  
Left hand version mirror image

Article no. **25188**    **25190**    **25194**

Cutting direction

Code no.	Description	D min	b	R	f	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
4.001	GA104.0100.005.12.40.R	4.00	1.00	0.05	1.60	2.00	12.00	30.00	4.00
4.002	GA104.0100.005.17.40.R	4.00	1.00	0.05	1.60	2.00	17.00	35.00	4.00
4.003	GA104.0150.005.12.40.R	4.00	1.50	0.05	1.60	3.00	12.00	30.00	4.00
4.004	GA104.0150.005.17.40.R	4.00	1.50	0.05	1.60	3.00	17.00	35.00	4.00
4.005	GA104.0200.005.12.50.R	5.00	2.00	0.05	1.60	5.00	12.00	30.00	4.00
4.006	GA104.0200.005.17.50.R	5.00	2.00	0.05	1.60	5.00	17.00	35.00	4.00

Article no. **25189**    **25191**    **25195**

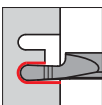
Cutting direction

Code no.	Description	D min	b	R	f	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
4.001	GA104.0100.005.12.40.L	4.00	1.00	0.05	1.60	2.00	12.00	30.00	4.00
4.002	GA104.0100.005.17.40.L	4.00	1.00	0.05	1.60	2.00	17.00	35.00	4.00
4.003	GA104.0150.005.12.40.L	4.00	1.50	0.05	1.60	3.00	12.00	30.00	4.00
4.004	GA104.0150.005.17.40.L	4.00	1.50	0.05	1.60	3.00	17.00	35.00	4.00
4.005	GA104.0200.005.12.50.L	5.00	2.00	0.05	1.60	5.00	12.00	30.00	4.00
4.006	GA104.0200.005.17.50.L	5.00	2.00	0.05	1.60	5.00	17.00	35.00	4.00

System 104



**Cutting insert for axial grooving bores, full radius slots**

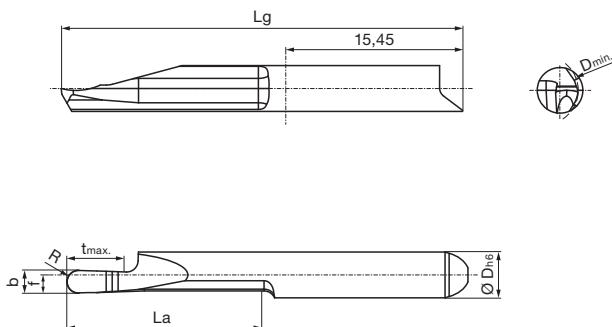


- grooving depth up to 5 mm

for tool holders type GH104/GB104 see from page 16

**GUHRING NAVIGATOR**

Cutting data page 184



Right hand version shown  
Left hand version mirror image

Tool material	Solid carbide		
Type	GA 104	GA 104	GA 104
Surface	<b>S</b> TiN	<b>a</b> TiAlN-nanoA	bright



Article no. **25196**    **25198**    **25202**

Cutting direction

Code no.	Description	D min	b	R	f	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
4.001	GA104.0100.050.12.60.R	6.00	1.00	0.50	1.60	2.00	12.00	30.00	4.00
4.002	GA104.0100.050.17.60.R	6.00	1.00	0.50	1.60	2.00	17.00	35.00	4.00
4.003	GA104.0150.075.12.60.R	6.00	1.50	0.75	1.60	3.00	12.00	30.00	4.00
4.004	GA104.0150.075.17.60.R	6.00	1.50	0.75	1.60	3.00	17.00	35.00	4.00
4.005	GA104.0200.100.12.60.R	6.00	2.00	1.00	1.60	5.00	12.00	30.00	4.00
4.006	GA104.0200.100.17.60.R	6.00	2.00	1.00	1.60	5.00	17.00	35.00	4.00

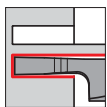
Article no. **25197**    **25199**    **25203**

Cutting direction

Code no.	Description	D min	b	R	f	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
4.001	GA104.0100.050.12.60.L	6.00	1.00	0.50	1.60	2.00	12.00	30.00	4.00
4.002	GA104.0100.050.17.60.L	6.00	1.00	0.50	1.60	2.00	17.00	35.00	4.00
4.003	GA104.0150.075.12.60.L	6.00	1.50	0.75	1.60	3.00	12.00	30.00	4.00
4.004	GA104.0150.075.17.60.L	6.00	1.50	0.75	1.60	3.00	17.00	35.00	4.00
4.005	GA104.0200.100.12.60.L	6.00	2.00	1.00	1.60	5.00	12.00	30.00	4.00
4.006	GA104.0200.100.17.60.L	6.00	2.00	1.00	1.60	5.00	17.00	35.00	4.00



**Cutting insert for axial grooving studs, straight slots**



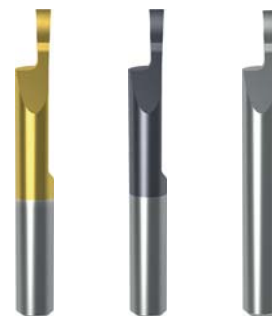
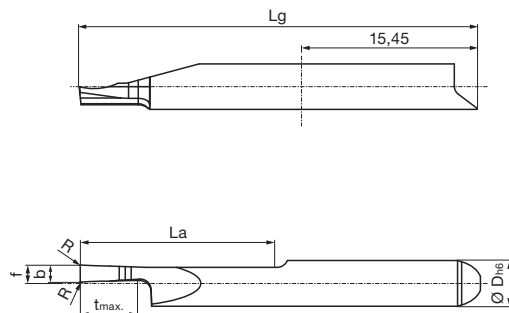
- grooving depth up to 5 mm

for tool holders type GH104/GB104 see from page 16

**GUHRING NAVIGATOR**

Cutting data page 184

Tool material	Solid carbide		
Type	GA 104	GA 104	GA 104
Surface	<b>S</b>	<b>a</b>	○
	TiN	TiAlN-nanoA	bright



Right hand version shown  
Left hand version mirror image

Article no. **25204** **25206** **25210**

Cutting direction **(R)** **(R)** **(R)**

Code no.	Description	D min	b	R	f	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
4.001	GA104.Z100.005.12.40.R	4.00	1.00	0.05	1.60	2.00	12.00	30.00	4.00
4.002	GA104.Z100.005.17.40.R	4.00	1.00	0.05	1.60	2.00	17.00	35.00	4.00
4.003	GA104.Z150.005.12.40.R	4.00	1.50	0.05	1.60	3.00	12.00	30.00	4.00
4.004	GA104.Z150.005.17.40.R	4.00	1.50	0.05	1.60	3.00	17.00	35.00	4.00
4.005	GA104.Z200.005.12.50.R	5.00	2.00	0.05	1.60	5.00	12.00	30.00	4.00
4.006	GA104.Z200.005.17.50.R	5.00	2.00	0.05	1.60	5.00	17.00	35.00	4.00

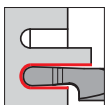
Article no. **25205** **25207** **25211**

Cutting direction **(L)** **(L)** **(L)**

Code no.	Description	D min	b	R	f	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
4.001	GA104.Z100.005.12.40.L	4.00	1.00	0.05	1.60	2.00	12.00	30.00	4.00
4.002	GA104.Z100.005.17.40.L	4.00	1.00	0.05	1.60	2.00	17.00	35.00	4.00
4.003	GA104.Z150.005.12.40.L	4.00	1.50	0.05	1.60	3.00	12.00	30.00	4.00
4.004	GA104.Z150.005.17.40.L	4.00	1.50	0.05	1.60	3.00	17.00	35.00	4.00
4.005	GA104.Z200.005.12.50.L	5.00	2.00	0.05	1.60	5.00	12.00	30.00	4.00
4.006	GA104.Z200.005.17.50.L	5.00	2.00	0.05	1.60	5.00	17.00	35.00	4.00



**Cutting insert for axial grooving studs, full radius slots**



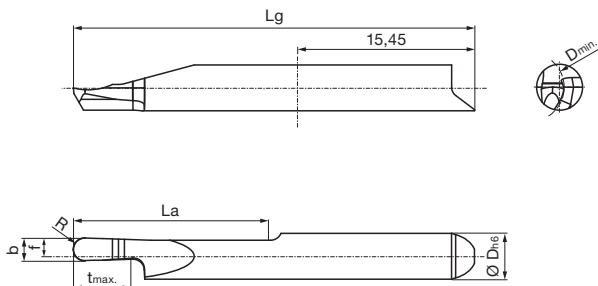
- grooving depth up to 5 mm

for tool holders type GH104/GB104 see from page 16

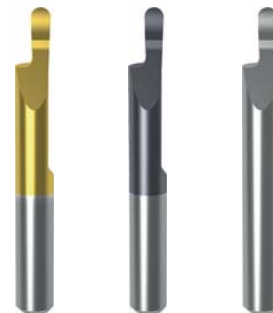
**GUHRING NAVIGATOR**

Cutting data page 184

Tool material	Solid carbide		
Type	GA 104	GA 104	GA 104
Surface	<b>S</b>	<b>a</b>	○
	TiN	TiAlN-nanoA	bright



Right hand version shown  
Left hand version mirror image



Article no. **25212**    **25214**    **25218**

Cutting direction

Code no.	Description	D min	b	R	f	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
4.001	GA104.Z100.050.12.60.R	6.00	1.00	0.50	1.60	2.00	12.00	30.00	4.00
4.002	GA104.Z100.050.17.60.R	6.00	1.00	0.50	1.60	2.00	17.00	35.00	4.00
4.003	GA104.Z150.075.12.60.R	6.00	1.50	0.75	1.60	3.00	12.00	30.00	4.00
4.004	GA104.Z150.075.17.60.R	6.00	1.50	0.75	1.60	3.00	17.00	35.00	4.00
4.005	GA104.Z200.100.12.60.R	6.00	2.00	1.00	1.60	5.00	12.00	30.00	4.00
4.006	GA104.Z200.100.17.60.R	6.00	2.00	1.00	1.60	5.00	17.00	35.00	4.00

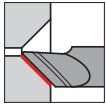
Article no. **25213**    **25215**    **25219**

Cutting direction

Code no.	Description	D min	b	R	f	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
4.001	GA104.Z100.050.12.60.L	6.00	1.00	0.50	1.60	2.00	12.00	30.00	4.00
4.002	GA104.Z100.050.17.60.L	6.00	1.00	0.50	1.60	2.00	17.00	35.00	4.00
4.003	GA104.Z150.075.12.60.L	6.00	1.50	0.75	1.60	3.00	12.00	30.00	4.00
4.004	GA104.Z150.075.17.60.L	6.00	1.50	0.75	1.60	3.00	17.00	35.00	4.00
4.005	GA104.Z200.100.12.60.L	6.00	2.00	1.00	1.60	5.00	12.00	30.00	4.00
4.006	GA104.Z200.100.17.60.L	6.00	2.00	1.00	1.60	5.00	17.00	35.00	4.00



**Cutting insert for axial chamfering bores**



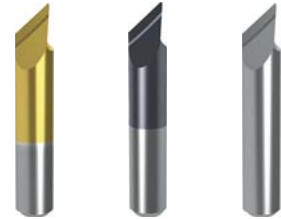
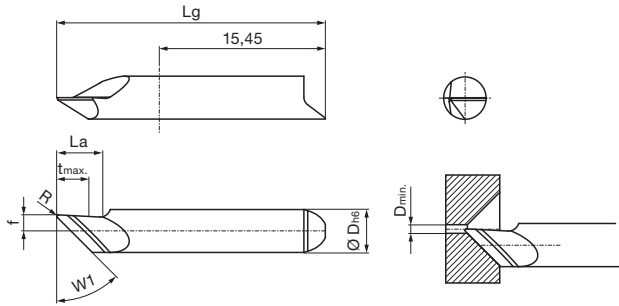
- 45°/60°/75° chamfer angle

for tool holders type GH104/GB104 see from page 16

**GUHRING NAVIGATOR**

Cutting data page 184

Tool material	Solid carbide		
Type	GA 104	GA 104	GA 104
Surface	<b>S</b>	<b>a</b>	○
	TiN	TiAlN-nanoA	bright



Right hand version shown  
Left hand version mirror image

Article no. **25220**    **25222**    **25226**

Cutting direction

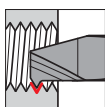
Code no.	Description	D min	R	W1	f	t max	La	Lg	D h6
		mm	mm	°	mm	mm	mm	mm	mm
4.001	GA104.F045.015.04.08.R	0.80	0.15	45.00	1.50	3.00	4.00	25.00	4.00
4.002	GA104.F060.015.04.08.R	0.80	0.15	60.00	0.50	3.50	4.00	25.00	4.00
4.003	GA104.F075.015.04.08.R	0.80	0.15	75.00	0.50	2.00	4.00	25.00	4.00

Article no. **25221**    **25223**    **25227**

Cutting direction

Code no.	Description	D min	R	W1	f	t max	La	Lg	D h6
		mm	mm	°	mm	mm	mm	mm	mm
4.001	GA104.F045.015.04.08.L	0.80	0.15	45.00	1.50	3.00	4.00	25.00	4.00
4.002	GA104.F060.015.04.08.L	0.80	0.15	60.00	0.50	3.50	4.00	25.00	4.00
4.003	GA104.F075.015.04.08.L	0.80	0.15	75.00	0.50	2.00	4.00	25.00	4.00

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



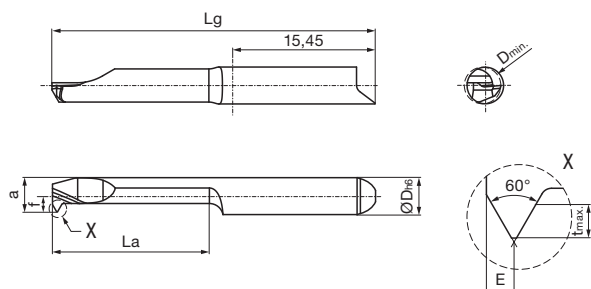
• pitch P = 0.4-1.0

for tool holders type GH104/GB104 see from page 16

**GUHRING** NAVIGATOR

Cutting data page 184

Tool material	Solid carbide			
	Type	GG 104	GG 104	GG 104
Surface	<b>S</b>	<b>a</b>	○	
	TiN	TiAlN-nanoA	bright	



Right hand version shown  
Left hand version mirror image

Article no.	25148	25150	25154
Cutting direction	<b>(R)</b>	<b>(R)</b>	<b>(R)</b>

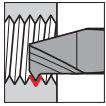
Code no.	Description	G	P	D min	f	t max	a	E	La	Lg	D h6
				mm	mm	mm	mm	mm	mm	mm	mm
4.001	GG104.TM02.040.04.15.R	M2/M2,5	0.40-0.45	1.50	1.95	0.25	1.40	0.25	4.00	25.00	4.00
4.002	GG104.TM02.040.07.15.R	M2/M2,5	0.40-0.45	1.50	1.95	0.25	1.40	0.25	7.00	25.00	4.00
4.003	GG104.TM02.040.12.15.R	M2/M2,5	0.40-0.45	1.50	1.95	0.25	1.40	0.25	12.00	30.00	4.00
4.004	GG104.TM03.050.04.25.R	M3	0.50	2.50	1.95	0.30	2.20	0.30	4.00	25.00	4.00
4.005	GG104.TM03.050.07.25.R	M3	0.50	2.50	1.95	0.30	2.20	0.30	7.00	25.00	4.00
4.006	GG104.TM03.050.12.25.R	M3	0.50	2.50	1.95	0.30	2.20	0.30	12.00	30.00	4.00
4.007	GG104.TM04.070.07.33.R	M4	0.70	3.30	1.95	0.40	3.00	0.40	7.00	25.00	4.00
4.008	GG104.TM04.070.12.33.R	M4	0.70	3.30	1.95	0.40	3.00	0.40	12.00	30.00	4.00
4.009	GG104.TM04.070.17.33.R	M4	0.70	3.30	1.95	0.40	3.00	0.40	17.00	35.00	4.00
4.010	GG104.TM05.080.12.40.R	M5/M6	0.80-1.00	4.00	1.70	0.60	3.70	0.50	12.00	30.00	4.00
4.011	GG104.TM05.080.17.40.R	M5/M6	0.80-1.00	4.00	1.70	0.60	3.70	0.50	17.00	35.00	4.00
4.012	GG104.TM05.080.22.40.R	M5/M6	0.80-1.00	4.00	1.70	0.60	3.70	0.50	22.00	40.00	4.00

Article no.	25149	25151	25155
Cutting direction	<b>(L)</b>	<b>(L)</b>	<b>(L)</b>

Code no.	Description	G	P	D min	f	t max	a	E	La	Lg	D h6
				mm	mm	mm	mm	mm	mm	mm	mm
4.001	GG104.TM02.040.04.15.L	M2/M2,5	0.40-0.45	1.50	1.95	0.25	1.40	0.25	4.00	25.00	4.00
4.002	GG104.TM02.040.07.15.L	M2/M2,5	0.40-0.45	1.50	1.95	0.25	1.40	0.25	7.00	25.00	4.00
4.003	GG104.TM02.040.12.15.L	M2/M2,5	0.40-0.45	1.50	1.95	0.25	1.40	0.25	12.00	30.00	4.00
4.004	GG104.TM03.050.04.25.L	M3	0.50	2.50	1.95	0.30	2.20	0.30	4.00	25.00	4.00
4.005	GG104.TM03.050.07.25.L	M3	0.50	2.50	1.95	0.30	2.20	0.30	7.00	25.00	4.00
4.006	GG104.TM03.050.12.25.L	M3	0.50	2.50	1.95	0.30	2.20	0.30	12.00	30.00	4.00
4.007	GG104.TM04.070.07.33.L	M4	0.70	3.30	1.95	0.40	3.00	0.40	7.00	25.00	4.00
4.008	GG104.TM04.070.12.33.L	M4	0.70	3.30	1.95	0.40	3.00	0.40	12.00	30.00	4.00
4.009	GG104.TM04.070.17.33.L	M4	0.70	3.30	1.95	0.40	3.00	0.40	17.00	35.00	4.00
4.010	GG104.TM05.080.12.40.L	M5/M6	0.80-1.00	4.00	1.70	0.60	3.70	0.50	12.00	30.00	4.00
4.011	GG104.TM05.080.17.40.L	M5/M6	0.80-1.00	4.00	1.70	0.60	3.70	0.50	17.00	35.00	4.00
4.012	GG104.TM05.080.22.40.L	M5/M6	0.80-1.00	4.00	1.70	0.60	3.70	0.50	22.00	40.00	4.00



**Cutting insert for internal threading, part profile - metric fine threads**



• pitch P = 0.2-0.5

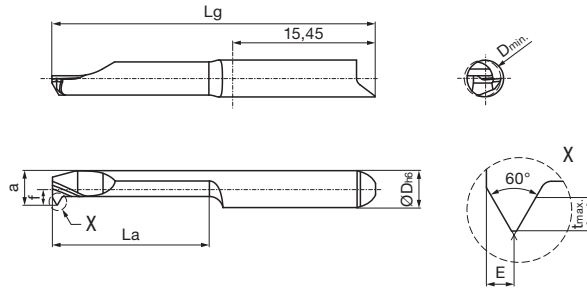
for tool holders type GH104/GB104 see from page 16

**GUHRING NAVIGATOR**

Cutting data page 184

Tool material	Solid carbide		
Type	GG 104	GG 104	GG 104
Surface	<b>S</b>	<b>a</b>	○
	TiN	TiAlN-nanoA	bright

System 104



Right hand version shown  
Left hand version mirror image

Article no. **25156**    **25158**    **25162**

Cutting direction

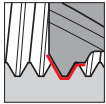
Code no.	Description	G	P	D min	f	t max	a	E	La	Lg	D h6
				mm	mm	mm	mm	mm	mm	mm	mm
4.001	GG104.TM02.020.04.17.R	M2/M3	0.20-0.30	1.70	1.95	0.20	1.55	0.20	4.00	25.00	4.00
4.002	GG104.TM02.020.07.17.R	M2/M3	0.20-0.30	1.70	1.95	0.20	1.55	0.20	7.00	25.00	4.00
4.003	GG104.TM02.020.12.17.R	M2/M3	0.20-0.30	1.70	1.95	0.20	1.55	0.20	12.00	30.00	4.00
4.004	GG104.TM04.035.07.35.R	M4/M5	0.35-0.50	3.50	1.95	0.30	3.20	0.35	7.00	25.00	4.00
4.005	GG104.TM04.035.12.35.R	M4/M5	0.35-0.50	3.50	1.95	0.30	3.20	0.35	12.00	30.00	4.00
4.006	GG104.TM04.035.17.35.R	M4/M5	0.35-0.50	3.50	1.95	0.30	3.20	0.35	17.00	35.00	4.00

Article no. **25157**    **25159**    **25163**

Cutting direction

Code no.	Description	G	P	D min	f	t max	a	E	La	Lg	D h6
				mm	mm	mm	mm	mm	mm	mm	mm
4.001	GG104.TM02.020.04.17.L	M2/M3	0.20-0.30	1.70	1.95	0.20	1.55	0.20	4.00	25.00	4.00
4.002	GG104.TM02.020.07.17.L	M2/M3	0.20-0.30	1.70	1.95	0.20	1.55	0.20	7.00	25.00	4.00
4.003	GG104.TM02.020.12.17.L	M2/M3	0.20-0.30	1.70	1.95	0.20	1.55	0.20	12.00	30.00	4.00
4.004	GG104.TM04.035.07.35.L	M4/M5	0.35-0.50	3.50	1.95	0.30	3.20	0.35	7.00	25.00	4.00
4.005	GG104.TM04.035.12.35.L	M4/M5	0.35-0.50	3.50	1.95	0.30	3.20	0.35	12.00	30.00	4.00
4.006	GG104.TM04.035.17.35.L	M4/M5	0.35-0.50	3.50	1.95	0.30	3.20	0.35	17.00	35.00	4.00

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

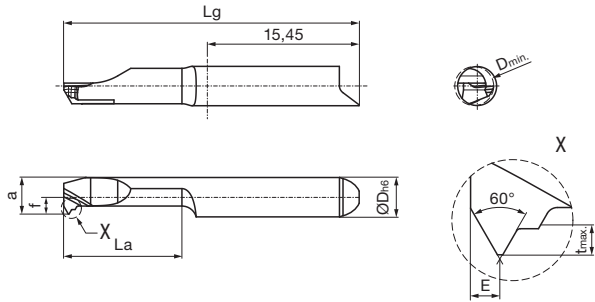


• pitch P = 0.4-0.8

for tool holders type GH104/GB104 see from page 16

**GUHRING** NAVIGATOR

Cutting data page 184



Right hand version shown  
Left hand version mirror image



Article no. **25164** **25166** **25170**

Cutting direction

Code no.	Description	G	P	D min	f	E	a	t max	La	Lg	D h6
			mm	mm	mm	mm	mm	mm	mm	mm	mm
4.001	GG104.VM02.040.04.15.R	M2	0.40	1.50	1.95	0.20	1.35	0.25	4.00	25.00	4.00
4.002	GG104.VM02.040.07.15.R	M2	0.40	1.50	1.95	0.20	1.35	0.25	7.00	25.00	4.00
4.003	GG104.VM02.040.12.15.R	M2	0.40	1.50	1.95	0.20	1.35	0.25	12.00	30.00	4.00
4.004	GG104.VM03.050.04.24.R	M3	0.50	2.40	1.95	0.30	1.95	0.35	4.00	25.00	4.00
4.005	GG104.VM03.050.07.24.R	M3	0.50	2.40	1.95	0.30	1.95	0.35	7.00	25.00	4.00
4.006	GG104.VM03.050.12.24.R	M3	0.50	2.40	1.95	0.30	1.95	0.35	12.00	30.00	4.00
4.007	GG104.VM04.070.07.31.R	M4	0.70	3.10	1.95	0.40	2.80	0.45	7.00	25.00	4.00
4.008	GG104.VM04.070.12.31.R	M4	0.70	3.10	1.95	0.40	2.80	0.45	12.00	30.00	4.00
4.009	GG104.VM04.070.17.31.R	M4	0.70	3.10	1.95	0.40	2.80	0.45	17.00	35.00	4.00
4.010	GG104.VM04.070.22.31.R	M4	0.70	3.10	1.95	0.40	2.80	0.45	22.00	40.00	4.00
4.011	GG104.VM05.080.12.40.R	M5	0.80	4.00	1.70	0.50	3.70	0.50	12.00	30.00	4.00
4.012	GG104.VM05.080.17.40.R	M5	0.80	4.00	1.70	0.50	3.70	0.50	17.00	35.00	4.00
4.013	GG104.VM05.080.22.40.R	M5	0.80	4.00	1.70	0.50	3.70	0.50	22.00	40.00	4.00
4.014	GG104.VM05.080.27.40.R	M5	0.80	4.00	1.70	0.50	3.70	0.50	27.00	45.00	4.00

Article no. **25165** **25167** **25171**

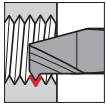
Cutting direction

Code no.	Description	G	P	D min	f	E	a	t max	La	Lg	D h6
			mm	mm	mm	mm	mm	mm	mm	mm	mm
4.001	GG104.VM02.040.04.15.L	M2	0.40	1.50	1.95	0.20	1.35	0.25	4.00	25.00	4.00
4.002	GG104.VM02.040.07.15.L	M2	0.40	1.50	1.95	0.20	1.35	0.25	7.00	25.00	4.00
4.003	GG104.VM02.040.12.15.L	M2	0.40	1.50	1.95	0.20	1.35	0.25	12.00	30.00	4.00
4.004	GG104.VM03.050.04.24.L	M3	0.50	2.40	1.95	0.30	1.95	0.35	4.00	25.00	4.00
4.005	GG104.VM03.050.07.24.L	M3	0.50	2.40	1.95	0.30	1.95	0.35	7.00	25.00	4.00
4.006	GG104.VM03.050.12.24.L	M3	0.50	2.40	1.95	0.30	1.95	0.35	12.00	30.00	4.00
4.007	GG104.VM04.070.07.31.L	M4	0.70	3.10	1.95	0.40	2.80	0.45	7.00	25.00	4.00
4.008	GG104.VM04.070.12.31.L	M4	0.70	3.10	1.95	0.40	2.80	0.45	12.00	30.00	4.00
4.009	GG104.VM04.070.17.31.L	M4	0.70	3.10	1.95	0.40	2.80	0.45	17.00	35.00	4.00
4.010	GG104.VM04.070.22.31.L	M4	0.70	3.10	1.95	0.40	2.80	0.45	22.00	40.00	4.00
4.011	GG104.VM05.080.12.40.L	M5	0.80	4.00	1.70	0.50	3.70	0.50	12.00	30.00	4.00
4.012	GG104.VM05.080.17.40.L	M5	0.80	4.00	1.70	0.50	3.70	0.50	17.00	35.00	4.00
4.013	GG104.VM05.080.22.40.L	M5	0.80	4.00	1.70	0.50	3.70	0.50	22.00	40.00	4.00
4.014	GG104.VM05.080.27.40.L	M5	0.80	4.00	1.70	0.50	3.70	0.50	27.00	45.00	4.00





**Cutting insert for internal threading, part profile - UN-threads**



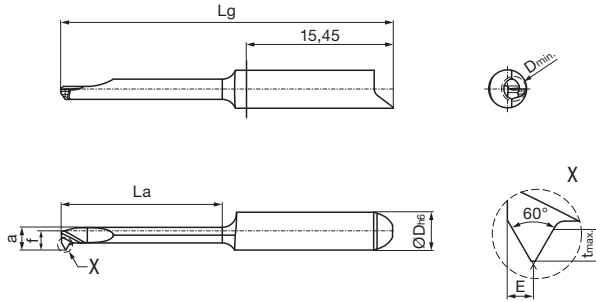
• pitch 32-40 thread/inch

for tool holders type GH104/GB104 see from page 16

**GUHRING NAVIGATOR**

Cutting data page 184

Tool material	Solid carbide		
Type	GG 104	GG 104	GG 104
Surface	<b>S</b>	<b>a</b>	○
	TiN	TiAlN-nanoA	bright



Right hand version shown  
Left hand version mirror image

Article no. **25172**    **25174**    **25178**

Cutting direction

Code no.	Description	P	D min	f	t max	a	E	La	Lg	D h6
		G/inch	mm	mm	mm	mm	mm	mm	mm	mm
4.001	GG104.TU32.040.17.26.R	32-40	2.60	1.95	0.55	2.35	0.45	17.00	35.00	4.00

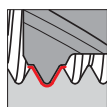
Article no. **25173**    **25175**    **25179**

Cutting direction

Code no.	Description	P	D min	f	t max	a	E	La	Lg	D h6
		G/inch	mm	mm	mm	mm	mm	mm	mm	mm
4.001	GG104.TU32.040.17.26.L	32-40	2.60	1.95	0.55	2.35	0.45	17.00	35.00	4.00



**Cutting insert for internal threading, full profile - Whitworth pipe threads**

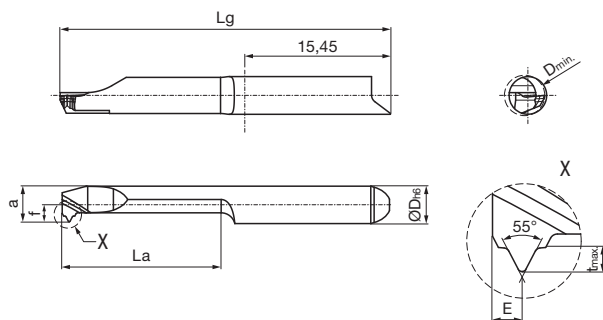


• pitch 24-28 thread/inch

for tool holders type GH104/GB104 see from page 16

**GUHRING NAVIGATOR**

Cutting data page 184



Right hand version shown  
Left hand version mirror image

Tool material	Solid carbide		
Type	GG 104	GG 104	GG 104
Surface	<b>S</b> TiN	<b>a</b> TiAlN-nanoA	○ bright



Article no. **25180**    **25182**    **25186**

Cutting direction **(R)**    **(R)**    **(R)**

Code no.	Description	P	D min	f	t max	a	E	La	Lg	D h6
		G/inch	mm	mm	mm	mm	mm	mm	mm	mm
4.001	GG104.VW28.091.17.43.R	28.00	4.30	1.80	0.65	3.80	0.75	17.00	35.00	4.00
4.002	GG104.VW26.098.17.49.R	26.00	4.90	1.95	0.70	3.95	0.80	17.00	35.00	4.00
4.003	GG104.VW24.106.17.33.R	24.00	3.30	1.95	0.75	3.00	0.80	17.00	35.00	4.00

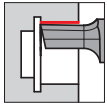
Article no. **25181**    **25183**    **25187**

Cutting direction **(L)**    **(L)**    **(L)**

Code no.	Description	P	D min	f	t max	a	E	La	Lg	D h6
		G/inch	mm	mm	mm	mm	mm	mm	mm	mm
4.001	GG104.VW28.091.17.43.L	28.00	4.30	1.80	0.65	3.80	0.75	17.00	35.00	4.00
4.002	GG104.VW26.098.17.49.L	26.00	4.90	1.95	0.70	3.95	0.80	17.00	35.00	4.00
4.003	GG104.VW24.106.17.33.L	24.00	3.30	1.95	0.75	3.00	0.80	17.00	35.00	4.00



**Cutting insert for internal hexagon**



• SW 1.5-4.0

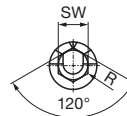
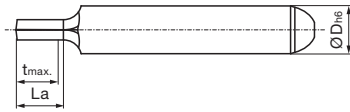
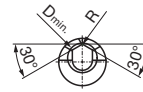
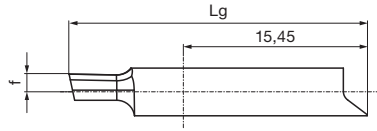
for tool holders type GB104 Art. No. 25006 see page 28

**GUHRING NAVIGATOR**

Cutting data page 184

Tool material	Solid carbide		
Type	GN 104	GN 104	GN 104
Surface	<b>S</b>	<b>a</b>	○
	TiN	TiAlN-nanoA	bright

System 104

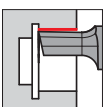


Article no. **25228**    **25229**    **25231**

Code no.	Description	SW	D min	R	f	t max	La	Lg	D h6
			mm	mm	mm	mm	mm	mm	mm
4.001	GN104.SW15.005.04.15.N	1,50-2,00	1.50	0.05	1.50	3.50	4.00	25.00	4.00
4.002	GN104.SW20.005.04.20.N	2,00-2,50	2.00	0.05	1.50	3.50	4.00	25.00	4.00
4.003	GN104.SW25.005.04.25.N	2,50-2,90	2.50	0.05	1.50	3.50	4.00	25.00	4.00
4.004	GN104.SW29.005.05.29.N	2,90-3,50	2.90	0.05	1.50	4.50	5.00	25.00	4.00
4.005	GN104.SW35.005.06.35.N	3,50-4,00	3.50	0.05	1.50	5.50	6.00	25.00	4.00



**Cutting insert for internal square**



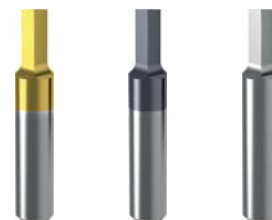
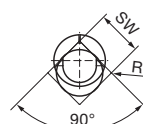
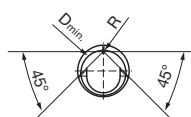
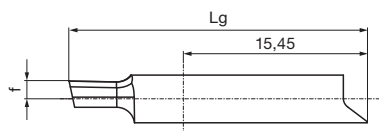
• SW 1.5-4.0

for tool holders type GB104 Art. No. 25006 see page 28

**GUHRING NAVIGATOR**

Cutting data page 184

Tool material	Solid carbide		
Type	GN 104	GN 104	GN 104
Surface	<b>S</b>	<b>a</b>	○
	TiN	TiAlN-nanoA	bright

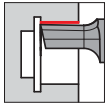


Article no. **25232**    **25233**    **25235**

Code no.	Description	SW	D min	R	f	t max	La	Lg	D h6
			mm	mm	mm	mm	mm	mm	mm
4.001	GN104.4545.005.04.15.N	1,50-2,00	1.50	0.05	1.50	3.50	4.00	25.00	4.00
4.002	GN104.4545.005.04.20.N	2,00-2,50	2.00	0.05	1.50	3.50	4.00	25.00	4.00
4.003	GN104.4545.005.04.25.N	2,50-2,90	2.50	0.05	1.50	3.50	4.00	25.00	4.00
4.004	GN104.4545.005.05.29.N	2,90-3,50	2.90	0.05	1.50	4.50	5.00	25.00	4.00
4.005	GN104.4545.005.06.35.N	3,50-4,00	3.50	0.05	1.50	5.50	6.00	25.00	4.00



**Cutting insert for Torx**



• Torx 8-30

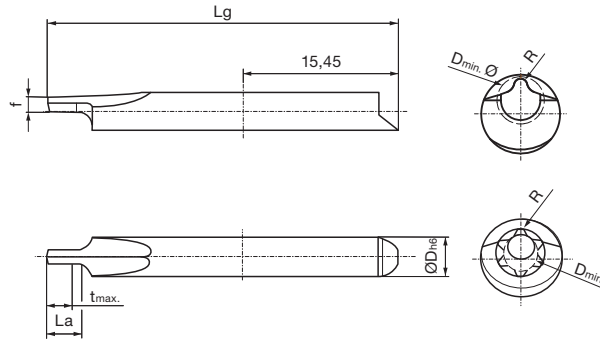
for tool holders type GB104 Art. No. 25006 see page 28

**GUHRING NAVIGATOR**

Cutting data page 184

Tool material	Solid carbide		
Type	GN 104	GN 104	GN 104
Surface	<b>S</b>	<b>a</b>	○
	TiN	TiAlN-nanoA	bright

System 104



Article no. **25236**    **25237**    **25239**

Code no.	Description	Torx	D min	R	f	t max	La	Lg	D h6
			mm	mm	mm	mm	mm	mm	mm
4.001	GN104.TX08.024.03.17.N	T8	1.70	0.24	1.80	2.50	3.00	35.00	4.00
4.002	GN104.TX10.028.03.20.N	T10	2.00	0.28	1.80	2.50	3.00	35.00	4.00
4.003	GN104.TX15.033.04.24.N	T15	2.40	0.33	1.80	3.50	4.00	40.00	4.00
4.004	GN104.TX20.039.04.28.N	T20	2.80	0.39	1.80	3.50	4.00	40.00	4.00
4.005	GN104.TX25.045.05.32.N	T25	3.20	0.45	1.80	4.50	5.00	40.00	4.00
4.006	GN104.TX30.056.05.40.N	T30	4.00	0.56	1.80	4.50	5.00	40.00	4.00

# 106







# SYSTEM 106

## MICRO-PRECISION TOOLS



Round shank holder

from page 62



Square shank holder

from page 69



Modular holder

from page 71

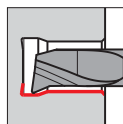


Round shank holder

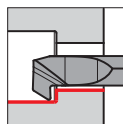
Broaching  
page 74

Tool holder

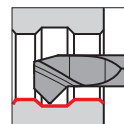
System 106



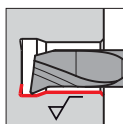
Boring out  
and profiling, type GT  
from page 75



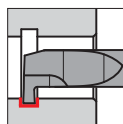
Back boring  
and profiling, type GT  
from page 96



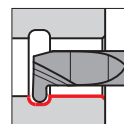
Boring out  
and chamfering, type GT  
from page 98



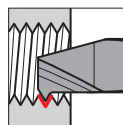
Boring out  
with Wiper, type GJ  
from page 92



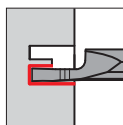
Internal grooving,  
straight slots, type GE  
from page 102



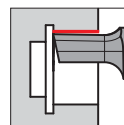
Internal grooving,  
full radius slots, type GE  
from page 106



Internal threading,  
type GG  
from page 114



Axial grooving bores,  
type GA  
from page 110



Broaching,  
type GN  
from page 119

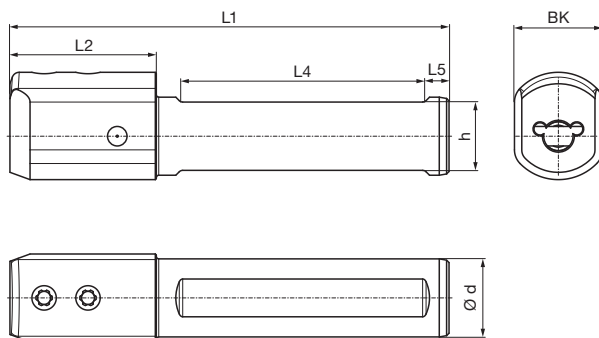
Cutting inserts from hole-Ø 5 mm

**Round shank holder, clamping screw top**

- for inserts type 106
- with internal coolant supply

Type GB 106

System 106



Article no. 25300

Code no.	Description	d	h	L1	L2	L4	L5	BK
		mm	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	12.70	11.00	89.92	26.67	54.86	5.08	13.9
6.016	GB106.0625.354.00.22.N.IK	15.87	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	19.05	17.04	105.41	26.67	69.85	5.08	
6.004	GB106.0020.095.00.22.N.IK	20.00	18.00	95.00	30.00	55.00	5.00	
6.005	GB106.0022.095.00.22.N.IK	22.00	20.00	95.00		55.00	5.00	
6.006	GB106.0025.100.00.22.N.IK	25.00	23.00	100.00		55.00	5.00	
6.018	GB106.1000.415.00.22.N.IK	25.40	23.39	105.41		69.85	5.08	

**Spare parts**

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

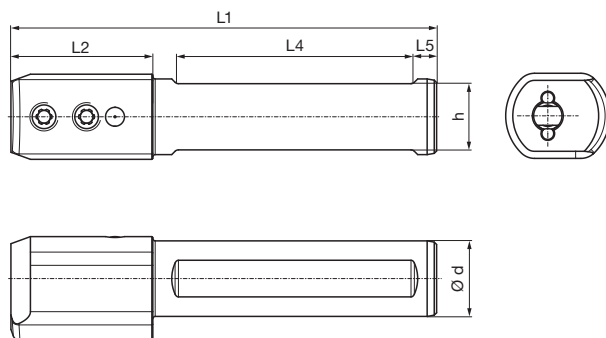
Article no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle



### Round shank holder, clamping screw lateral

- for inserts type 106
- with internal coolant supply

Type GB 106



System 106

Article no. 25301

Code no.	Description	d	h	L1	L2	L4	L5
		mm	mm	mm	mm	mm	mm
6.001	GB106.0010.090.00.22.N.IK.90	10.00	9.00	90.00	30.00	50.00	5.00
6.002	GB106.0012.090.00.22.N.IK.90	12.00	11.00	90.00	30.00	50.00	5.00
6.015	GB106.0500.354.00.22.N.IK.90	12.70	11.00	89.92	26.67	54.86	5.08
6.016	GB106.0625.354.00.22.N.IK.90	15.87	14.00	89.92	26.67	54.86	5.08
6.003	GB106.0016.090.00.22.N.IK.90	16.00	14.00	90.00	30.00	50.00	5.00
6.017	GB106.0750.415.00.22.N.IK.90	19.05	17.04	105.41	26.67	69.85	5.08
6.004	GB106.0020.095.00.22.N.IK.90	20.00	18.00	95.00	30.00	55.00	5.00
6.005	GB106.0022.095.00.22.N.IK.90	22.00	20.00	95.00		55.00	5.00
6.006	GB106.0025.100.00.22.N.IK.90	25.00	23.00	100.00		55.00	5.00
6.018	GB106.1000.415.00.22.N.IK.90	25.40	23.39	105.41		69.85	5.08

### Spare parts

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

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

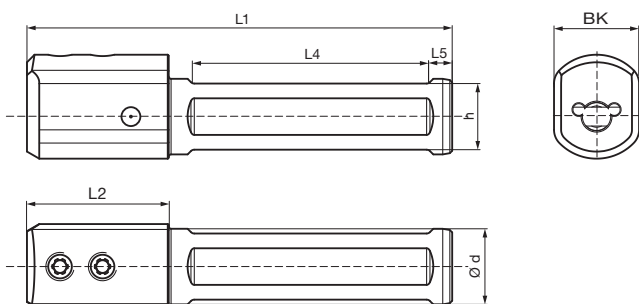


**Round shank holder, clamping screw above, four clamping surfaces**

- for inserts type 106
- with internal coolant supply

Type GB 106

System 106



Article no. 25320

version left and right

Code no.	Description	d	h	L1	L2	L4	L5	BK
		mm	mm	mm	mm	mm	mm	mm
6.010	GB106.0016.090.00.22.N.IK.VSP	16.00	14.00	90.00	30.00	50.00	5.00	18.0
6.020	GB106.0020.095.00.22.N.IK.VSP	20.00	18.00	95.00	30.00	55.00	5.00	
6.030	GB106.0022.095.00.22.N.IK.VSP	22.00	20.00	95.00		55.00	5.00	
6.040	GB106.0025.100.00.22.N.IK.VSP	25.00	23.00	100.00		55.00	5.00	

**Spare parts**

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

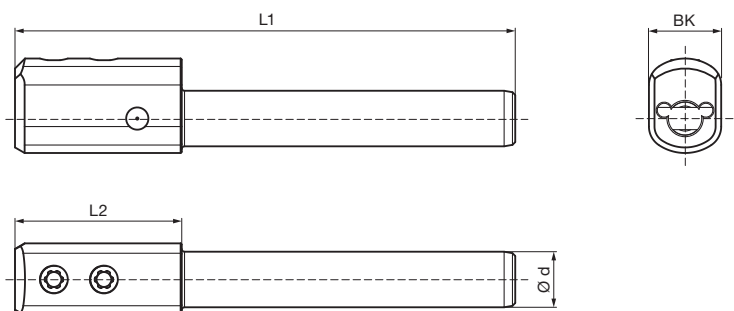
Article no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle



**Round shank holder, clamping screw above, without clamping surfaces**

- for inserts type 106
- with internal coolant supply

Type	GB 106
------	--------



System 106

Article no. **25319**  
version left and right

Code no.	Description	d	L1	L2	BK
		mm	mm	mm	mm
6.010	GB106.0010.090.00.22.N.IK.RND	10.00	90.00	30.00	13.0
6.020	GB106.0012.090.00.22.N.IK.RND	12.00	90.00	30.00	14.0
6.030	GB106.0016.090.00.22.N.IK.RND	16.00	90.00	30.00	18.0

**Spare parts**

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

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

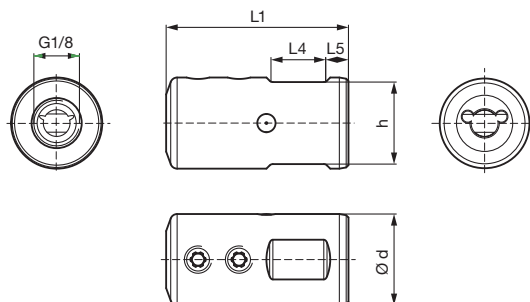


**Round shank holder, clamping screw above, for Citizen machine**

- for inserts type 106
- with internal coolant supply

Type GB 106

System 106



Article no. **25316**

version left and right

Code no.	Description	d	h	L1	L4	L5
		mm	mm	mm	mm	mm
6.110	GB106.0750.040.00.22.N.IK.CIT	19.05	17.05	40.00	12.70	5.08
6.120	GB106.0750.050.00.22.N.IK.CIT	19.05	17.05	50.00	22.86	5.08
6.130	GB106.0750.070.00.22.N.IK.CIT	19.05	17.05	70.00	44.45	5.08
6.140	GB106.0750.100.00.22.N.IK.CIT	19.05	17.05	100.00	73.66	5.08
6.010	GB106.0020.040.00.22.N.IK.CIT	20.00	18.00	40.00	12.00	5.00
6.020	GB106.0020.050.00.22.N.IK.CIT	20.00	18.00	50.00	22.00	5.00
6.150	GB106.1000.060.00.22.N.IK.CIT	25.40	23.40	60.00	31.75	5.08
6.160	GB106.1000.100.00.22.N.IK.CIT	25.40	23.40	100.00	73.66	5.08

**Spare parts**

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

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

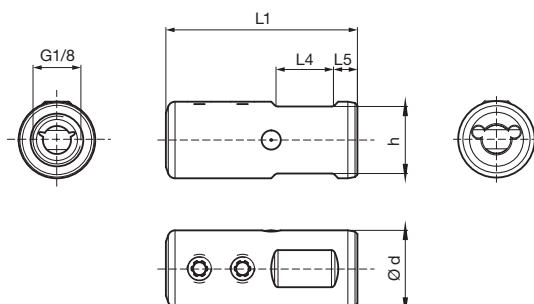




**Round shank holder, clamping screw above, for Star machine**

- for inserts type 106
- with internal coolant supply

Type	GB 106
------	--------



System 106

Article no. **25317**  
version left and right

Code no.	Description	d	h	L1	L4	L5
		mm	mm	mm	mm	mm
6.010	GB106.0016.040.00.22.N.IK.STA	16.00	14.00	40.00	12.00	5.00
6.020	GB106.0016.050.00.22.N.IK.STA	16.00	14.00	50.00	22.00	5.00
6.030	GB106.0016.070.00.22.N.IK.STA	16.00	14.00	70.00	42.00	5.00
6.040	GB106.0022.038.00.22.N.IK.STA	22.00	20.00	38.00	10.00	5.00
6.050	GB106.0022.050.00.22.N.IK.STA	22.00	20.00	50.00	20.00	5.00
6.060	GB106.0022.070.00.22.N.IK.STA	22.00	20.00	70.00	40.00	5.00
6.070	GB106.0022.100.00.22.N.IK.STA	22.00	20.00	100.00	70.00	5.00
6.080	GB106.0022.120.00.22.N.IK.STA	22.00	20.00	120.00	90.00	5.00

**Spare parts**

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

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

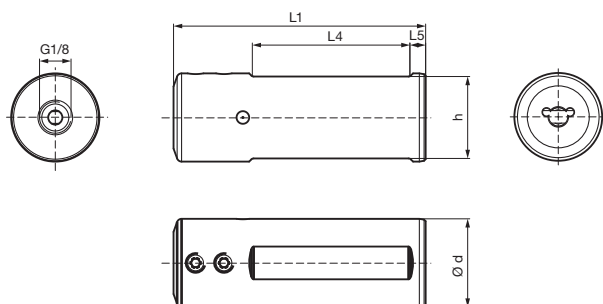


**Round shank holder, clamping screw above, for Tornos machine**

- for inserts type 106
- with internal coolant supply

Type GB 106

System 106



Article no. **25318**

version left and right

Code no.	Description	d	h	L1	L4	L5
		mm	mm	mm	mm	mm
6.010	GB106.0018.310.00.22.N.IK.TOR	18.00	16.00	310.00	280.00	5.00
6.020	GB106.0020.170.00.22.N.IK.TOR	20.00	18.00	170.00	140.00	5.00
6.030	GB106.0020.185.00.22.N.IK.TOR	20.00	18.00	185.00	155.00	5.00
6.040	GB106.0025.100.00.22.N.IK.TOR	25.00	23.00	100.00	70.00	5.00
6.050	GB106.0025.150.00.22.N.IK.TOR	25.00	23.00	150.00	120.00	5.00
6.060	GB106.0028.080.00.22.N.IK.TOR	28.00	26.00	80.00	50.00	5.00

**Spare parts**

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

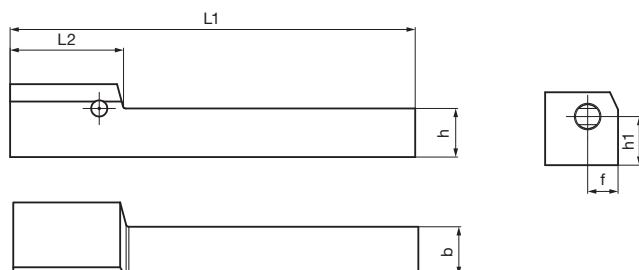
Article no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle



**Square shank holder, straight 0°**

- for inserts type 106
- without internal coolant supply

Type GH 106



Right hand version shown  
Left hand version mirror image

System 106

Article no. **25314**

version right-hand

Code no.	Description	b	h	h1	f	L1	L2
		mm	mm	mm	mm	mm	mm
6.110	GH106.0375.350.00.22.R	9.52	9.52	9.52	7.62	88.90	27.94
6.010	GH106.1010.100.00.22.R	10.00	10.00	10.00	7.50	100.00	28.00
6.020	GH106.1212.100.00.22.R	12.00	12.00	12.00	7.50	100.00	28.00
6.120	GH106.0500.350.00.22.R	12.70	12.70	12.70	7.62	88.90	27.94
6.130	GH106.0625.400.00.22.R	15.87	15.87	15.87	7.62	101.60	27.94
6.030	GH106.1616.120.00.22.R	16.00	16.00	16.00	7.50	120.00	28.00

Article no. **25315**

version left-hand

Code no.	Description	b	h	h1	f	L1	L2
		mm	mm	mm	mm	mm	mm
6.110	GH106.0375.350.00.22.L	9.52	9.52	9.52	7.62	88.90	27.94
6.010	GH106.1010.100.00.22.L	10.00	10.00	10.00	7.50	100.00	28.00
6.020	GH106.1212.100.00.22.L	12.00	12.00	12.00	7.50	100.00	28.00
6.120	GH106.0500.350.00.22.L	12.70	12.70	12.70	7.62	88.90	27.94
6.130	GH106.0625.400.00.22.L	15.87	15.87	15.87	7.62	101.60	27.94
6.030	GH106.1616.120.00.22.L	16.00	16.00	16.00	7.50	120.00	28.00

**Spare parts**

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

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

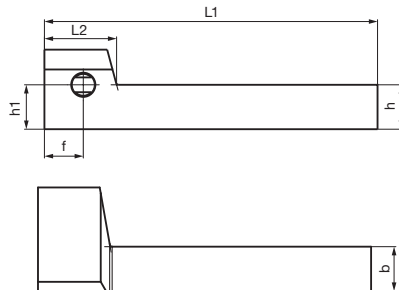


**Square shank holder, 90° offset**

- for inserts type 106
- without internal coolant supply

Type GH 106

System 106



Right hand version shown  
Left hand version mirror image

Article no. **25304**

version right-hand

Code no.	Description	b	h	h1	f	L1	L2
		mm	mm	mm	mm	mm	mm
6.010	GH106.0375.350.90.22.R	9.52	9.52	9.52	22.00	88.90	19.50
6.001	GH106.1010.090.90.22.R	10.00	10.00	10.00	22.00	90.00	19.50
6.002	GH106.1212.090.90.22.R	12.00	12.00	12.00	22.00	90.00	19.50
6.011	GH106.0500.350.90.22.R	12.70	12.70	12.70	22.00	88.90	19.50
6.012	GH106.0625.400.90.22.R	15.87	15.87	15.87	22.00	101.60	19.50
6.003	GH106.1616.120.90.22.R	16.00	16.00	16.00	22.00	120.00	19.50

Article no. **25305**

version left-hand

Code no.	Description	b	h	h1	f	L1	L2
		mm	mm	mm	mm	mm	mm
6.010	GH106.0375.350.90.22.L	9.52	9.52	9.52	22.00	88.90	19.50
6.001	GH106.1010.090.90.22.L	10.00	10.00	10.00	22.00	90.00	19.50
6.002	GH106.1212.090.90.22.L	12.00	12.00	12.00	22.00	90.00	19.50
6.011	GH106.0500.350.90.22.L	12.70	12.70	12.70	22.00	88.90	19.50
6.012	GH106.0625.400.90.22.L	15.87	15.87	15.87	22.00	101.60	19.50
6.003	GH106.1616.120.90.22.L	16.00	16.00	16.00	22.00	120.00	19.50

**Spare parts**

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

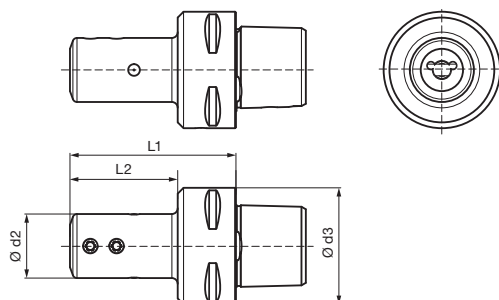
Article no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle



**Polygon shank holder, to ISO 26623, straight 0°**

- for inserts type 106
- with internal coolant supply

Type GH 106



System 106

Article no. **25307**

version left and right

Code no.	Description	d2	d3	L1	L2
		mm		mm	mm
6.001	GH106.PO32.052.00.22.N.IK	22.00	PSC 32	52.00	37.00
6.002	GH106.PO40.057.00.22.N.IK	22.00	PSC 40	57.00	37.00
6.003	GH106.PO50.057.00.22.N.IK	22.00	PSC 50	57.00	37.00
6.004	GH106.PO63.060.00.22.N.IK	22.00	PSC 63	60.00	38.00

**Spare parts**

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

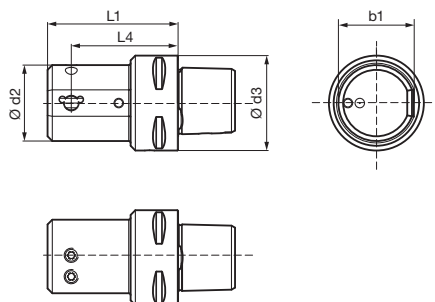
Article no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle



**Polygon shank holder, to ISO 26623, off-set 90°**

- for inserts type 106
- with internal coolant supply

Type GH 106



Right hand version shown  
Left hand version mirror image

Article no. **25308**

version right-hand

Code no.	Description	d2	d3	L1	L4	b1
		mm		mm	mm	mm
6.001	GH106.PO32.045.90.22.R.IK	32.00	PSC 32	55.00	45.00	31.00
6.002	GH106.PO40.045.90.22.R.IK	32.00	PSC 40	55.00	45.00	31.00
6.003	GH106.PO50.050.90.22.R.IK	32.00	PSC 50	60.00	50.00	31.00
6.004	GH106.PO63.050.90.22.R.IK	32.00	PSC 63	60.00	50.00	31.00

Article no. **25309**

version left-hand

Code no.	Description	d2	d3	L1	L4	b1
		mm		mm	mm	mm
6.001	GH106.PO32.045.90.22.L.IK	32.00	PSC 32	55.00	45.00	31.00
6.002	GH106.PO40.045.90.22.L.IK	32.00	PSC 40	55.00	45.00	31.00
6.003	GH106.PO50.050.90.22.L.IK	32.00	PSC 50	60.00	50.00	31.00
6.004	GH106.PO63.050.90.22.L.IK	32.00	PSC 63	60.00	50.00	31.00

**Spare parts**

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

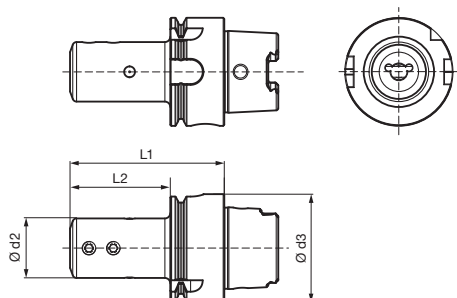
Article no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle




**HSK-T holder, to ISO 12164-3, straight 0°**

- for inserts type 106
- with internal coolant supply

Type	GH 106
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System 106

Article no.	<b>25311</b>
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version	left and right
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Code no.	Description	d2	d3	L1	L2
		mm		mm	mm
6.001	GH106.HS40.057.00.22.N.IK	22.00	HSK-T 40	57.00	37.00
6.002	GH106.HS63.063.00.22.N.IK	22.00	HSK-T 63	63.00	37.00

**Spare parts**

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

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

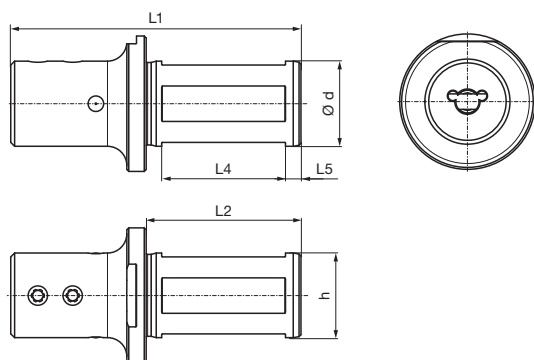


**Round shank holder, 4 clamping surfaces**

- for inserts type 106
- with internal coolant supply

Type GB 106

System 106



Article no. **25302**

Code no.	Description	d	h	L1	L2	L4	L5
		mm	mm	mm	mm	mm	mm
6.010	GB106.0750.300.00.22.S.IK	19.05	17.05	76.20	40.00	32.00	4.00
6.001	GB106.0020.075.00.22.S.IK	20.00	18.00	75.00	40.00	32.00	4.00
6.002	GB106.0022.075.00.22.S.IK	22.00	20.00	75.00	40.00	32.00	4.00
6.003	GB106.0025.075.00.22.S.IK	25.00	23.00	75.00	40.00	32.00	4.00
6.011	GB106.1000.300.00.22.S.IK	25.40	23.40	76.20	40.00	32.00	4.00

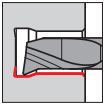
**Spare parts**

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

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



**Cutting insert for boring out and profiling**

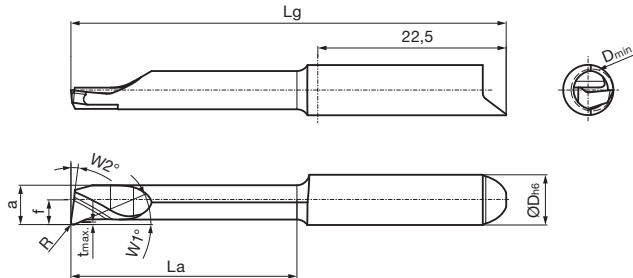


• radial free 23°

for tool holders type GH106/GB106 see from page 62

**GUHRING NAVIGATOR**

Cutting data page 184



Right hand version shown  
Left hand version mirror image

Tool material	Solid carbide		
	GT 106	GT 106	GT 106
Type			
Surface	<b>S</b>	<b>a</b>	○
	TiN	TiAlN-nanoA	bright



System 106

Article no. **25832**    **25834**    **25838**

Cutting direction **(R)**    **(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
6.010	GT106.2347.005.12.50.R	5.00	0.05	23	8	2.95	4.70	0.30	12.00	37.00	6.00
6.020	GT106.2347.005.17.50.R	5.00	0.05	23	8	2.95	4.70	0.30	17.00	42.00	6.00
6.030	GT106.2347.005.22.50.R	5.00	0.05	23	8	2.95	4.70	0.30	22.00	47.00	6.00
6.040	GT106.2347.005.27.50.R	5.00	0.05	23	8	2.95	4.70	0.30	27.00	52.00	6.00
6.050	GT106.2347.005.32.50.R	5.00	0.05	23	8	2.95	4.70	0.30	32.00	57.00	6.00
6.060	GT106.2347.005.37.50.R	5.00	0.05	23	8	2.95	4.70	0.30	37.00	62.00	6.00
6.070	GT106.2347.010.42.50.R	5.00	0.05	23	8	2.95	4.70	0.30	42.00	67.00	6.00
6.110	GT106.2347.010.12.50.R	5.00	0.10	23	8	2.95	4.70	0.30	12.00	37.00	6.00
6.120	GT106.2347.010.17.50.R	5.00	0.10	23	8	2.95	4.70	0.30	17.00	42.00	6.00
6.130	GT106.2347.010.22.50.R	5.00	0.10	23	8	2.95	4.70	0.30	22.00	47.00	6.00
6.140	GT106.2347.010.27.50.R	5.00	0.10	23	8	2.95	4.70	0.30	27.00	52.00	6.00
6.150	GT106.2347.010.32.50.R	5.00	0.10	23	8	2.95	4.70	0.30	32.00	57.00	6.00
6.160	GT106.2347.010.37.50.R	5.00	0.10	23	8	2.95	4.70	0.30	37.00	62.00	6.00
6.170	GT106.2347.010.42.50.R	5.00	0.10	23	8	2.95	4.70	0.30	42.00	67.00	6.00
6.210	GT106.2347.015.12.50.R	5.00	0.15	23	8	2.95	4.70	0.30	12.00	37.00	6.00
6.220	GT106.2347.015.17.50.R	5.00	0.15	23	8	2.95	4.70	0.30	17.00	42.00	6.00
6.230	GT106.2347.015.22.50.R	5.00	0.15	23	8	2.95	4.70	0.30	22.00	47.00	6.00
6.240	GT106.2347.015.27.50.R	5.00	0.15	23	8	2.95	4.70	0.30	27.00	52.00	6.00
6.250	GT106.2347.015.32.50.R	5.00	0.15	23	8	2.95	4.70	0.30	32.00	57.00	6.00
6.260	GT106.2347.015.37.50.R	5.00	0.15	23	8	2.95	4.70	0.30	37.00	62.00	6.00
6.270	GT106.2347.015.42.50.R	5.00	0.15	23	8	2.95	4.70	0.30	42.00	67.00	6.00
6.310	GT106.2347.020.12.50.R	5.00	0.20	23	8	2.95	4.70	0.30	12.00	37.00	6.00
6.320	GT106.2347.020.17.50.R	5.00	0.20	23	8	2.95	4.70	0.30	17.00	42.00	6.00
6.330	GT106.2347.020.22.50.R	5.00	0.20	23	8	2.95	4.70	0.30	22.00	47.00	6.00
6.340	GT106.2347.020.27.50.R	5.00	0.20	23	8	2.95	4.70	0.30	27.00	52.00	6.00
6.350	GT106.2347.020.32.50.R	5.00	0.20	23	8	2.95	4.70	0.30	32.00	57.00	6.00
6.360	GT106.2347.020.37.50.R	5.00	0.20	23	8	2.95	4.70	0.30	37.00	62.00	6.00
6.370	GT106.2347.020.42.50.R	5.00	0.20	23	8	2.95	4.70	0.30	42.00	67.00	6.00
6.410	GT106.2347.030.12.50.R	5.00	0.30	23	8	2.95	4.70	0.30	12.00	37.00	6.00
6.420	GT106.2347.030.17.50.R	5.00	0.30	23	8	2.95	4.70	0.30	17.00	42.00	6.00
6.430	GT106.2347.030.22.50.R	5.00	0.30	23	8	2.95	4.70	0.30	22.00	47.00	6.00
6.440	GT106.2347.030.27.50.R	5.00	0.30	23	8	2.95	4.70	0.30	27.00	52.00	6.00
6.450	GT106.2347.030.32.50.R	5.00	0.30	23	8	2.95	4.70	0.30	32.00	57.00	6.00
6.460	GT106.2347.030.37.50.R	5.00	0.30	23	8	2.95	4.70	0.30	37.00	62.00	6.00
6.470	GT106.2347.030.42.50.R	5.00	0.30	23	8	2.95	4.70	0.30	42.00	67.00	6.00



Article no. **25833** **25835** **25839**

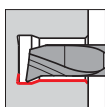
Cutting direction

System 106

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
6.010	GT106.2347.005.12.50.L	5.00	0.05	23	8	2.95	4.70	0.30	12.00	37.00	6.00
6.020	GT106.2347.005.17.50.L	5.00	0.05	23	8	2.95	4.70	0.30	17.00	42.00	6.00
6.030	GT106.2347.005.22.50.L	5.00	0.05	23	8	2.95	4.70	0.30	22.00	47.00	6.00
6.040	GT106.2347.005.27.50.L	5.00	0.05	23	8	2.95	4.70	0.30	27.00	52.00	6.00
6.050	GT106.2347.005.32.50.L	5.00	0.05	23	8	2.95	4.70	0.30	32.00	57.00	6.00
6.060	GT106.2347.005.37.50.L	5.00	0.05	23	8	2.95	4.70	0.30	37.00	62.00	6.00
6.070	GT106.2347.005.42.50.L	5.00	0.05	23	8	2.95	4.70	0.30	42.00	67.00	6.00
6.110	GT106.2347.010.12.50.L	5.00	0.10	23	8	2.95	4.70	0.30	12.00	37.00	6.00
6.120	GT106.2347.010.17.50.L	5.00	0.10	23	8	2.95	4.70	0.30	17.00	42.00	6.00
6.130	GT106.2347.010.22.50.L	5.00	0.10	23	8	2.95	4.70	0.30	22.00	47.00	6.00
6.140	GT106.2347.010.27.50.L	5.00	0.10	23	8	2.95	4.70	0.30	27.00	52.00	6.00
6.150	GT106.2347.010.32.50.L	5.00	0.10	23	8	2.95	4.70	0.30	32.00	57.00	6.00
6.160	GT106.2347.010.37.50.L	5.00	0.10	23	8	2.95	4.70	0.30	37.00	62.00	6.00
6.170	GT106.2347.010.42.50.L	5.00	0.10	23	8	2.95	4.70	0.30	42.00	67.00	6.00
6.210	GT106.2347.015.12.50.L	5.00	0.15	23	8	2.95	4.70	0.30	12.00	37.00	6.00
6.220	GT106.2347.015.17.50.L	5.00	0.15	23	8	2.95	4.70	0.30	17.00	42.00	6.00
6.230	GT106.2347.015.22.50.L	5.00	0.15	23	8	2.95	4.70	0.30	22.00	47.00	6.00
6.240	GT106.2347.015.27.50.L	5.00	0.15	23	8	2.95	4.70	0.30	27.00	52.00	6.00
6.250	GT106.2347.015.32.50.L	5.00	0.15	23	8	2.95	4.70	0.30	32.00	57.00	6.00
6.260	GT106.2347.015.37.50.L	5.00	0.15	23	8	2.95	4.70	0.30	37.00	62.00	6.00
6.270	GT106.2347.015.42.50.L	5.00	0.15	23	8	2.95	4.70	0.30	42.00	67.00	6.00
6.310	GT106.2347.020.12.50.L	5.00	0.20	23	8	2.95	4.70	0.30	12.00	37.00	6.00
6.320	GT106.2347.020.17.50.L	5.00	0.20	23	8	2.95	4.70	0.30	17.00	42.00	6.00
6.330	GT106.2347.020.22.50.L	5.00	0.20	23	8	2.95	4.70	0.30	22.00	47.00	6.00
6.340	GT106.2347.020.27.50.L	5.00	0.20	23	8	2.95	4.70	0.30	27.00	52.00	6.00
6.350	GT106.2347.020.32.50.L	5.00	0.20	23	8	2.95	4.70	0.30	32.00	57.00	6.00
6.360	GT106.2347.020.37.50.L	5.00	0.20	23	8	2.95	4.70	0.30	37.00	62.00	6.00
6.370	GT106.2347.020.42.50.L	5.00	0.20	23	8	2.95	4.70	0.30	42.00	67.00	6.00
6.410	GT106.2347.030.12.50.L	5.00	0.30	23	8	2.95	4.70	0.30	12.00	37.00	6.00
6.420	GT106.2347.030.17.50.L	5.00	0.30	23	8	2.95	4.70	0.30	17.00	42.00	6.00
6.430	GT106.2347.030.22.50.L	5.00	0.30	23	8	2.95	4.70	0.30	22.00	47.00	6.00
6.440	GT106.2347.030.27.50.L	5.00	0.30	23	8	2.95	4.70	0.30	27.00	52.00	6.00
6.450	GT106.2347.030.32.50.L	5.00	0.30	23	8	2.95	4.70	0.30	32.00	57.00	6.00
6.460	GT106.2347.030.37.50.L	5.00	0.30	23	8	2.95	4.70	0.30	37.00	62.00	6.00
6.470	GT106.2347.030.42.50.L	5.00	0.30	23	8	2.95	4.70	0.30	42.00	67.00	6.00



**Cutting insert for boring out and profiling**

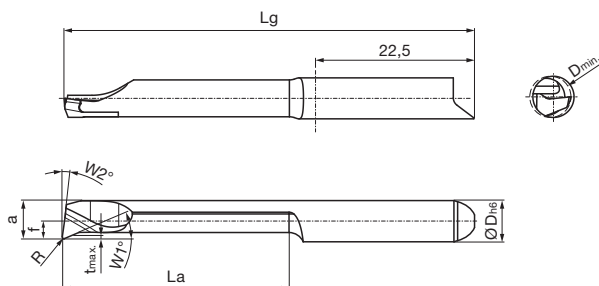


• radial free 23°

for tool holders type GH106/GB106 see from page 62

**GUHRING NAVIGATOR**

Cutting data page 184



Right hand version shown  
Left hand version mirror image

Tool material	Solid carbide		
	GT 106	GT 106	GT 106
Type	GT 106	GT 106	GT 106
Surface	<b>S</b> TiN	<b>a</b> TiAlN-nanoA	○ bright



Article no. **25700** **25702** **25706**

Cutting direction **(R)** **(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
6.019	GT106.2357.005.12.60.R	6.00	0.05	23	8	2.70	5.70	0.30	12.00	37.00	6.00
6.020	GT106.2357.005.17.60.R	6.00	0.05	23	8	2.70	5.70	0.30	17.00	42.00	6.00
6.021	GT106.2357.005.22.60.R	6.00	0.05	23	8	2.70	5.70	0.30	22.00	47.00	6.00
6.022	GT106.2357.005.27.60.R	6.00	0.05	23	8	2.70	5.70	0.30	27.00	52.00	6.00
6.023	GT106.2357.005.32.60.R	6.00	0.05	23	8	2.70	5.70	0.30	32.00	57.00	6.00
6.024	GT106.2357.005.37.60.R	6.00	0.05	23	8	2.70	5.70	0.30	37.00	62.00	6.00
6.025	GT106.2357.005.42.60.R	6.00	0.05	23	8	2.70	5.70	0.30	42.00	67.00	6.00
6.026	GT106.2357.005.47.60.R	6.00	0.05	23	8	2.70	5.70	0.30	47.00	72.00	6.00
6.027	GT106.2357.005.52.60.R	6.00	0.05	23	8	2.70	5.70	0.30	52.00	77.00	6.00
6.028	GT106.2357.010.12.60.R	6.00	0.10	23	8	2.70	5.70	0.30	12.00	37.00	6.00
6.029	GT106.2357.010.17.60.R	6.00	0.10	23	8	2.70	5.70	0.30	17.00	42.00	6.00
6.030	GT106.2357.010.22.60.R	6.00	0.10	23	8	2.70	5.70	0.30	22.00	47.00	6.00
6.031	GT106.2357.010.27.60.R	6.00	0.10	23	8	2.70	5.70	0.30	27.00	52.00	6.00
6.032	GT106.2357.010.32.60.R	6.00	0.10	23	8	2.70	5.70	0.30	32.00	57.00	6.00
6.033	GT106.2357.010.37.60.R	6.00	0.10	23	8	2.70	5.70	0.30	37.00	62.00	6.00
6.034	GT106.2357.010.42.60.R	6.00	0.10	23	8	2.70	5.70	0.30	42.00	67.00	6.00
6.035	GT106.2357.010.47.60.R	6.00	0.10	23	8	2.70	5.70	0.30	47.00	72.00	6.00
6.036	GT106.2357.010.52.60.R	6.00	0.10	23	8	2.70	5.70	0.30	52.00	77.00	6.00
6.013	GT106.2357.015.12.60.R	6.00	0.15	23	8	2.70	5.70	0.30	12.00	37.00	6.00
6.014	GT106.2357.015.17.60.R	6.00	0.15	23	8	2.70	5.70	0.30	17.00	42.00	6.00
6.015	GT106.2357.015.22.60.R	6.00	0.15	23	8	2.70	5.70	0.30	22.00	47.00	6.00
6.001	GT106.2357.015.27.60.R	6.00	0.15	23	8	2.70	5.70	0.30	27.00	52.00	6.00
6.002	GT106.2357.015.32.60.R	6.00	0.15	23	8	2.70	5.70	0.30	32.00	57.00	6.00
6.003	GT106.2357.015.37.60.R	6.00	0.15	23	8	2.70	5.70	0.30	37.00	62.00	6.00
6.004	GT106.2357.015.42.60.R	6.00	0.15	23	8	2.70	5.70	0.30	42.00	67.00	6.00
6.005	GT106.2357.015.47.60.R	6.00	0.15	23	8	2.70	5.70	0.30	47.00	72.00	6.00
6.006	GT106.2357.015.52.60.R	6.00	0.15	23	8	2.70	5.70	0.30	52.00	77.00	6.00
6.037	GT106.2357.020.12.60.R	6.00	0.20	23	8	2.70	5.70	0.30	12.00	37.00	6.00
6.038	GT106.2357.020.17.60.R	6.00	0.20	23	8	2.70	5.70	0.30	17.00	42.00	6.00
6.039	GT106.2357.020.22.60.R	6.00	0.20	23	8	2.70	5.70	0.30	22.00	47.00	6.00
6.040	GT106.2357.020.27.60.R	6.00	0.20	23	8	2.70	5.70	0.30	27.00	52.00	6.00
6.041	GT106.2357.020.32.60.R	6.00	0.20	23	8	2.70	5.70	0.30	32.00	57.00	6.00
6.042	GT106.2357.020.37.60.R	6.00	0.20	23	8	2.70	5.70	0.30	37.00	62.00	6.00
6.043	GT106.2357.020.42.60.R	6.00	0.20	23	8	2.70	5.70	0.30	42.00	67.00	6.00
6.044	GT106.2357.020.47.60.R	6.00	0.20	23	8	2.70	5.70	0.30	47.00	72.00	6.00
6.045	GT106.2357.020.52.60.R	6.00	0.20	23	8	2.70	5.70	0.30	52.00	77.00	6.00
6.046	GT106.2357.025.12.60.R	6.00	0.25	23	8	2.70	5.70	0.30	12.00	37.00	6.00
6.047	GT106.2357.025.17.60.R	6.00	0.25	23	8	2.70	5.70	0.30	17.00	42.00	6.00
6.048	GT106.2357.025.22.60.R	6.00	0.25	23	8	2.70	5.70	0.30	22.00	47.00	6.00
6.049	GT106.2357.025.27.60.R	6.00	0.25	23	8	2.70	5.70	0.30	27.00	52.00	6.00
6.050	GT106.2357.025.32.60.R	6.00	0.25	23	8	2.70	5.70	0.30	32.00	57.00	6.00
6.051	GT106.2357.025.37.60.R	6.00	0.25	23	8	2.70	5.70	0.30	37.00	62.00	6.00

System 106



System 106

Article no. **25700** **25702** **25706**

Cutting direction

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
6.052	GT106.2357.025.42.60.R	6.00	0.25	23	8	2.70	5.70	0.30	42.00	67.00	6.00
6.053	GT106.2357.025.47.60.R	6.00	0.25	23	8	2.70	5.70	0.30	47.00	72.00	6.00
6.054	GT106.2357.025.52.60.R	6.00	0.25	23	8	2.70	5.70	0.30	52.00	77.00	6.00
6.016	GT106.2357.030.12.60.R	6.00	0.30	23	8	2.70	5.70	0.30	12.00	37.00	6.00
6.017	GT106.2357.030.17.60.R	6.00	0.30	23	8	2.70	5.70	0.30	17.00	42.00	6.00
6.018	GT106.2357.030.22.60.R	6.00	0.30	23	8	2.70	5.70	0.30	22.00	47.00	6.00
6.007	GT106.2357.030.27.60.R	6.00	0.30	23	8	2.70	5.70	0.30	27.00	52.00	6.00
6.008	GT106.2357.030.32.60.R	6.00	0.30	23	8	2.70	5.70	0.30	32.00	57.00	6.00
6.009	GT106.2357.030.37.60.R	6.00	0.30	23	8	2.70	5.70	0.30	37.00	62.00	6.00
6.010	GT106.2357.030.42.60.R	6.00	0.30	23	8	2.70	5.70	0.30	42.00	67.00	6.00
6.011	GT106.2357.030.47.60.R	6.00	0.30	23	8	2.70	5.70	0.30	47.00	72.00	6.00
6.012	GT106.2357.030.52.60.R	6.00	0.30	23	8	2.70	5.70	0.30	52.00	77.00	6.00

Article no. **25701** **25703** **25707**

Cutting direction

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
6.019	GT106.2357.005.12.60.L	6.00	0.05	23	8	2.70	5.70	0.30	12.00	37.00	6.00
6.020	GT106.2357.005.17.60.L	6.00	0.05	23	8	2.70	5.70	0.30	17.00	42.00	6.00
6.021	GT106.2357.005.22.60.L	6.00	0.05	23	8	2.70	5.70	0.30	22.00	47.00	6.00
6.022	GT106.2357.005.27.60.L	6.00	0.05	23	8	2.70	5.70	0.30	27.00	52.00	6.00
6.023	GT106.2357.005.32.60.L	6.00	0.05	23	8	2.70	5.70	0.30	32.00	57.00	6.00
6.024	GT106.2357.005.37.60.L	6.00	0.05	23	8	2.70	5.70	0.30	37.00	62.00	6.00
6.025	GT106.2357.005.42.60.L	6.00	0.05	23	8	2.70	5.70	0.30	42.00	67.00	6.00
6.026	GT106.2357.005.47.60.L	6.00	0.05	23	8	2.70	5.70	0.30	47.00	72.00	6.00
6.027	GT106.2357.005.52.60.L	6.00	0.05	23	8	2.70	5.70	0.30	52.00	77.00	6.00
6.028	GT106.2357.010.12.60.L	6.00	0.10	23	8	2.70	5.70	0.30	12.00	37.00	6.00
6.029	GT106.2357.010.17.60.L	6.00	0.10	23	8	2.70	5.70	0.30	17.00	42.00	6.00
6.030	GT106.2357.010.22.60.L	6.00	0.10	23	8	2.70	5.70	0.30	22.00	47.00	6.00
6.031	GT106.2357.010.27.60.L	6.00	0.10	23	8	2.70	5.70	0.30	27.00	52.00	6.00
6.032	GT106.2357.010.32.60.L	6.00	0.10	23	8	2.70	5.70	0.30	32.00	57.00	6.00
6.033	GT106.2357.010.37.60.L	6.00	0.10	23	8	2.70	5.70	0.30	37.00	62.00	6.00
6.034	GT106.2357.010.42.60.L	6.00	0.10	23	8	2.70	5.70	0.30	42.00	67.00	6.00
6.035	GT106.2357.010.47.60.L	6.00	0.10	23	8	2.70	5.70	0.30	47.00	72.00	6.00
6.036	GT106.2357.010.52.60.L	6.00	0.10	23	8	2.70	5.70	0.30	52.00	77.00	6.00
6.013	GT106.2357.015.12.60.L	6.00	0.15	23	8	2.70	5.70	0.30	12.00	37.00	6.00
6.014	GT106.2357.015.17.60.L	6.00	0.15	23	8	2.70	5.70	0.30	17.00	42.00	6.00
6.015	GT106.2357.015.22.60.L	6.00	0.15	23	8	2.70	5.70	0.30	22.00	47.00	6.00
6.001	GT106.2357.015.27.60.L	6.00	0.15	23	8	2.70	5.70	0.30	27.00	52.00	6.00
6.002	GT106.2357.015.32.60.L	6.00	0.15	23	8	2.70	5.70	0.30	32.00	57.00	6.00
6.003	GT106.2357.015.37.60.L	6.00	0.15	23	8	2.70	5.70	0.30	37.00	62.00	6.00
6.004	GT106.2357.015.42.60.L	6.00	0.15	23	8	2.70	5.70	0.30	42.00	67.00	6.00
6.005	GT106.2357.015.47.60.L	6.00	0.15	23	8	2.70	5.70	0.30	47.00	72.00	6.00
6.006	GT106.2357.015.52.60.L	6.00	0.15	23	8	2.70	5.70	0.30	52.00	77.00	6.00
6.037	GT106.2357.020.12.60.L	6.00	0.20	23	8	2.70	5.70	0.30	12.00	37.00	6.00
6.038	GT106.2357.020.17.60.L	6.00	0.20	23	8	2.70	5.70	0.30	17.00	42.00	6.00
6.039	GT106.2357.020.22.60.L	6.00	0.20	23	8	2.70	5.70	0.30	22.00	47.00	6.00
6.040	GT106.2357.020.27.60.L	6.00	0.20	23	8	2.70	5.70	0.30	27.00	52.00	6.00
6.041	GT106.2357.020.32.60.L	6.00	0.20	23	8	2.70	5.70	0.30	32.00	57.00	6.00
6.042	GT106.2357.020.37.60.L	6.00	0.20	23	8	2.70	5.70	0.30	37.00	62.00	6.00
6.043	GT106.2357.020.42.60.L	6.00	0.20	23	8	2.70	5.70	0.30	42.00	67.00	6.00
6.044	GT106.2357.020.47.60.L	6.00	0.20	23	8	2.70	5.70	0.30	47.00	72.00	6.00
6.045	GT106.2357.020.52.60.L	6.00	0.20	23	8	2.70	5.70	0.30	52.00	77.00	6.00
6.046	GT106.2357.025.12.60.L	6.00	0.25	23	8	2.70	5.70	0.30	12.00	37.00	6.00
6.047	GT106.2357.025.17.60.L	6.00	0.25	23	8	2.70	5.70	0.30	17.00	42.00	6.00
6.048	GT106.2357.025.22.60.L	6.00	0.25	23	8	2.70	5.70	0.30	22.00	47.00	6.00
6.049	GT106.2357.025.27.60.L	6.00	0.25	23	8	2.70	5.70	0.30	27.00	52.00	6.00
6.050	GT106.2357.025.32.60.L	6.00	0.25	23	8	2.70	5.70	0.30	32.00	57.00	6.00
6.051	GT106.2357.025.37.60.L	6.00	0.25	23	8	2.70	5.70	0.30	37.00	62.00	6.00
6.052	GT106.2357.025.42.60.L	6.00	0.25	23	8	2.70	5.70	0.30	42.00	67.00	6.00
6.053	GT106.2357.025.47.60.L	6.00	0.25	23	8	2.70	5.70	0.30	47.00	72.00	6.00
6.054	GT106.2357.025.52.60.L	6.00	0.25	23	8	2.70	5.70	0.30	52.00	77.00	6.00
6.016	GT106.2357.030.12.60.L	6.00	0.30	23	8	2.70	5.70	0.30	12.00	37.00	6.00
6.017	GT106.2357.030.17.60.L	6.00	0.30	23	8	2.70	5.70	0.30	17.00	42.00	6.00
6.018	GT106.2357.030.22.60.L	6.00	0.30	23	8	2.70	5.70	0.30	22.00	47.00	6.00

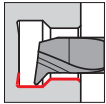


Article no. **25701** **25703** **25707**Cutting direction   

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
6.007	GT106.2357.030.27.60.L	6.00	0.30	23	8	2.70	5.70	0.30	27.00	52.00	6.00
6.008	GT106.2357.030.32.60.L	6.00	0.30	23	8	2.70	5.70	0.30	32.00	57.00	6.00
6.009	GT106.2357.030.37.60.L	6.00	0.30	23	8	2.70	5.70	0.30	37.00	62.00	6.00
6.010	GT106.2357.030.42.60.L	6.00	0.30	23	8	2.70	5.70	0.30	42.00	67.00	6.00
6.011	GT106.2357.030.47.60.L	6.00	0.30	23	8	2.70	5.70	0.30	47.00	72.00	6.00
6.012	GT106.2357.030.52.60.L	6.00	0.30	23	8	2.70	5.70	0.30	52.00	77.00	6.00

System 106

**Cutting insert for boring out and profiling**



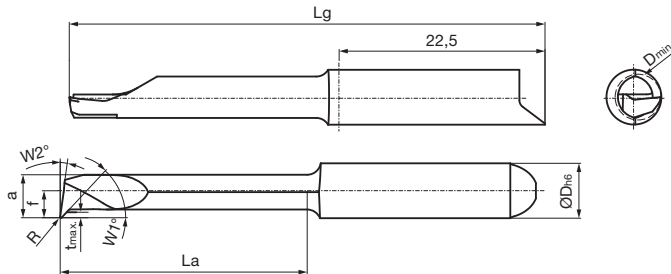
• radial free 47°, tmax 0.6

for tool holders type GH106/GB106 see from page 62

**GUHRING NAVIGATOR**

Cutting data page 184

System 106



Right hand version shown  
Left hand version mirror image

Tool material	Solid carbide		
	GT 106	GT 106	GT 106
Type			
Surface	<b>S</b>	<b>a</b>	○
	TiN	TiAlN-nanoA	bright



Article no. **25840** **25842** **25846**

Cutting direction **(R)** **(R)** **(R)**

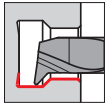
Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
6.010	GT106.4747.005.12.50.R	5.00	0.05	47	8	2.95	4.70	0.60	12.00	37.00	6.00
6.020	GT106.4747.005.17.50.R	5.00	0.05	47	8	2.95	4.70	0.60	17.00	42.00	6.00
6.030	GT106.4747.005.22.50.R	5.00	0.05	47	8	2.95	4.70	0.60	22.00	47.00	6.00
6.040	GT106.4747.005.27.50.R	5.00	0.05	47	8	2.95	4.70	0.60	27.00	52.00	6.00
6.050	GT106.4747.005.32.50.R	5.00	0.05	47	8	2.95	4.70	0.60	32.00	57.00	6.00
6.060	GT106.4747.005.37.50.R	5.00	0.05	47	8	2.95	4.70	0.60	37.00	62.00	6.00
6.070	GT106.4747.010.12.50.R	5.00	0.05	47	8	2.95	4.70	0.60	42.00	67.00	6.00
6.110	GT106.4747.010.12.50.R	5.00	0.10	47	8	2.95	4.70	0.60	12.00	37.00	6.00
6.120	GT106.4747.010.17.50.R	5.00	0.10	47	8	2.95	4.70	0.60	17.00	42.00	6.00
6.130	GT106.4747.010.22.50.R	5.00	0.10	47	8	2.95	4.70	0.60	22.00	47.00	6.00
6.140	GT106.4747.010.27.50.R	5.00	0.10	47	8	2.95	4.70	0.60	27.00	52.00	6.00
6.150	GT106.4747.010.32.50.R	5.00	0.10	47	8	2.95	4.70	0.60	32.00	57.00	6.00
6.160	GT106.4747.010.37.50.R	5.00	0.10	47	8	2.95	4.70	0.60	37.00	62.00	6.00
6.170	GT106.4747.010.42.50.R	5.00	0.10	47	8	2.95	4.70	0.60	42.00	67.00	6.00
6.210	GT106.4747.015.12.50.R	5.00	0.15	47	8	2.95	4.70	0.60	12.00	37.00	6.00
6.220	GT106.4747.015.17.50.R	5.00	0.15	47	8	2.95	4.70	0.60	17.00	42.00	6.00
6.230	GT106.4747.015.22.50.R	5.00	0.15	47	8	2.95	4.70	0.60	22.00	47.00	6.00
6.240	GT106.4747.015.27.50.R	5.00	0.15	47	8	2.95	4.70	0.60	27.00	52.00	6.00
6.250	GT106.4747.015.32.50.R	5.00	0.15	47	8	2.95	4.70	0.60	32.00	57.00	6.00
6.260	GT106.4747.015.37.50.R	5.00	0.15	47	8	2.95	4.70	0.60	37.00	62.00	6.00
6.270	GT106.4747.015.42.50.R	5.00	0.15	47	8	2.95	4.70	0.60	42.00	67.00	6.00
6.310	GT106.4747.020.12.50.R	5.00	0.20	47	8	2.95	4.70	0.60	12.00	37.00	6.00
6.320	GT106.4747.020.17.50.R	5.00	0.20	47	8	2.95	4.70	0.60	17.00	42.00	6.00
6.330	GT106.4747.020.22.50.R	5.00	0.20	47	8	2.95	4.70	0.60	22.00	47.00	6.00
6.340	GT106.4747.020.27.50.R	5.00	0.20	47	8	2.95	4.70	0.60	27.00	52.00	6.00
6.350	GT106.4747.020.32.50.R	5.00	0.20	47	8	2.95	4.70	0.60	32.00	57.00	6.00
6.360	GT106.4747.020.37.50.R	5.00	0.20	47	8	2.95	4.70	0.60	37.00	62.00	6.00
6.370	GT106.4747.020.42.50.R	5.00	0.20	47	8	2.95	4.70	0.60	42.00	67.00	6.00
6.410	GT106.4747.030.12.50.R	5.00	0.30	47	8	2.95	4.70	0.60	12.00	37.00	6.00
6.420	GT106.4747.030.17.50.R	5.00	0.30	47	8	2.95	4.70	0.60	17.00	42.00	6.00
6.430	GT106.4747.030.22.50.R	5.00	0.30	47	8	2.95	4.70	0.60	22.00	47.00	6.00
6.440	GT106.4747.030.27.50.R	5.00	0.30	47	8	2.95	4.70	0.60	27.00	52.00	6.00
6.450	GT106.4747.030.32.50.R	5.00	0.30	47	8	2.95	4.70	0.60	32.00	57.00	6.00
6.460	GT106.4747.030.37.50.R	5.00	0.30	47	8	2.95	4.70	0.60	37.00	62.00	6.00
6.470	GT106.4747.030.42.50.R	5.00	0.30	47	8	2.95	4.70	0.60	42.00	67.00	6.00

Article no. **25841** **25843** **25847**Cutting direction   

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
6.010	GT106.4747.005.12.50.L	5.00	0.05	47	8	2.95	4.70	0.60	12.00	37.00	6.00
6.020	GT106.4747.005.17.50.L	5.00	0.05	47	8	2.95	4.70	0.60	17.00	42.00	6.00
6.030	GT106.4747.005.22.50.L	5.00	0.05	47	8	2.95	4.70	0.60	22.00	47.00	6.00
6.040	GT106.4747.005.27.50.L	5.00	0.05	47	8	2.95	4.70	0.60	27.00	52.00	6.00
6.050	GT106.4747.005.32.50.L	5.00	0.05	47	8	2.95	4.70	0.60	32.00	57.00	6.00
6.060	GT106.4747.005.37.50.L	5.00	0.05	47	8	2.95	4.70	0.60	37.00	62.00	6.00
6.070	GT106.4747.005.42.50.L	5.00	0.05	47	8	2.95	4.70	0.60	42.00	67.00	6.00
6.110	GT106.4747.010.12.50.L	5.00	0.10	47	8	2.95	4.70	0.60	12.00	37.00	6.00
6.120	GT106.4747.010.17.50.L	5.00	0.10	47	8	2.95	4.70	0.60	17.00	42.00	6.00
6.130	GT106.4747.010.22.50.L	5.00	0.10	47	8	2.95	4.70	0.60	22.00	47.00	6.00
6.140	GT106.4747.010.27.50.L	5.00	0.10	47	8	2.95	4.70	0.60	27.00	52.00	6.00
6.150	GT106.4747.010.32.50.L	5.00	0.10	47	8	2.95	4.70	0.60	32.00	57.00	6.00
6.160	GT106.4747.010.37.50.L	5.00	0.10	47	8	2.95	4.70	0.60	37.00	62.00	6.00
6.170	GT106.4747.010.42.50.L	5.00	0.10	47	8	2.95	4.70	0.60	42.00	67.00	6.00
6.210	GT106.4747.015.12.50.L	5.00	0.15	47	8	2.95	4.70	0.60	12.00	37.00	6.00
6.220	GT106.4747.015.17.50.L	5.00	0.15	47	8	2.95	4.70	0.60	17.00	42.00	6.00
6.230	GT106.4747.015.22.50.L	5.00	0.15	47	8	2.95	4.70	0.60	22.00	47.00	6.00
6.240	GT106.4747.015.27.50.L	5.00	0.15	47	8	2.95	4.70	0.60	27.00	52.00	6.00
6.250	GT106.4747.015.32.50.L	5.00	0.15	47	8	2.95	4.70	0.60	32.00	57.00	6.00
6.260	GT106.4747.015.37.50.L	5.00	0.15	47	8	2.95	4.70	0.60	37.00	62.00	6.00
6.270	GT106.4747.015.42.50.L	5.00	0.15	47	8	2.95	4.70	0.60	42.00	67.00	6.00
6.310	GT106.4747.020.12.50.L	5.00	0.20	47	8	2.95	4.70	0.60	12.00	37.00	6.00
6.320	GT106.4747.020.17.50.L	5.00	0.20	47	8	2.95	4.70	0.60	17.00	42.00	6.00
6.330	GT106.4747.020.22.50.L	5.00	0.20	47	8	2.95	4.70	0.60	22.00	47.00	6.00
6.340	GT106.4747.020.27.50.L	5.00	0.20	47	8	2.95	4.70	0.60	27.00	52.00	6.00
6.350	GT106.4747.020.32.50.L	5.00	0.20	47	8	2.95	4.70	0.60	32.00	57.00	6.00
6.360	GT106.4747.020.37.50.L	5.00	0.20	47	8	2.95	4.70	0.60	37.00	62.00	6.00
6.370	GT106.4747.020.42.50.L	5.00	0.20	47	8	2.95	4.70	0.60	42.00	67.00	6.00
6.410	GT106.4747.030.12.50.L	5.00	0.30	47	8	2.95	4.70	0.60	12.00	37.00	6.00
6.420	GT106.4747.030.17.50.L	5.00	0.30	47	8	2.95	4.70	0.60	17.00	42.00	6.00
6.430	GT106.4747.030.22.50.L	5.00	0.30	47	8	2.95	4.70	0.60	22.00	47.00	6.00
6.440	GT106.4747.030.27.50.L	5.00	0.30	47	8	2.95	4.70	0.60	27.00	52.00	6.00
6.450	GT106.4747.030.32.50.L	5.00	0.30	47	8	2.95	4.70	0.60	32.00	57.00	6.00
6.460	GT106.4747.030.37.50.L	5.00	0.30	47	8	2.95	4.70	0.60	37.00	62.00	6.00
6.470	GT106.4747.030.42.50.L	5.00	0.30	47	8	2.95	4.70	0.60	42.00	67.00	6.00

System 106

Cutting insert for boring out and profiling



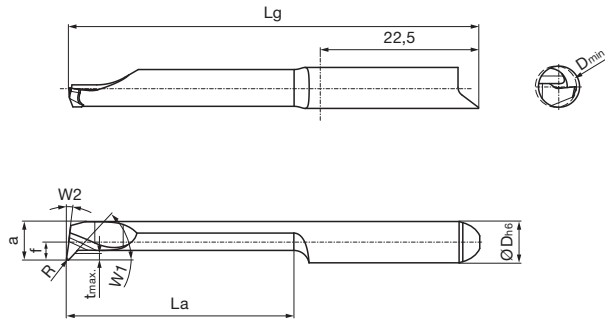
• radial free 47°, tmax 0.8

for tool holders type GH106/GB106 see from page 62

**GUHRING NAVIGATOR**

Cutting data page 184

System 106



Right hand version shown  
Left hand version mirror image

Tool material	Solid carbide			
	Type	GT 106	GT 106	GT 106
Surface	<b>S</b>	<b>a</b>	○	
	TiN	TiAlN-nanoA	bright	



Article no.	25708	25710	25714
Cutting direction	<b>(R)</b>	<b>(R)</b>	<b>(R)</b>

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
6.019	GT106.4757.005.12.60.R	6.00	0.05	47	8	2.70	5.70	0.60	12.00	37.00	6.00
6.020	GT106.4757.005.17.60.R	6.00	0.05	47	8	2.70	5.70	0.60	17.00	42.00	6.00
6.021	GT106.4757.005.22.60.R	6.00	0.05	47	8	2.70	5.70	0.60	22.00	47.00	6.00
6.022	GT106.4757.005.27.60.R	6.00	0.05	47	8	2.70	5.70	0.60	27.00	52.00	6.00
6.023	GT106.4757.005.32.60.R	6.00	0.05	47	8	2.70	5.70	0.60	32.00	57.00	6.00
6.024	GT106.4757.005.37.60.R	6.00	0.05	47	8	2.70	5.70	0.60	37.00	62.00	6.00
6.025	GT106.4757.005.42.60.R	6.00	0.05	47	8	2.70	5.70	0.60	42.00	67.00	6.00
6.026	GT106.4757.005.47.60.R	6.00	0.05	47	8	2.70	5.70	0.60	47.00	72.00	6.00
6.027	GT106.4757.005.52.60.R	6.00	0.05	47	8	2.70	5.70	0.60	52.00	77.00	6.00
6.028	GT106.4757.010.12.60.R	6.00	0.10	47	8	2.70	5.70	0.60	12.00	37.00	6.00
6.029	GT106.4757.010.17.60.R	6.00	0.10	47	8	2.70	5.70	0.60	17.00	42.00	6.00
6.030	GT106.4757.010.22.60.R	6.00	0.10	47	8	2.70	5.70	0.60	22.00	47.00	6.00
6.031	GT106.4757.010.27.60.R	6.00	0.10	47	8	2.70	5.70	0.60	27.00	52.00	6.00
6.032	GT106.4757.010.32.60.R	6.00	0.10	47	8	2.70	5.70	0.60	32.00	57.00	6.00
6.033	GT106.4757.010.37.60.R	6.00	0.10	47	8	2.70	5.70	0.60	37.00	62.00	6.00
6.034	GT106.4757.010.42.60.R	6.00	0.10	47	8	2.70	5.70	0.60	42.00	67.00	6.00
6.035	GT106.4757.010.47.60.R	6.00	0.10	47	8	2.70	5.70	0.60	47.00	72.00	6.00
6.036	GT106.4757.010.52.60.R	6.00	0.10	47	8	2.70	5.70	0.60	52.00	77.00	6.00
6.013	GT106.4757.015.12.60.R	6.00	0.15	47	8	2.70	5.70	0.60	12.00	37.00	6.00
6.014	GT106.4757.015.17.60.R	6.00	0.15	47	8	2.70	5.70	0.60	17.00	42.00	6.00
6.015	GT106.4757.015.22.60.R	6.00	0.15	47	8	2.70	5.70	0.60	22.00	47.00	6.00
6.001	GT106.4757.015.27.60.R	6.00	0.15	47	8	2.70	5.70	0.60	27.00	52.00	6.00
6.002	GT106.4757.015.32.60.R	6.00	0.15	47	8	2.70	5.70	0.60	32.00	57.00	6.00
6.003	GT106.4757.015.37.60.R	6.00	0.15	47	8	2.70	5.70	0.60	37.00	62.00	6.00
6.004	GT106.4757.015.42.60.R	6.00	0.15	47	8	2.70	5.70	0.60	42.00	67.00	6.00
6.005	GT106.4757.015.47.60.R	6.00	0.15	47	8	2.70	5.70	0.60	47.00	72.00	6.00
6.006	GT106.4757.015.52.60.R	6.00	0.15	47	8	2.70	5.70	0.60	52.00	77.00	6.00
6.037	GT106.4757.020.12.60.R	6.00	0.20	47	8	2.70	5.70	0.60	12.00	37.00	6.00
6.038	GT106.4757.020.17.60.R	6.00	0.20	47	8	2.70	5.70	0.60	17.00	42.00	6.00
6.039	GT106.4757.020.22.60.R	6.00	0.20	47	8	2.70	5.70	0.60	22.00	47.00	6.00
6.040	GT106.4757.020.27.60.R	6.00	0.20	47	8	2.70	5.70	0.60	27.00	52.00	6.00
6.041	GT106.4757.020.32.60.R	6.00	0.20	47	8	2.70	5.70	0.60	32.00	57.00	6.00
6.042	GT106.4757.020.37.60.R	6.00	0.20	47	8	2.70	5.70	0.60	37.00	62.00	6.00
6.043	GT106.4757.020.42.60.R	6.00	0.20	47	8	2.70	5.70	0.60	42.00	67.00	6.00
6.044	GT106.4757.020.47.60.R	6.00	0.20	47	8	2.70	5.70	0.60	47.00	72.00	6.00
6.045	GT106.4757.020.52.60.R	6.00	0.20	47	8	2.70	5.70	0.60	52.00	77.00	6.00
6.016	GT106.4757.030.12.60.R	6.00	0.30	47	8	2.70	5.70	0.60	12.00	37.00	6.00
6.017	GT106.4757.030.17.60.R	6.00	0.30	47	8	2.70	5.70	0.60	17.00	42.00	6.00
6.018	GT106.4757.030.22.60.R	6.00	0.30	47	8	2.70	5.70	0.60	22.00	47.00	6.00
6.007	GT106.4757.030.27.60.R	6.00	0.30	47	8	2.70	5.70	0.60	27.00	52.00	6.00
6.008	GT106.4757.030.32.60.R	6.00	0.30	47	8	2.70	5.70	0.60	32.00	57.00	6.00
6.009	GT106.4757.030.37.60.R	6.00	0.30	47	8	2.70	5.70	0.60	37.00	62.00	6.00

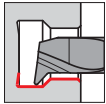
Article no. **25708** **25710** **25714**Cutting direction   

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
6.010	GT106.4757.030.42.60.R	6.00	0.30	47	8	2.70	5.70	0.60	42.00	67.00	6.00
6.011	GT106.4757.030.47.60.R	6.00	0.30	47	8	2.70	5.70	0.60	47.00	72.00	6.00
6.012	GT106.4757.030.52.60.R	6.00	0.30	47	8	2.70	5.70	0.60	52.00	77.00	6.00

Article no. **25709** **25711** **25715**Cutting direction   

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
6.019	GT106.4757.005.12.60.L	6.00	0.05	47	8	2.70	5.70	0.60	12.00	37.00	6.00
6.020	GT106.4757.005.17.60.L	6.00	0.05	47	8	2.70	5.70	0.60	17.00	42.00	6.00
6.021	GT106.4757.005.22.60.L	6.00	0.05	47	8	2.70	5.70	0.60	22.00	47.00	6.00
6.022	GT106.4757.005.27.60.L	6.00	0.05	47	8	2.70	5.70	0.60	27.00	52.00	6.00
6.023	GT106.4757.005.32.60.L	6.00	0.05	47	8	2.70	5.70	0.60	32.00	57.00	6.00
6.024	GT106.4757.005.37.60.L	6.00	0.05	47	8	2.70	5.70	0.60	37.00	62.00	6.00
6.025	GT106.4757.005.42.60.L	6.00	0.05	47	8	2.70	5.70	0.60	42.00	67.00	6.00
6.026	GT106.4757.005.47.60.L	6.00	0.05	47	8	2.70	5.70	0.60	47.00	72.00	6.00
6.027	GT106.4757.005.52.60.L	6.00	0.05	47	8	2.70	5.70	0.60	52.00	77.00	6.00
6.028	GT106.4757.010.12.60.L	6.00	0.10	47	8	2.70	5.70	0.60	12.00	37.00	6.00
6.029	GT106.4757.010.17.60.L	6.00	0.10	47	8	2.70	5.70	0.60	17.00	42.00	6.00
6.030	GT106.4757.010.22.60.L	6.00	0.10	47	8	2.70	5.70	0.60	22.00	47.00	6.00
6.031	GT106.4757.010.27.60.L	6.00	0.10	47	8	2.70	5.70	0.60	27.00	52.00	6.00
6.032	GT106.4757.010.32.60.L	6.00	0.10	47	8	2.70	5.70	0.60	32.00	57.00	6.00
6.033	GT106.4757.010.37.60.L	6.00	0.10	47	8	2.70	5.70	0.60	37.00	62.00	6.00
6.034	GT106.4757.010.42.60.L	6.00	0.10	47	8	2.70	5.70	0.60	42.00	67.00	6.00
6.035	GT106.4757.010.47.60.L	6.00	0.10	47	8	2.70	5.70	0.60	47.00	72.00	6.00
6.036	GT106.4757.010.52.60.L	6.00	0.10	47	8	2.70	5.70	0.60	52.00	77.00	6.00
6.013	GT106.4757.015.12.60.L	6.00	0.15	47	8	2.70	5.70	0.60	12.00	37.00	6.00
6.014	GT106.4757.015.17.60.L	6.00	0.15	47	8	2.70	5.70	0.60	17.00	42.00	6.00
6.015	GT106.4757.015.22.60.L	6.00	0.15	47	8	2.70	5.70	0.60	22.00	47.00	6.00
6.001	GT106.4757.015.27.60.L	6.00	0.15	47	8	2.70	5.70	0.60	27.00	52.00	6.00
6.002	GT106.4757.015.32.60.L	6.00	0.15	47	8	2.70	5.70	0.60	32.00	57.00	6.00
6.003	GT106.4757.015.37.60.L	6.00	0.15	47	8	2.70	5.70	0.60	37.00	62.00	6.00
6.004	GT106.4757.015.42.60.L	6.00	0.15	47	8	2.70	5.70	0.60	42.00	67.00	6.00
6.005	GT106.4757.015.47.60.L	6.00	0.15	47	8	2.70	5.70	0.60	47.00	72.00	6.00
6.006	GT106.4757.015.52.60.L	6.00	0.15	47	8	2.70	5.70	0.60	52.00	77.00	6.00
6.037	GT106.4757.020.12.60.L	6.00	0.20	47	8	2.70	5.70	0.60	12.00	37.00	6.00
6.038	GT106.4757.020.17.60.L	6.00	0.20	47	8	2.70	5.70	0.60	17.00	42.00	6.00
6.039	GT106.4757.020.22.60.L	6.00	0.20	47	8	2.70	5.70	0.60	22.00	47.00	6.00
6.040	GT106.4757.020.27.60.L	6.00	0.20	47	8	2.70	5.70	0.60	27.00	52.00	6.00
6.041	GT106.4757.020.32.60.L	6.00	0.20	47	8	2.70	5.70	0.60	32.00	57.00	6.00
6.042	GT106.4757.020.37.60.L	6.00	0.20	47	8	2.70	5.70	0.60	37.00	62.00	6.00
6.043	GT106.4757.020.42.60.L	6.00	0.20	47	8	2.70	5.70	0.60	42.00	67.00	6.00
6.044	GT106.4757.020.47.60.L	6.00	0.20	47	8	2.70	5.70	0.60	47.00	72.00	6.00
6.045	GT106.4757.020.52.60.L	6.00	0.20	47	8	2.70	5.70	0.60	52.00	77.00	6.00
6.016	GT106.4757.030.12.60.L	6.00	0.30	47	8	2.70	5.70	0.60	12.00	37.00	6.00
6.017	GT106.4757.030.17.60.L	6.00	0.30	47	8	2.70	5.70	0.60	17.00	42.00	6.00
6.018	GT106.4757.030.22.60.L	6.00	0.30	47	8	2.70	5.70	0.60	22.00	47.00	6.00
6.007	GT106.4757.030.27.60.L	6.00	0.30	47	8	2.70	5.70	0.60	27.00	52.00	6.00
6.008	GT106.4757.030.32.60.L	6.00	0.30	47	8	2.70	5.70	0.60	32.00	57.00	6.00
6.009	GT106.4757.030.37.60.L	6.00	0.30	47	8	2.70	5.70	0.60	37.00	62.00	6.00
6.010	GT106.4757.030.42.60.L	6.00	0.30	47	8	2.70	5.70	0.60	42.00	67.00	6.00
6.011	GT106.4757.030.47.60.L	6.00	0.30	47	8	2.70	5.70	0.60	47.00	72.00	6.00
6.012	GT106.4757.030.52.60.L	6.00	0.30	47	8	2.70	5.70	0.60	52.00	77.00	6.00

**Cutting insert for boring out and profiling**



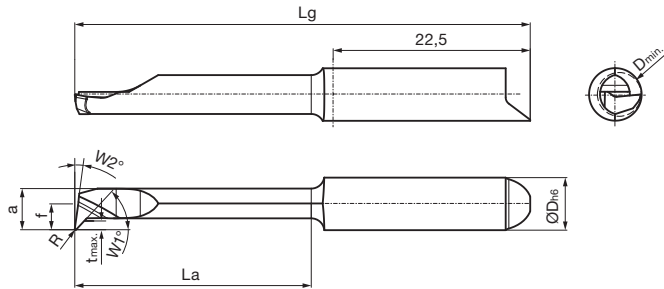
- radial free 47°, tmax 1

for tool holders type GH106/GB106 see from page 62

**GUHRING NAVIGATOR**

Cutting data page 184

System 106



Right hand version shown  
Left hand version mirror image

Article no. **25888**    **25890**    **25894**

Cutting direction

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
6.010	GT106.4747.005.12.50.R.T1	5.00	0.05	47	8	2.95	4.70	1.00	12.00	37.00	6.00
6.020	GT106.4747.005.17.50.R.T1	5.00	0.05	47	8	2.95	4.70	1.00	17.00	42.00	6.00
6.030	GT106.4747.005.22.50.R.T1	5.00	0.05	47	8	2.95	4.70	1.00	22.00	47.00	6.00
6.040	GT106.4747.005.27.50.R.T1	5.00	0.05	47	8	2.95	4.70	1.00	27.00	52.00	6.00
6.050	GT106.4747.005.32.50.R.T1	5.00	0.05	47	8	2.95	4.70	1.00	32.00	57.00	6.00
6.060	GT106.4747.005.37.50.R.T1	5.00	0.05	47	8	2.95	4.70	1.00	37.00	62.00	6.00
6.070	GT106.4747.010.12.50.R.T1	5.00	0.05	47	8	2.95	4.70	1.00	42.00	67.00	6.00
6.110	GT106.4747.010.12.50.R.T1	5.00	0.10	47	8	2.95	4.70	1.00	12.00	37.00	6.00
6.120	GT106.4747.010.17.50.R.T1	5.00	0.10	47	8	2.95	4.70	1.00	17.00	42.00	6.00
6.130	GT106.4747.010.22.50.R.T1	5.00	0.10	47	8	2.95	4.70	1.00	22.00	47.00	6.00
6.140	GT106.4747.010.27.50.R.T1	5.00	0.10	47	8	2.95	4.70	1.00	27.00	52.00	6.00
6.150	GT106.4747.010.32.50.R.T1	5.00	0.10	47	8	2.95	4.70	1.00	32.00	57.00	6.00
6.160	GT106.4747.010.37.50.R.T1	5.00	0.10	47	8	2.95	4.70	1.00	37.00	62.00	6.00
6.170	GT106.4747.010.42.50.R.T1	5.00	0.10	47	8	2.95	4.70	1.00	42.00	67.00	6.00
6.210	GT106.4747.015.12.50.R.T1	5.00	0.15	47	8	2.95	4.70	1.00	12.00	37.00	6.00
6.220	GT106.4747.015.17.50.R.T1	5.00	0.15	47	8	2.95	4.70	1.00	17.00	42.00	6.00
6.230	GT106.4747.015.22.50.R.T1	5.00	0.15	47	8	2.95	4.70	1.00	22.00	47.00	6.00
6.240	GT106.4747.015.27.50.R.T1	5.00	0.15	47	8	2.95	4.70	1.00	27.00	52.00	6.00
6.250	GT106.4747.015.32.50.R.T1	5.00	0.15	47	8	2.95	4.70	1.00	32.00	57.00	6.00
6.260	GT106.4747.015.37.50.R.T1	5.00	0.15	47	8	2.95	4.70	1.00	37.00	62.00	6.00
6.270	GT106.4747.015.42.50.R.T1	5.00	0.15	47	8	2.95	4.70	1.00	42.00	67.00	6.00
6.310	GT106.4747.020.12.50.R.T1	5.00	0.20	47	8	2.95	4.70	1.00	12.00	37.00	6.00
6.320	GT106.4747.020.17.50.R.T1	5.00	0.20	47	8	2.95	4.70	1.00	17.00	42.00	6.00
6.330	GT106.4747.020.22.50.R.T1	5.00	0.20	47	8	2.95	4.70	1.00	22.00	47.00	6.00
6.340	GT106.4747.020.27.50.R.T1	5.00	0.20	47	8	2.95	4.70	1.00	27.00	52.00	6.00
6.350	GT106.4747.020.32.50.R.T1	5.00	0.20	47	8	2.95	4.70	1.00	32.00	57.00	6.00
6.360	GT106.4747.020.37.50.R.T1	5.00	0.20	47	8	2.95	4.70	1.00	37.00	62.00	6.00
6.370	GT106.4747.020.42.50.R.T1	5.00	0.20	47	8	2.95	4.70	1.00	42.00	67.00	6.00
6.410	GT106.4747.030.12.50.R.T1	5.00	0.30	47	8	2.95	4.70	1.00	12.00	37.00	6.00
6.420	GT106.4747.030.17.50.R.T1	5.00	0.30	47	8	2.95	4.70	1.00	17.00	42.00	6.00
6.430	GT106.4747.030.22.50.R.T1	5.00	0.30	47	8	2.95	4.70	1.00	22.00	47.00	6.00
6.440	GT106.4747.030.27.50.R.T1	5.00	0.30	47	8	2.95	4.70	1.00	27.00	52.00	6.00
6.450	GT106.4747.030.32.50.R.T1	5.00	0.30	47	8	2.95	4.70	1.00	32.00	57.00	6.00
6.460	GT106.4747.030.37.50.R.T1	5.00	0.30	47	8	2.95	4.70	1.00	37.00	62.00	6.00
6.470	GT106.4747.030.42.50.R.T1	5.00	0.30	47	8	2.95	4.70	1.00	42.00	67.00	6.00

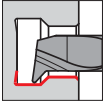
Article no. **25889** **25891** **25895**Cutting direction   

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
6.010	GT106.4747.005.12.50.L.T1	5.00	0.05	47	8	2.95	4.70	1.00	12.00	37.00	6.00
6.020	GT106.4747.005.17.50.L.T1	5.00	0.05	47	8	2.95	4.70	1.00	17.00	42.00	6.00
6.030	GT106.4747.005.22.50.L.T1	5.00	0.05	47	8	2.95	4.70	1.00	22.00	47.00	6.00
6.040	GT106.4747.005.27.50.L.T1	5.00	0.05	47	8	2.95	4.70	1.00	27.00	52.00	6.00
6.050	GT106.4747.005.32.50.L.T1	5.00	0.05	47	8	2.95	4.70	1.00	32.00	57.00	6.00
6.060	GT106.4747.005.37.50.L.T1	5.00	0.05	47	8	2.95	4.70	1.00	37.00	62.00	6.00
6.070	GT106.4747.005.42.50.L.T1	5.00	0.05	47	8	2.95	4.70	1.00	42.00	67.00	6.00
6.110	GT106.4747.010.12.50.L.T1	5.00	0.10	47	8	2.95	4.70	1.00	12.00	37.00	6.00
6.120	GT106.4747.010.17.50.L.T1	5.00	0.10	47	8	2.95	4.70	1.00	17.00	42.00	6.00
6.130	GT106.4747.010.22.50.L.T1	5.00	0.10	47	8	2.95	4.70	1.00	22.00	47.00	6.00
6.140	GT106.4747.010.27.50.L.T1	5.00	0.10	47	8	2.95	4.70	1.00	27.00	52.00	6.00
6.150	GT106.4747.010.32.50.L.T1	5.00	0.10	47	8	2.95	4.70	1.00	32.00	57.00	6.00
6.160	GT106.4747.010.37.50.L.T1	5.00	0.10	47	8	2.95	4.70	1.00	37.00	62.00	6.00
6.170	GT106.4747.010.42.50.L.T1	5.00	0.10	47	8	2.95	4.70	1.00	42.00	67.00	6.00
6.210	GT106.4747.015.12.50.L.T1	5.00	0.15	47	8	2.95	4.70	1.00	12.00	37.00	6.00
6.220	GT106.4747.015.17.50.L.T1	5.00	0.15	47	8	2.95	4.70	1.00	17.00	42.00	6.00
6.230	GT106.4747.015.22.50.L.T1	5.00	0.15	47	8	2.95	4.70	1.00	22.00	47.00	6.00
6.240	GT106.4747.015.27.50.L.T1	5.00	0.15	47	8	2.95	4.70	1.00	27.00	52.00	6.00
6.250	GT106.4747.015.32.50.L.T1	5.00	0.15	47	8	2.95	4.70	1.00	32.00	57.00	6.00
6.260	GT106.4747.015.37.50.L.T1	5.00	0.15	47	8	2.95	4.70	1.00	37.00	62.00	6.00
6.270	GT106.4747.015.42.50.L.T1	5.00	0.15	47	8	2.95	4.70	1.00	42.00	67.00	6.00
6.310	GT106.4747.020.12.50.L.T1	5.00	0.20	47	8	2.95	4.70	1.00	12.00	37.00	6.00
6.320	GT106.4747.020.17.50.L.T1	5.00	0.20	47	8	2.95	4.70	1.00	17.00	42.00	6.00
6.330	GT106.4747.020.22.50.L.T1	5.00	0.20	47	8	2.95	4.70	1.00	22.00	47.00	6.00
6.340	GT106.4747.020.27.50.L.T1	5.00	0.20	47	8	2.95	4.70	1.00	27.00	52.00	6.00
6.350	GT106.4747.020.32.50.L.T1	5.00	0.20	47	8	2.95	4.70	1.00	32.00	57.00	6.00
6.360	GT106.4747.020.37.50.L.T1	5.00	0.20	47	8	2.95	4.70	1.00	37.00	62.00	6.00
6.370	GT106.4747.020.42.50.L.T1	5.00	0.20	47	8	2.95	4.70	1.00	42.00	67.00	6.00
6.410	GT106.4747.030.12.50.L.T1	5.00	0.30	47	8	2.95	4.70	1.00	12.00	37.00	6.00
6.420	GT106.4747.030.17.50.L.T1	5.00	0.30	47	8	2.95	4.70	1.00	17.00	42.00	6.00
6.430	GT106.4747.030.22.50.L.T1	5.00	0.30	47	8	2.95	4.70	1.00	22.00	47.00	6.00
6.440	GT106.4747.030.27.50.L.T1	5.00	0.30	47	8	2.95	4.70	1.00	27.00	52.00	6.00
6.450	GT106.4747.030.32.50.L.T1	5.00	0.30	47	8	2.95	4.70	1.00	32.00	57.00	6.00
6.460	GT106.4747.030.37.50.L.T1	5.00	0.30	47	8	2.95	4.70	1.00	37.00	62.00	6.00
6.470	GT106.4747.030.42.50.L.T1	5.00	0.30	47	8	2.95	4.70	1.00	42.00	67.00	6.00

System 106



Cutting insert for boring out and profiling



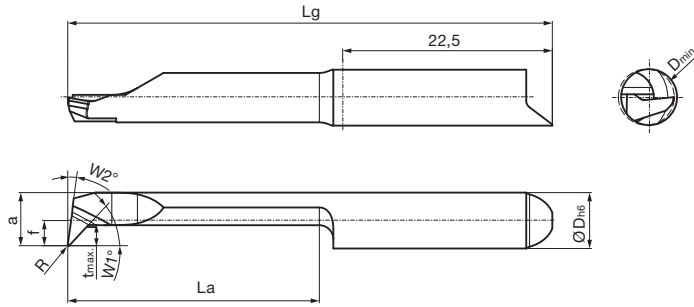
• radial free 47°, tmax 2

for tool holders type GH106/GB106 see from page 62

**GUHRING NAVIGATOR**

Cutting data page 184

System 106



Right hand version shown  
Left hand version mirror image

Article no. **25516** **25518** **25522**

Cutting direction

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
6.010	GT106.4757.005.12.60.R.T2	6.00	0.05	47	8	2.70	5.70	2.00	12.00	37.00	6.00
6.020	GT106.4757.005.17.60.R.T2	6.00	0.05	47	8	2.70	5.70	2.00	17.00	42.00	6.00
6.030	GT106.4757.005.22.60.R.T2	6.00	0.05	47	8	2.70	5.70	2.00	22.00	47.00	6.00
6.040	GT106.4757.005.27.60.R.T2	6.00	0.05	47	8	2.70	5.70	2.00	27.00	52.00	6.00
6.050	GT106.4757.005.32.60.R.T2	6.00	0.05	47	8	2.70	5.70	2.00	32.00	57.00	6.00
6.060	GT106.4757.005.37.60.R.T2	6.00	0.05	47	8	2.70	5.70	2.00	37.00	62.00	6.00
6.070	GT106.4757.005.42.60.R.T2	6.00	0.05	47	8	2.70	5.70	2.00	42.00	67.00	6.00
6.080	GT106.4757.005.47.60.R.T2	6.00	0.05	47	8	2.70	5.70	2.00	47.00	72.00	6.00
6.090	GT106.4757.005.52.60.R.T2	6.00	0.05	47	8	2.70	5.70	2.00	52.00	77.00	6.00
6.110	GT106.4757.010.12.60.R.T2	6.00	0.10	47	8	2.70	5.70	2.00	12.00	37.00	6.00
6.120	GT106.4757.010.17.60.R.T2	6.00	0.10	47	8	2.70	5.70	2.00	17.00	42.00	6.00
6.130	GT106.4757.010.22.60.R.T2	6.00	0.10	47	8	2.70	5.70	2.00	22.00	47.00	6.00
6.140	GT106.4757.010.27.60.R.T2	6.00	0.10	47	8	2.70	5.70	2.00	27.00	52.00	6.00
6.150	GT106.4757.010.32.60.R.T2	6.00	0.10	47	8	2.70	5.70	2.00	32.00	57.00	6.00
6.160	GT106.4757.010.37.60.R.T2	6.00	0.10	47	8	2.70	5.70	2.00	37.00	62.00	6.00
6.170	GT106.4757.010.42.60.R.T2	6.00	0.10	47	8	2.70	5.70	2.00	42.00	67.00	6.00
6.180	GT106.4757.010.47.60.R.T2	6.00	0.10	47	8	2.70	5.70	2.00	47.00	72.00	6.00
6.190	GT106.4757.010.52.60.R.T2	6.00	0.10	47	8	2.70	5.70	2.00	52.00	77.00	6.00
6.210	GT106.4757.015.12.60.R.T2	6.00	0.15	47	8	2.70	5.70	2.00	12.00	37.00	6.00
6.220	GT106.4757.015.17.60.R.T2	6.00	0.15	47	8	2.70	5.70	2.00	17.00	42.00	6.00
6.230	GT106.4757.015.22.60.R.T2	6.00	0.15	47	8	2.70	5.70	2.00	22.00	47.00	6.00
6.240	GT106.4757.015.27.60.R.T2	6.00	0.15	47	8	2.70	5.70	2.00	27.00	52.00	6.00
6.250	GT106.4757.015.32.60.R.T2	6.00	0.15	47	8	2.70	5.70	2.00	32.00	57.00	6.00
6.260	GT106.4757.015.37.60.R.T2	6.00	0.15	47	8	2.70	5.70	2.00	37.00	62.00	6.00
6.270	GT106.4757.015.42.60.R.T2	6.00	0.15	47	8	2.70	5.70	2.00	42.00	67.00	6.00
6.280	GT106.4757.015.47.60.R.T2	6.00	0.15	47	8	2.70	5.70	2.00	47.00	72.00	6.00
6.290	GT106.4757.015.52.60.R.T2	6.00	0.15	47	8	2.70	5.70	2.00	52.00	77.00	6.00
6.310	GT106.4757.020.12.60.R.T2	6.00	0.20	47	8	2.70	5.70	2.00	12.00	37.00	6.00
6.320	GT106.4757.020.17.60.R.T2	6.00	0.20	47	8	2.70	5.70	2.00	17.00	42.00	6.00
6.330	GT106.4757.020.22.60.R.T2	6.00	0.20	47	8	2.70	5.70	2.00	22.00	47.00	6.00
6.340	GT106.4757.020.27.60.R.T2	6.00	0.20	47	8	2.70	5.70	2.00	27.00	52.00	6.00
6.350	GT106.4757.020.32.60.R.T2	6.00	0.20	47	8	2.70	5.70	2.00	32.00	57.00	6.00
6.360	GT106.4757.020.37.60.R.T2	6.00	0.20	47	8	2.70	5.70	2.00	37.00	62.00	6.00
6.370	GT106.4757.020.42.60.R.T2	6.00	0.20	47	8	2.70	5.70	2.00	42.00	67.00	6.00
6.380	GT106.4757.020.47.60.R.T2	6.00	0.20	47	8	2.70	5.70	2.00	47.00	72.00	6.00
6.390	GT106.4757.020.52.60.R.T2	6.00	0.20	47	8	2.70	5.70	2.00	52.00	77.00	6.00
6.410	GT106.4757.030.12.60.R.T2	6.00	0.30	47	8	2.70	5.70	2.00	12.00	37.00	6.00
6.420	GT106.4757.030.17.60.R.T2	6.00	0.30	47	8	2.70	5.70	2.00	17.00	42.00	6.00
6.430	GT106.4757.030.22.60.R.T2	6.00	0.30	47	8	2.70	5.70	2.00	22.00	47.00	6.00
6.440	GT106.4757.030.27.60.R.T2	6.00	0.30	47	8	2.70	5.70	2.00	27.00	52.00	6.00
6.450	GT106.4757.030.32.60.R.T2	6.00	0.30	47	8	2.70	5.70	2.00	32.00	57.00	6.00
6.460	GT106.4757.030.37.60.R.T2	6.00	0.30	47	8	2.70	5.70	2.00	37.00	62.00	6.00



Article no. **25516** **25518** **25522**

Cutting direction   

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
6.470	GT106.4757.030.42.60.R.T2	6.00	0.30	47	8	2.70	5.70	2.00	42.00	67.00	6.00
6.480	GT106.4757.030.47.60.R.T2	6.00	0.30	47	8	2.70	5.70	2.00	47.00	72.00	6.00
6.490	GT106.4757.030.52.60.R.T2	6.00	0.30	47	8	2.70	5.70	2.00	52.00	77.00	6.00

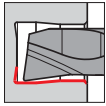
System 106

Article no. **25517** **25519** **25523**

Cutting direction   

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
6.010	GT106.4757.005.12.60.L.T2	6.00	0.05	47	8	2.70	5.70	2.00	12.00	37.00	6.00
6.020	GT106.4757.005.17.60.L.T2	6.00	0.05	47	8	2.70	5.70	2.00	17.00	42.00	6.00
6.030	GT106.4757.005.22.60.L.T2	6.00	0.05	47	8	2.70	5.70	2.00	22.00	47.00	6.00
6.040	GT106.4757.005.27.60.L.T2	6.00	0.05	47	8	2.70	5.70	2.00	27.00	52.00	6.00
6.050	GT106.4757.005.32.60.L.T2	6.00	0.05	47	8	2.70	5.70	2.00	32.00	57.00	6.00
6.060	GT106.4757.005.37.60.L.T2	6.00	0.05	47	8	2.70	5.70	2.00	37.00	62.00	6.00
6.070	GT106.4757.005.42.60.L.T2	6.00	0.05	47	8	2.70	5.70	2.00	42.00	67.00	6.00
6.080	GT106.4757.005.47.60.L.T2	6.00	0.05	47	8	2.70	5.70	2.00	47.00	72.00	6.00
6.090	GT106.4757.010.37.60.L.T2	6.00	0.05	47	8	2.70	5.70	2.00	52.00	77.00	6.00
6.110	GT106.4757.010.12.60.L.T2	6.00	0.10	47	8	2.70	5.70	2.00	12.00	37.00	6.00
6.120	GT106.4757.010.17.60.L.T2	6.00	0.10	47	8	2.70	5.70	2.00	17.00	42.00	6.00
6.130	GT106.4757.010.22.60.L.T2	6.00	0.10	47	8	2.70	5.70	2.00	22.00	47.00	6.00
6.140	GT106.4757.010.27.60.L.T2	6.00	0.10	47	8	2.70	5.70	2.00	27.00	52.00	6.00
6.150	GT106.4757.010.32.60.L.T2	6.00	0.10	47	8	2.70	5.70	2.00	32.00	57.00	6.00
6.160	GT106.4757.010.37.60.L.T2	6.00	0.10	47	8	2.70	5.70	2.00	37.00	62.00	6.00
6.170	GT106.4757.010.42.60.L.T2	6.00	0.10	47	8	2.70	5.70	2.00	42.00	67.00	6.00
6.180	GT106.4757.010.47.60.L.T2	6.00	0.10	47	8	2.70	5.70	2.00	47.00	72.00	6.00
6.190	GT106.4757.010.52.60.L.T2	6.00	0.10	47	8	2.70	5.70	2.00	52.00	77.00	6.00
6.210	GT106.4757.015.12.60.L.T2	6.00	0.15	47	8	2.70	5.70	2.00	12.00	37.00	6.00
6.220	GT106.4757.015.17.60.L.T2	6.00	0.15	47	8	2.70	5.70	2.00	17.00	42.00	6.00
6.230	GT106.4757.015.22.60.L.T2	6.00	0.15	47	8	2.70	5.70	2.00	22.00	47.00	6.00
6.240	GT106.4757.015.27.60.L.T2	6.00	0.15	47	8	2.70	5.70	2.00	27.00	52.00	6.00
6.250	GT106.4757.015.32.60.L.T2	6.00	0.15	47	8	2.70	5.70	2.00	32.00	57.00	6.00
6.260	GT106.4757.015.37.60.L.T2	6.00	0.15	47	8	2.70	5.70	2.00	37.00	62.00	6.00
6.270	GT106.4757.015.42.60.L.T2	6.00	0.15	47	8	2.70	5.70	2.00	42.00	67.00	6.00
6.280	GT106.4757.015.47.60.L.T2	6.00	0.15	47	8	2.70	5.70	2.00	47.00	72.00	6.00
6.290	GT106.4757.015.52.60.L.T2	6.00	0.15	47	8	2.70	5.70	2.00	52.00	77.00	6.00
6.310	GT106.4757.020.12.60.L.T2	6.00	0.20	47	8	2.70	5.70	2.00	12.00	37.00	6.00
6.320	GT106.4757.020.17.60.L.T2	6.00	0.20	47	8	2.70	5.70	2.00	17.00	42.00	6.00
6.330	GT106.4757.020.22.60.L.T2	6.00	0.20	47	8	2.70	5.70	2.00	22.00	47.00	6.00
6.340	GT106.4757.020.27.60.L.T2	6.00	0.20	47	8	2.70	5.70	2.00	27.00	52.00	6.00
6.350	GT106.4757.020.32.60.L.T2	6.00	0.20	47	8	2.70	5.70	2.00	32.00	57.00	6.00
6.360	GT106.4757.020.37.60.L.T2	6.00	0.20	47	8	2.70	5.70	2.00	37.00	62.00	6.00
6.370	GT106.4757.020.42.60.L.T2	6.00	0.20	47	8	2.70	5.70	2.00	42.00	67.00	6.00
6.380	GT106.4757.020.47.60.L.T2	6.00	0.20	47	8	2.70	5.70	2.00	47.00	72.00	6.00
6.390	GT106.4757.020.52.60.L.T2	6.00	0.20	47	8	2.70	5.70	2.00	52.00	77.00	6.00
6.410	GT106.4757.030.12.60.L.T2	6.00	0.30	47	8	2.70	5.70	2.00	12.00	37.00	6.00
6.420	GT106.4757.030.17.60.L.T2	6.00	0.30	47	8	2.70	5.70	2.00	17.00	42.00	6.00
6.430	GT106.4757.030.22.60.L.T2	6.00	0.30	47	8	2.70	5.70	2.00	22.00	47.00	6.00
6.440	GT106.4757.030.27.60.L.T2	6.00	0.30	47	8	2.70	5.70	2.00	27.00	52.00	6.00
6.450	GT106.4757.030.32.60.L.T2	6.00	0.30	47	8	2.70	5.70	2.00	32.00	57.00	6.00
6.460	GT106.4757.030.37.60.L.T2	6.00	0.30	47	8	2.70	5.70	2.00	37.00	62.00	6.00
6.470	GT106.4757.030.42.60.L.T2	6.00	0.30	47	8	2.70	5.70	2.00	42.00	67.00	6.00
6.480	GT106.4757.030.47.60.L.T2	6.00	0.30	47	8	2.70	5.70	2.00	47.00	72.00	6.00
6.490	GT106.4757.030.52.60.L.T2	6.00	0.30	47	8	2.70	5.70	2.00	52.00	77.00	6.00

Cutting insert for boring out and profiling



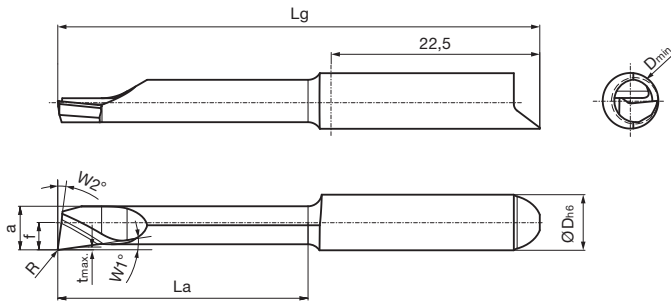
• radial free 8°

for tool holders type GH106/GB106 see from page 62

**GUHRING NAVIGATOR**

Cutting data page 184

System 106



Right hand version shown  
Left hand version mirror image

Tool material	Solid carbide		
	GT 106	GT 106	GT 106
Type			
Surface	<b>S</b> TiN	<b>a</b> TiAlN-nanoA	<b>○</b> bright



Article no. **25500**    **25502**    **25506**

Cutting direction **(R)**    **(R)**    **(R)**

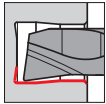
Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
6.010	GT106.0847.005.12.50.R	5.00	0.05	8	8	2.95	4.70	0.30	12.00	37.00	6.00
6.020	GT106.0847.005.17.50.R	5.00	0.05	8	8	2.95	4.70	0.30	17.00	42.00	6.00
6.030	GT106.0847.005.22.50.R	5.00	0.05	8	8	2.95	4.70	0.30	22.00	47.00	6.00
6.040	GT106.0847.005.27.50.R	5.00	0.05	8	8	2.95	4.70	0.30	27.00	52.00	6.00
6.050	GT106.0847.005.32.50.R	5.00	0.05	8	8	2.95	4.70	0.30	32.00	57.00	6.00
6.060	GT106.0847.005.37.50.R	5.00	0.05	8	8	2.95	4.70	0.30	37.00	62.00	6.00
6.070	GT106.0847.010.12.50.R	5.00	0.05	8	8	2.95	4.70	0.30	42.00	67.00	6.00
6.110	GT106.0847.010.12.50.R	5.00	0.10	8	8	2.95	4.70	0.30	12.00	37.00	6.00
6.120	GT106.0847.010.17.50.R	5.00	0.10	8	8	2.95	4.70	0.30	17.00	42.00	6.00
6.130	GT106.0847.010.22.50.R	5.00	0.10	8	8	2.95	4.70	0.30	22.00	47.00	6.00
6.140	GT106.0847.010.27.50.R	5.00	0.10	8	8	2.95	4.70	0.30	27.00	52.00	6.00
6.150	GT106.0847.010.32.50.R	5.00	0.10	8	8	2.95	4.70	0.30	32.00	57.00	6.00
6.160	GT106.0847.010.37.50.R	5.00	0.10	8	8	2.95	4.70	0.30	37.00	62.00	6.00
6.170	GT106.0847.010.42.50.R	5.00	0.10	8	8	2.95	4.70	0.30	42.00	67.00	6.00
6.210	GT106.0847.015.12.50.R	5.00	0.15	8	8	2.95	4.70	0.30	12.00	37.00	6.00
6.220	GT106.0847.015.17.50.R	5.00	0.15	8	8	2.95	4.70	0.30	17.00	42.00	6.00
6.230	GT106.0847.015.22.50.R	5.00	0.15	8	8	2.95	4.70	0.30	22.00	47.00	6.00
6.240	GT106.0847.015.27.50.R	5.00	0.15	8	8	2.95	4.70	0.30	27.00	52.00	6.00
6.250	GT106.0847.015.32.50.R	5.00	0.15	8	8	2.95	4.70	0.30	32.00	57.00	6.00
6.260	GT106.0847.015.37.50.R	5.00	0.15	8	8	2.95	4.70	0.30	37.00	62.00	6.00
6.270	GT106.0847.015.42.50.R	5.00	0.15	8	8	2.95	4.70	0.30	42.00	67.00	6.00
6.310	GT106.0847.020.12.50.R	5.00	0.20	8	8	2.95	4.70	0.30	12.00	37.00	6.00
6.320	GT106.0847.020.17.50.R	5.00	0.20	8	8	2.95	4.70	0.30	17.00	42.00	6.00
6.330	GT106.0847.020.22.50.R	5.00	0.20	8	8	2.95	4.70	0.30	22.00	47.00	6.00
6.340	GT106.0847.020.27.50.R	5.00	0.20	8	8	2.95	4.70	0.30	27.00	52.00	6.00
6.350	GT106.0847.020.32.50.R	5.00	0.20	8	8	2.95	4.70	0.30	32.00	57.00	6.00
6.360	GT106.0847.020.37.50.R	5.00	0.20	8	8	2.95	4.70	0.30	37.00	62.00	6.00
6.370	GT106.0847.020.42.50.R	5.00	0.20	8	8	2.95	4.70	0.30	42.00	67.00	6.00
6.410	GT106.0847.030.12.50.R	5.00	0.30	8	8	2.95	4.70	0.30	12.00	37.00	6.00
6.420	GT106.0847.030.17.50.R	5.00	0.30	8	8	2.95	4.70	0.30	17.00	42.00	6.00
6.430	GT106.0847.030.22.50.R	5.00	0.30	8	8	2.95	4.70	0.30	22.00	47.00	6.00
6.440	GT106.0847.030.27.50.R	5.00	0.30	8	8	2.95	4.70	0.30	27.00	52.00	6.00
6.450	GT106.0847.030.32.50.R	5.00	0.30	8	8	2.95	4.70	0.30	32.00	57.00	6.00
6.460	GT106.0847.030.37.50.R	5.00	0.30	8	8	2.95	4.70	0.30	37.00	62.00	6.00
6.470	GT106.0847.030.42.50.R	5.00	0.30	8	8	2.95	4.70	0.30	42.00	67.00	6.00

Article no. **25501** **25503** **25507**Cutting direction   

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
6.010	GT106.0847.005.12.50.L	5.00	0.05	8	8	2.95	4.70	0.30	12.00	37.00	6.00
6.020	GT106.0847.005.17.50.L	5.00	0.05	8	8	2.95	4.70	0.30	17.00	42.00	6.00
6.030	GT106.0847.005.22.50.L	5.00	0.05	8	8	2.95	4.70	0.30	22.00	47.00	6.00
6.040	GT106.0847.005.27.50.L	5.00	0.05	8	8	2.95	4.70	0.30	27.00	52.00	6.00
6.050	GT106.0847.005.32.50.L	5.00	0.05	8	8	2.95	4.70	0.30	32.00	57.00	6.00
6.060	GT106.0847.005.37.50.L	5.00	0.05	8	8	2.95	4.70	0.30	37.00	62.00	6.00
6.070	GT106.0847.005.42.50.L	5.00	0.05	8	8	2.95	4.70	0.30	42.00	67.00	6.00
6.110	GT106.0847.010.12.50.L	5.00	0.10	8	8	2.95	4.70	0.30	12.00	37.00	6.00
6.120	GT106.0847.010.17.50.L	5.00	0.10	8	8	2.95	4.70	0.30	17.00	42.00	6.00
6.130	GT106.0847.010.22.50.L	5.00	0.10	8	8	2.95	4.70	0.30	22.00	47.00	6.00
6.140	GT106.0847.010.27.50.L	5.00	0.10	8	8	2.95	4.70	0.30	27.00	52.00	6.00
6.150	GT106.0847.010.32.50.L	5.00	0.10	8	8	2.95	4.70	0.30	32.00	57.00	6.00
6.160	GT106.0847.010.37.50.L	5.00	0.10	8	8	2.95	4.70	0.30	37.00	62.00	6.00
6.170	GT106.0847.010.42.50.L	5.00	0.10	8	8	2.95	4.70	0.30	42.00	67.00	6.00
6.210	GT106.0847.015.12.50.L	5.00	0.15	8	8	2.95	4.70	0.30	12.00	37.00	6.00
6.220	GT106.0847.015.17.50.L	5.00	0.15	8	8	2.95	4.70	0.30	17.00	42.00	6.00
6.230	GT106.0847.015.22.50.L	5.00	0.15	8	8	2.95	4.70	0.30	22.00	47.00	6.00
6.240	GT106.0847.015.27.50.L	5.00	0.15	8	8	2.95	4.70	0.30	27.00	52.00	6.00
6.250	GT106.0847.015.32.50.L	5.00	0.15	8	8	2.95	4.70	0.30	32.00	57.00	6.00
6.260	GT106.0847.015.37.50.L	5.00	0.15	8	8	2.95	4.70	0.30	37.00	62.00	6.00
6.270	GT106.0847.015.42.50.L	5.00	0.15	8	8	2.95	4.70	0.30	42.00	67.00	6.00
6.310	GT106.0847.020.12.50.L	5.00	0.20	8	8	2.95	4.70	0.30	12.00	37.00	6.00
6.320	GT106.0847.020.17.50.L	5.00	0.20	8	8	2.95	4.70	0.30	17.00	42.00	6.00
6.330	GT106.0847.020.22.50.L	5.00	0.20	8	8	2.95	4.70	0.30	22.00	47.00	6.00
6.340	GT106.0847.020.27.50.L	5.00	0.20	8	8	2.95	4.70	0.30	27.00	52.00	6.00
6.350	GT106.0847.020.32.50.L	5.00	0.20	8	8	2.95	4.70	0.30	32.00	57.00	6.00
6.360	GT106.0847.020.37.50.L	5.00	0.20	8	8	2.95	4.70	0.30	37.00	62.00	6.00
6.370	GT106.0847.020.42.50.L	5.00	0.20	8	8	2.95	4.70	0.30	42.00	67.00	6.00
6.410	GT106.0847.030.12.50.L	5.00	0.30	8	8	2.95	4.70	0.30	12.00	37.00	6.00
6.420	GT106.0847.030.17.50.L	5.00	0.30	8	8	2.95	4.70	0.30	17.00	42.00	6.00
6.430	GT106.0847.030.22.50.L	5.00	0.30	8	8	2.95	4.70	0.30	22.00	47.00	6.00
6.440	GT106.0847.030.27.50.L	5.00	0.30	8	8	2.95	4.70	0.30	27.00	52.00	6.00
6.450	GT106.0847.030.32.50.L	5.00	0.30	8	8	2.95	4.70	0.30	32.00	57.00	6.00
6.460	GT106.0847.030.37.50.L	5.00	0.30	8	8	2.95	4.70	0.30	37.00	62.00	6.00
6.470	GT106.0847.030.42.50.L	5.00	0.30	8	8	2.95	4.70	0.30	42.00	67.00	6.00

System 106

**Cutting insert for boring out and profiling**



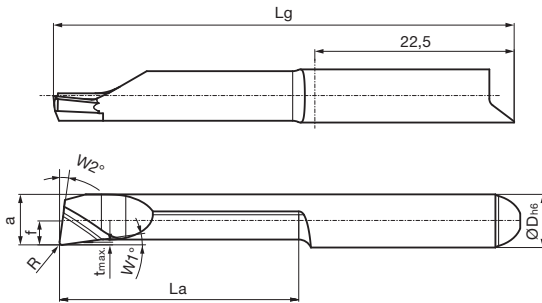
• radial free 8°

for tool holders type GH106/GB106 see from page 62

**GUHRING NAVIGATOR**

Cutting data page 184

System 106



Right hand version shown  
Left hand version mirror image

Article no.	<b>25508</b>	<b>25510</b>	<b>25514</b>
Cutting direction			

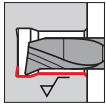
Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
6.010	GT106.0857.005.12.60.R	6.00	0.05	8	8	2.70	5.70	0.30	12.00	37.00	6.00
6.020	GT106.0857.005.17.60.R	6.00	0.05	8	8	2.70	5.70	0.30	17.00	42.00	6.00
6.030	GT106.0857.005.22.60.R	6.00	0.05	8	8	2.70	5.70	0.30	22.00	47.00	6.00
6.040	GT106.0857.005.27.60.R	6.00	0.05	8	8	2.70	5.70	0.30	27.00	52.00	6.00
6.050	GT106.0857.005.32.60.R	6.00	0.05	8	8	2.70	5.70	0.30	32.00	57.00	6.00
6.060	GT106.0857.005.37.60.R	6.00	0.05	8	8	2.70	5.70	0.30	37.00	62.00	6.00
6.070	GT106.0857.010.12.60.R	6.00	0.05	8	8	2.70	5.70	0.30	42.00	67.00	6.00
6.110	GT106.0857.010.12.60.R	6.00	0.10	8	8	2.70	5.70	0.30	12.00	37.00	6.00
6.120	GT106.0857.010.17.60.R	6.00	0.10	8	8	2.70	5.70	0.30	17.00	42.00	6.00
6.130	GT106.0857.010.22.60.R	6.00	0.10	8	8	2.70	5.70	0.30	22.00	47.00	6.00
6.140	GT106.0857.010.27.60.R	6.00	0.10	8	8	2.70	5.70	0.30	27.00	52.00	6.00
6.150	GT106.0857.010.32.60.R	6.00	0.10	8	8	2.70	5.70	0.30	32.00	57.00	6.00
6.160	GT106.0857.010.37.60.R	6.00	0.10	8	8	2.70	5.70	0.30	37.00	62.00	6.00
6.170	GT106.0857.010.42.60.R	6.00	0.10	8	8	2.70	5.70	0.30	42.00	67.00	6.00
6.210	GT106.0857.015.12.60.R	6.00	0.15	8	8	2.70	5.70	0.30	12.00	37.00	6.00
6.220	GT106.0857.015.17.60.R	6.00	0.15	8	8	2.70	5.70	0.30	17.00	42.00	6.00
6.230	GT106.0857.015.22.60.R	6.00	0.15	8	8	2.70	5.70	0.30	22.00	47.00	6.00
6.240	GT106.0857.015.27.60.R	6.00	0.15	8	8	2.70	5.70	0.30	27.00	52.00	6.00
6.250	GT106.0857.015.32.60.R	6.00	0.15	8	8	2.70	5.70	0.30	32.00	57.00	6.00
6.260	GT106.0857.015.37.60.R	6.00	0.15	8	8	2.70	5.70	0.30	37.00	62.00	6.00
6.270	GT106.0857.015.42.60.R	6.00	0.15	8	8	2.70	5.70	0.30	42.00	67.00	6.00
6.310	GT106.0857.020.12.60.R	6.00	0.20	8	8	2.70	5.70	0.30	12.00	37.00	6.00
6.320	GT106.0857.020.17.60.R	6.00	0.20	8	8	2.70	5.70	0.30	17.00	42.00	6.00
6.330	GT106.0857.020.22.60.R	6.00	0.20	8	8	2.70	5.70	0.30	22.00	47.00	6.00
6.340	GT106.0857.020.27.60.R	6.00	0.20	8	8	2.70	5.70	0.30	27.00	52.00	6.00
6.350	GT106.0857.020.32.60.R	6.00	0.20	8	8	2.70	5.70	0.30	32.00	57.00	6.00
6.360	GT106.0857.020.37.60.R	6.00	0.20	8	8	2.70	5.70	0.30	37.00	62.00	6.00
6.370	GT106.0857.020.42.60.R	6.00	0.20	8	8	2.70	5.70	0.30	42.00	67.00	6.00
6.410	GT106.0857.030.12.60.R	6.00	0.30	8	8	2.70	5.70	0.30	12.00	37.00	6.00
6.420	GT106.0857.030.17.60.R	6.00	0.30	8	8	2.70	5.70	0.30	17.00	42.00	6.00
6.430	GT106.0857.030.22.60.R	6.00	0.30	8	8	2.70	5.70	0.30	22.00	47.00	6.00
6.440	GT106.0857.030.27.60.R	6.00	0.30	8	8	2.70	5.70	0.30	27.00	52.00	6.00
6.450	GT106.0857.030.32.60.R	6.00	0.30	8	8	2.70	5.70	0.30	32.00	57.00	6.00
6.460	GT106.0857.030.37.60.R	6.00	0.30	8	8	2.70	5.70	0.30	37.00	62.00	6.00
6.470	GT106.0857.030.42.60.R	6.00	0.30	8	8	2.70	5.70	0.30	42.00	67.00	6.00

Article no. **25509** **25511** **25515**Cutting direction   

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
6.010	GT106.0857.005.12.60.L	6.00	0.05	8	8	2.70	5.70	0.30	12.00	37.00	6.00
6.020	GT106.0857.005.17.60.L	6.00	0.05	8	8	2.70	5.70	0.30	17.00	42.00	6.00
6.030	GT106.0857.005.22.60.L	6.00	0.05	8	8	2.70	5.70	0.30	22.00	47.00	6.00
6.040	GT106.0857.005.27.60.L	6.00	0.05	8	8	2.70	5.70	0.30	27.00	52.00	6.00
6.050	GT106.0857.005.32.60.L	6.00	0.05	8	8	2.70	5.70	0.30	32.00	57.00	6.00
6.060	GT106.0857.005.37.60.L	6.00	0.05	8	8	2.70	5.70	0.30	37.00	62.00	6.00
6.070	GT106.0857.005.42.60.L	6.00	0.05	8	8	2.70	5.70	0.30	42.00	67.00	6.00
6.110	GT106.0857.010.12.60.L	6.00	0.10	8	8	2.70	5.70	0.30	12.00	37.00	6.00
6.120	GT106.0857.010.17.60.L	6.00	0.10	8	8	2.70	5.70	0.30	17.00	42.00	6.00
6.130	GT106.0857.010.22.60.L	6.00	0.10	8	8	2.70	5.70	0.30	22.00	47.00	6.00
6.140	GT106.0857.010.27.60.L	6.00	0.10	8	8	2.70	5.70	0.30	27.00	52.00	6.00
6.150	GT106.0857.010.32.60.L	6.00	0.10	8	8	2.70	5.70	0.30	32.00	57.00	6.00
6.160	GT106.0857.010.37.60.L	6.00	0.10	8	8	2.70	5.70	0.30	37.00	62.00	6.00
6.170	GT106.0857.010.42.60.L	6.00	0.10	8	8	2.70	5.70	0.30	42.00	67.00	6.00
6.210	GT106.0857.015.12.60.L	6.00	0.15	8	8	2.70	5.70	0.30	12.00	37.00	6.00
6.220	GT106.0857.015.17.60.L	6.00	0.15	8	8	2.70	5.70	0.30	17.00	42.00	6.00
6.230	GT106.0857.015.22.60.L	6.00	0.15	8	8	2.70	5.70	0.30	22.00	47.00	6.00
6.240	GT106.0857.015.27.60.L	6.00	0.15	8	8	2.70	5.70	0.30	27.00	52.00	6.00
6.250	GT106.0857.015.32.60.L	6.00	0.15	8	8	2.70	5.70	0.30	32.00	57.00	6.00
6.260	GT106.0857.015.37.60.L	6.00	0.15	8	8	2.70	5.70	0.30	37.00	62.00	6.00
6.270	GT106.0857.015.42.60.L	6.00	0.15	8	8	2.70	5.70	0.30	42.00	67.00	6.00
6.310	GT106.0857.020.12.60.L	6.00	0.20	8	8	2.70	5.70	0.30	12.00	37.00	6.00
6.320	GT106.0857.020.17.60.L	6.00	0.20	8	8	2.70	5.70	0.30	17.00	42.00	6.00
6.330	GT106.0857.020.22.60.L	6.00	0.20	8	8	2.70	5.70	0.30	22.00	47.00	6.00
6.340	GT106.0857.020.27.60.L	6.00	0.20	8	8	2.70	5.70	0.30	27.00	52.00	6.00
6.350	GT106.0857.020.32.60.L	6.00	0.20	8	8	2.70	5.70	0.30	32.00	57.00	6.00
6.360	GT106.0857.020.37.60.L	6.00	0.20	8	8	2.70	5.70	0.30	37.00	62.00	6.00
6.370	GT106.0857.020.42.60.L	6.00	0.20	8	8	2.70	5.70	0.30	42.00	67.00	6.00
6.410	GT106.0857.030.12.60.L	6.00	0.30	8	8	2.70	5.70	0.30	12.00	37.00	6.00
6.420	GT106.0857.030.17.60.L	6.00	0.30	8	8	2.70	5.70	0.30	17.00	42.00	6.00
6.430	GT106.0857.030.22.60.L	6.00	0.30	8	8	2.70	5.70	0.30	22.00	47.00	6.00
6.440	GT106.0857.030.27.60.L	6.00	0.30	8	8	2.70	5.70	0.30	27.00	52.00	6.00
6.450	GT106.0857.030.32.60.L	6.00	0.30	8	8	2.70	5.70	0.30	32.00	57.00	6.00
6.460	GT106.0857.030.37.60.L	6.00	0.30	8	8	2.70	5.70	0.30	37.00	62.00	6.00
6.470	GT106.0857.030.42.60.L	6.00	0.30	8	8	2.70	5.70	0.30	42.00	67.00	6.00

System 106

Cutting insert for boring out and profiling



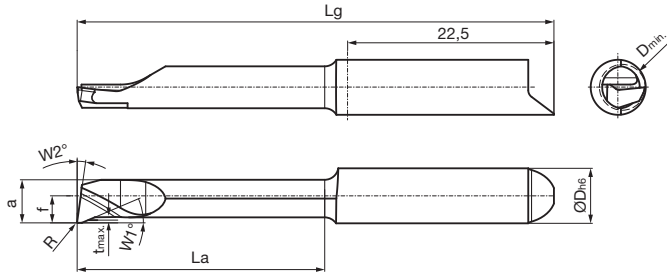
• WIPER-geometry

for tool holders type GH106/GB106 see from page 62

**GUHRING NAVIGATOR**

Cutting data page 184

System 106



Right hand version shown  
Left hand version mirror image



Article no. **25848** **25850** **25854**

Cutting direction

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
6.010	GJ106.2347.005.12.50.R	5.00	0.05	23	8	2.95	4.70	0.30	12.00	37.00	6.00
6.020	GJ106.2347.005.17.50.R	5.00	0.05	23	8	2.95	4.70	0.30	17.00	42.00	6.00
6.030	GJ106.2347.005.22.50.R	5.00	0.05	23	8	2.95	4.70	0.30	22.00	47.00	6.00
6.040	GJ106.2347.005.27.50.R	5.00	0.05	23	8	2.95	4.70	0.30	27.00	52.00	6.00
6.050	GJ106.2347.005.32.50.R	5.00	0.05	23	8	2.95	4.70	0.30	32.00	57.00	6.00
6.060	GJ106.2347.005.37.50.R	5.00	0.05	23	8	2.95	4.70	0.30	37.00	62.00	6.00
6.070	GJ106.2347.010.12.50.R	5.00	0.05	23	8	2.95	4.70	0.30	42.00	67.00	6.00
6.110	GJ106.2347.010.12.50.R	5.00	0.10	23	8	2.95	4.70	0.30	12.00	37.00	6.00
6.120	GJ106.2347.010.17.50.R	5.00	0.10	23	8	2.95	4.70	0.30	17.00	42.00	6.00
6.130	GJ106.2347.010.22.50.R	5.00	0.10	23	8	2.95	4.70	0.30	22.00	47.00	6.00
6.140	GJ106.2347.010.27.50.R	5.00	0.10	23	8	2.95	4.70	0.30	27.00	52.00	6.00
6.150	GJ106.2347.010.32.50.R	5.00	0.10	23	8	2.95	4.70	0.30	32.00	57.00	6.00
6.160	GJ106.2347.010.37.50.R	5.00	0.10	23	8	2.95	4.70	0.30	37.00	62.00	6.00
6.170	GJ106.2347.010.42.50.R	5.00	0.10	23	8	2.95	4.70	0.30	42.00	67.00	6.00
6.210	GJ106.2347.015.12.50.R	5.00	0.15	23	8	2.95	4.70	0.30	12.00	37.00	6.00
6.220	GJ106.2347.015.17.50.R	5.00	0.15	23	8	2.95	4.70	0.30	17.00	42.00	6.00
6.230	GJ106.2347.015.22.50.R	5.00	0.15	23	8	2.95	4.70	0.30	22.00	47.00	6.00
6.240	GJ106.2347.015.27.50.R	5.00	0.15	23	8	2.95	4.70	0.30	27.00	52.00	6.00
6.250	GJ106.2347.015.32.50.R	5.00	0.15	23	8	2.95	4.70	0.30	32.00	57.00	6.00
6.260	GJ106.2347.015.37.50.R	5.00	0.15	23	8	2.95	4.70	0.30	37.00	62.00	6.00
6.270	GJ106.2347.015.42.50.R	5.00	0.15	23	8	2.95	4.70	0.30	42.00	67.00	6.00
6.310	GJ106.2347.020.12.50.R	5.00	0.20	23	8	2.95	4.70	0.30	12.00	37.00	6.00
6.320	GJ106.2347.020.17.50.R	5.00	0.20	23	8	2.95	4.70	0.30	17.00	42.00	6.00
6.330	GJ106.2347.020.22.50.R	5.00	0.20	23	8	2.95	4.70	0.30	22.00	47.00	6.00
6.340	GJ106.2347.020.27.50.R	5.00	0.20	23	8	2.95	4.70	0.30	27.00	52.00	6.00
6.350	GJ106.2347.020.32.50.R	5.00	0.20	23	8	2.95	4.70	0.30	32.00	57.00	6.00
6.360	GJ106.2347.020.37.50.R	5.00	0.20	23	8	2.95	4.70	0.30	37.00	62.00	6.00
6.370	GJ106.2347.020.42.50.R	5.00	0.20	23	8	2.95	4.70	0.30	42.00	67.00	6.00
6.410	GJ106.2347.030.12.50.R	5.00	0.30	23	8	2.95	4.70	0.30	12.00	37.00	6.00
6.420	GJ106.2347.030.17.50.R	5.00	0.30	23	8	2.95	4.70	0.30	17.00	42.00	6.00
6.430	GJ106.2347.030.22.50.R	5.00	0.30	23	8	2.95	4.70	0.30	22.00	47.00	6.00
6.440	GJ106.2347.030.27.50.R	5.00	0.30	23	8	2.95	4.70	0.30	27.00	52.00	6.00
6.450	GJ106.2347.030.32.50.R	5.00	0.30	23	8	2.95	4.70	0.30	32.00	57.00	6.00
6.460	GJ106.2347.030.37.50.R	5.00	0.30	23	8	2.95	4.70	0.30	37.00	62.00	6.00
6.470	GJ106.2347.030.42.50.R	5.00	0.30	23	8	2.95	4.70	0.30	42.00	67.00	6.00

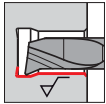
Article no. **25849** **25851** **25855**Cutting direction   

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
6.010	GJ106.2347.005.12.50.L	5.00	0.05	23	8	2.95	4.70	0.30	12.00	37.00	6.00
6.020	GJ106.2347.005.17.50.L	5.00	0.05	23	8	2.95	4.70	0.30	17.00	42.00	6.00
6.030	GJ106.2347.005.22.50.L	5.00	0.05	23	8	2.95	4.70	0.30	22.00	47.00	6.00
6.040	GJ106.2347.005.27.50.L	5.00	0.05	23	8	2.95	4.70	0.30	27.00	52.00	6.00
6.050	GJ106.2347.005.32.50.L	5.00	0.05	23	8	2.95	4.70	0.30	32.00	57.00	6.00
6.060	GJ106.2347.005.37.50.L	5.00	0.05	23	8	2.95	4.70	0.30	37.00	62.00	6.00
6.070	GJ106.2347.005.42.50.L	5.00	0.05	23	8	2.95	4.70	0.30	42.00	67.00	6.00
6.110	GJ106.2347.010.12.50.L	5.00	0.10	23	8	2.95	4.70	0.30	12.00	37.00	6.00
6.120	GJ106.2347.010.17.50.L	5.00	0.10	23	8	2.95	4.70	0.30	17.00	42.00	6.00
6.130	GJ106.2347.010.22.50.L	5.00	0.10	23	8	2.95	4.70	0.30	22.00	47.00	6.00
6.140	GJ106.2347.010.27.50.L	5.00	0.10	23	8	2.95	4.70	0.30	27.00	52.00	6.00
6.150	GJ106.2347.010.32.50.L	5.00	0.10	23	8	2.95	4.70	0.30	32.00	57.00	6.00
6.160	GJ106.2347.010.37.50.L	5.00	0.10	23	8	2.95	4.70	0.30	37.00	62.00	6.00
6.170	GJ106.2347.010.42.50.L	5.00	0.10	23	8	2.95	4.70	0.30	42.00	67.00	6.00
6.210	GJ106.2347.015.12.50.L	5.00	0.15	23	8	2.95	4.70	0.30	12.00	37.00	6.00
6.220	GJ106.2347.015.17.50.L	5.00	0.15	23	8	2.95	4.70	0.30	17.00	42.00	6.00
6.230	GJ106.2347.015.22.50.L	5.00	0.15	23	8	2.95	4.70	0.30	22.00	47.00	6.00
6.240	GJ106.2347.015.27.50.L	5.00	0.15	23	8	2.95	4.70	0.30	27.00	52.00	6.00
6.250	GJ106.2347.015.32.50.L	5.00	0.15	23	8	2.95	4.70	0.30	32.00	57.00	6.00
6.260	GJ106.2347.015.37.50.L	5.00	0.15	23	8	2.95	4.70	0.30	37.00	62.00	6.00
6.270	GJ106.2347.015.42.50.L	5.00	0.15	23	8	2.95	4.70	0.30	42.00	67.00	6.00
6.310	GJ106.2347.020.12.50.L	5.00	0.20	23	8	2.95	4.70	0.30	12.00	37.00	6.00
6.320	GJ106.2347.020.17.50.L	5.00	0.20	23	8	2.95	4.70	0.30	17.00	42.00	6.00
6.330	GJ106.2347.020.22.50.L	5.00	0.20	23	8	2.95	4.70	0.30	22.00	47.00	6.00
6.340	GJ106.2347.020.27.50.L	5.00	0.20	23	8	2.95	4.70	0.30	27.00	52.00	6.00
6.350	GJ106.2347.020.32.50.L	5.00	0.20	23	8	2.95	4.70	0.30	32.00	57.00	6.00
6.360	GJ106.2347.020.37.50.L	5.00	0.20	23	8	2.95	4.70	0.30	37.00	62.00	6.00
6.370	GJ106.2347.020.42.50.L	5.00	0.20	23	8	2.95	4.70	0.30	42.00	67.00	6.00
6.410	GJ106.2347.030.12.50.L	5.00	0.30	23	8	2.95	4.70	0.30	12.00	37.00	6.00
6.420	GJ106.2347.030.17.50.L	5.00	0.30	23	8	2.95	4.70	0.30	17.00	42.00	6.00
6.430	GJ106.2347.030.22.50.L	5.00	0.30	23	8	2.95	4.70	0.30	22.00	47.00	6.00
6.440	GJ106.2347.030.27.50.L	5.00	0.30	23	8	2.95	4.70	0.30	27.00	52.00	6.00
6.450	GJ106.2347.030.32.50.L	5.00	0.30	23	8	2.95	4.70	0.30	32.00	57.00	6.00
6.460	GJ106.2347.030.37.50.L	5.00	0.30	23	8	2.95	4.70	0.30	37.00	62.00	6.00
6.470	GJ106.2347.030.42.50.L	5.00	0.30	23	8	2.95	4.70	0.30	42.00	67.00	6.00

System 106



**Cutting insert for boring out and profiling**



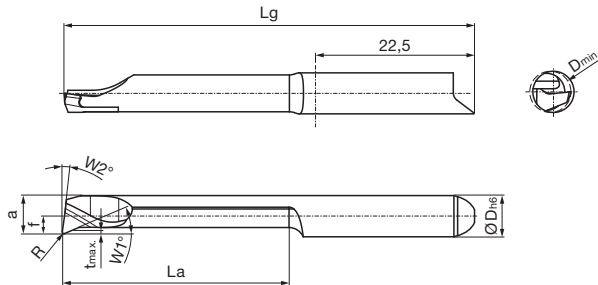
• WIPER-geometry

for tool holders type GH106/GB106 see from page 62

**GUHRING NAVIGATOR**

Cutting data page 184

System 106



Right hand version shown  
Left hand version mirror image

Article no. **25716** **25718** **25722**

Cutting direction

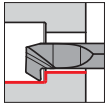
Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
6.019	GJ106.2357.005.12.60.R	6.00	0.05	23	8	2.70	5.70	0.30	12.00	37.00	6.00
6.020	GJ106.2357.005.17.60.R	6.00	0.05	23	8	2.70	5.70	0.30	17.00	42.00	6.00
6.021	GJ106.2357.005.22.60.R	6.00	0.05	23	8	2.70	5.70	0.30	22.00	47.00	6.00
6.022	GJ106.2357.005.27.60.R	6.00	0.05	23	8	2.70	5.70	0.30	27.00	52.00	6.00
6.023	GJ106.2357.005.32.60.R	6.00	0.05	23	8	2.70	5.70	0.30	32.00	57.00	6.00
6.024	GJ106.2357.005.37.60.R	6.00	0.05	23	8	2.70	5.70	0.30	37.00	62.00	6.00
6.025	GJ106.2357.005.42.60.R	6.00	0.05	23	8	2.70	5.70	0.30	42.00	67.00	6.00
6.026	GJ106.2357.005.47.60.R	6.00	0.05	23	8	2.70	5.70	0.30	47.00	72.00	6.00
6.027	GJ106.2357.005.52.60.R	6.00	0.05	23	8	2.70	5.70	0.30	52.00	77.00	6.00
6.013	GJ106.2357.015.12.60.R	6.00	0.15	23	8	2.70	5.70	0.30	12.00	37.00	6.00
6.014	GJ106.2357.015.17.60.R	6.00	0.15	23	8	2.70	5.70	0.30	17.00	42.00	6.00
6.015	GJ106.2357.015.22.60.R	6.00	0.15	23	8	2.70	5.70	0.30	22.00	47.00	6.00
6.001	GJ106.2357.015.27.60.R	6.00	0.15	23	8	2.70	5.70	0.30	27.00	52.00	6.00
6.002	GJ106.2357.015.32.60.R	6.00	0.15	23	8	2.70	5.70	0.30	32.00	57.00	6.00
6.003	GJ106.2357.015.37.60.R	6.00	0.15	23	8	2.70	5.70	0.30	37.00	62.00	6.00
6.004	GJ106.2357.015.42.60.R	6.00	0.15	23	8	2.70	5.70	0.30	42.00	67.00	6.00
6.005	GJ106.2357.015.47.60.R	6.00	0.15	23	8	2.70	5.70	0.30	47.00	72.00	6.00
6.006	GJ106.2357.015.52.60.R	6.00	0.15	23	8	2.70	5.70	0.30	52.00	77.00	6.00
6.028	GJ106.2357.020.12.60.R	6.00	0.20	23	8	2.70	5.70	0.30	12.00	37.00	6.00
6.029	GJ106.2357.020.17.60.R	6.00	0.20	23	8	2.70	5.70	0.30	17.00	42.00	6.00
6.030	GJ106.2357.020.22.60.R	6.00	0.20	23	8	2.70	5.70	0.30	22.00	47.00	6.00
6.031	GJ106.2357.020.27.60.R	6.00	0.20	23	8	2.70	5.70	0.30	27.00	52.00	6.00
6.032	GJ106.2357.020.32.60.R	6.00	0.20	23	8	2.70	5.70	0.30	32.00	57.00	6.00
6.033	GJ106.2357.020.37.60.R	6.00	0.20	23	8	2.70	5.70	0.30	37.00	62.00	6.00
6.034	GJ106.2357.020.42.60.R	6.00	0.20	23	8	2.70	5.70	0.30	42.00	67.00	6.00
6.035	GJ106.2357.020.47.60.R	6.00	0.20	23	8	2.70	5.70	0.30	47.00	72.00	6.00
6.036	GJ106.2357.020.52.60.R	6.00	0.20	23	8	2.70	5.70	0.30	52.00	77.00	6.00
6.016	GJ106.2357.030.12.60.R	6.00	0.30	23	8	2.70	5.70	0.30	12.00	37.00	6.00
6.017	GJ106.2357.030.17.60.R	6.00	0.30	23	8	2.70	5.70	0.30	17.00	42.00	6.00
6.018	GJ106.2357.030.22.60.R	6.00	0.30	23	8	2.70	5.70	0.30	22.00	47.00	6.00
6.007	GJ106.2357.030.27.60.R	6.00	0.30	23	8	2.70	5.70	0.30	27.00	52.00	6.00
6.008	GJ106.2357.030.32.60.R	6.00	0.30	23	8	2.70	5.70	0.30	32.00	57.00	6.00
6.009	GJ106.2357.030.37.60.R	6.00	0.30	23	8	2.70	5.70	0.30	37.00	62.00	6.00
6.010	GJ106.2357.030.42.60.R	6.00	0.30	23	8	2.70	5.70	0.30	42.00	67.00	6.00
6.011	GJ106.2357.030.47.60.R	6.00	0.30	23	8	2.70	5.70	0.30	47.00	72.00	6.00
6.012	GJ106.2357.030.52.60.R	6.00	0.30	23	8	2.70	5.70	0.30	52.00	77.00	6.00

Article no. **25717** **25719** **25723**Cutting direction   

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
6.019	GJ106.2357.005.12.60.L	6.00	0.05	23	8	2.70	5.70	0.30	12.00	37.00	6.00
6.020	GJ106.2357.005.17.60.L	6.00	0.05	23	8	2.70	5.70	0.30	17.00	42.00	6.00
6.021	GJ106.2357.005.22.60.L	6.00	0.05	23	8	2.70	5.70	0.30	22.00	47.00	6.00
6.022	GJ106.2357.005.27.60.L	6.00	0.05	23	8	2.70	5.70	0.30	27.00	52.00	6.00
6.023	GJ106.2357.005.32.60.L	6.00	0.05	23	8	2.70	5.70	0.30	32.00	57.00	6.00
6.024	GJ106.2357.005.37.60.L	6.00	0.05	23	8	2.70	5.70	0.30	37.00	62.00	6.00
6.025	GJ106.2357.005.42.60.L	6.00	0.05	23	8	2.70	5.70	0.30	42.00	67.00	6.00
6.026	GJ106.2357.005.47.60.L	6.00	0.05	23	8	2.70	5.70	0.30	47.00	72.00	6.00
6.027	GJ106.2357.005.52.60.L	6.00	0.05	23	8	2.70	5.70	0.30	52.00	77.00	6.00
6.013	GJ106.2357.015.12.60.L	6.00	0.15	23	8	2.70	5.70	0.30	12.00	37.00	6.00
6.014	GJ106.2357.015.17.60.L	6.00	0.15	23	8	2.70	5.70	0.30	17.00	42.00	6.00
6.015	GJ106.2357.015.22.60.L	6.00	0.15	23	8	2.70	5.70	0.30	22.00	47.00	6.00
6.001	GJ106.2357.015.27.60.L	6.00	0.15	23	8	2.70	5.70	0.30	27.00	52.00	6.00
6.002	GJ106.2357.015.32.60.L	6.00	0.15	23	8	2.70	5.70	0.30	32.00	57.00	6.00
6.003	GJ106.2357.015.37.60.L	6.00	0.15	23	8	2.70	5.70	0.30	37.00	62.00	6.00
6.004	GJ106.2357.015.42.60.L	6.00	0.15	23	8	2.70	5.70	0.30	42.00	67.00	6.00
6.005	GJ106.2357.015.47.60.L	6.00	0.15	23	8	2.70	5.70	0.30	47.00	72.00	6.00
6.006	GJ106.2357.015.52.60.L	6.00	0.15	23	8	2.70	5.70	0.30	52.00	77.00	6.00
6.028	GJ106.2357.020.12.60.L	6.00	0.20	23	8	2.70	5.70	0.30	12.00	37.00	6.00
6.029	GJ106.2357.020.17.60.L	6.00	0.20	23	8	2.70	5.70	0.30	17.00	42.00	6.00
6.030	GJ106.2357.020.22.60.L	6.00	0.20	23	8	2.70	5.70	0.30	22.00	47.00	6.00
6.031	GJ106.2357.020.27.60.L	6.00	0.20	23	8	2.70	5.70	0.30	27.00	52.00	6.00
6.032	GJ106.2357.020.32.60.L	6.00	0.20	23	8	2.70	5.70	0.30	32.00	57.00	6.00
6.033	GJ106.2357.020.37.60.L	6.00	0.20	23	8	2.70	5.70	0.30	37.00	62.00	6.00
6.034	GJ106.2357.020.42.60.L	6.00	0.20	23	8	2.70	5.70	0.30	42.00	67.00	6.00
6.035	GJ106.2357.020.47.60.L	6.00	0.20	23	8	2.70	5.70	0.30	47.00	72.00	6.00
6.036	GJ106.2357.020.52.60.L	6.00	0.20	23	8	2.70	5.70	0.30	52.00	77.00	6.00
6.016	GJ106.2357.030.12.60.L	6.00	0.30	23	8	2.70	5.70	0.30	12.00	37.00	6.00
6.017	GJ106.2357.030.17.60.L	6.00	0.30	23	8	2.70	5.70	0.30	17.00	42.00	6.00
6.018	GJ106.2357.030.22.60.L	6.00	0.30	23	8	2.70	5.70	0.30	22.00	47.00	6.00
6.007	GJ106.2357.030.27.60.L	6.00	0.30	23	8	2.70	5.70	0.30	27.00	52.00	6.00
6.008	GJ106.2357.030.32.60.L	6.00	0.30	23	8	2.70	5.70	0.30	32.00	57.00	6.00
6.009	GJ106.2357.030.37.60.L	6.00	0.30	23	8	2.70	5.70	0.30	37.00	62.00	6.00
6.010	GJ106.2357.030.42.60.L	6.00	0.30	23	8	2.70	5.70	0.30	42.00	67.00	6.00
6.011	GJ106.2357.030.47.60.L	6.00	0.30	23	8	2.70	5.70	0.30	47.00	72.00	6.00
6.012	GJ106.2357.030.52.60.L	6.00	0.30	23	8	2.70	5.70	0.30	52.00	77.00	6.00

System 106

**Cutting insert for back boring and profiling**

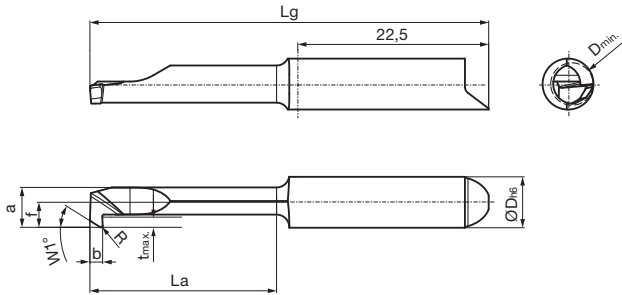


• radial free 32°

for tool holders type GH106/GB106 see from page 62

**GUHRING NAVIGATOR**

Cutting data page 184



Right hand version shown  
Left hand version mirror image

Tool material	Solid carbide		
	GT 106	GT 106	GT 106
Type	GT 106	GT 106	GT 106
Surface	<b>S</b>	<b>a</b>	○
	TiN	TiAlN-nanoA	bright



Article no. **25856**    **25858**    **25862**

Cutting direction

Code no.	Description	D min	R	W1	f	a	t max	La	Lg	D h6
		mm	mm	°	mm	mm	mm	mm	mm	mm
6.010	GT106.3247.020.12.50.R	5.00	0.20	32	2.95	4.70	1.20	12.00	37.00	6.00
6.020	GT106.3247.020.17.50.R	5.00	0.20	32	2.95	4.70	1.20	17.00	42.00	6.00
6.030	GT106.3247.020.22.50.R	5.00	0.20	32	2.95	4.70	1.20	22.00	47.00	6.00
6.040	GT106.3247.020.27.50.R	5.00	0.20	32	2.95	4.70	1.20	27.00	52.00	6.00
6.050	GT106.3247.020.32.50.R	5.00	0.20	32	2.95	4.70	1.20	32.00	57.00	6.00
6.060	GT106.3247.020.37.50.R	5.00	0.20	32	2.95	4.70	1.20	37.00	62.00	6.00
6.070	GT106.3247.020.42.50.R	5.00	0.20	32	2.95	4.70	1.20	42.00	67.00	6.00

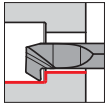
Article no. **25857**    **25859**    **25863**

Cutting direction

Code no.	Description	D min	R	W1	f	a	t max	La	Lg	D h6
		mm	mm	°	mm	mm	mm	mm	mm	mm
6.010	GT106.3247.020.12.50.L	5.00	0.20	32	2.95	4.70	1.20	12.00	37.00	6.00
6.020	GT106.3247.020.17.50.L	5.00	0.20	32	2.95	4.70	1.20	17.00	42.00	6.00
6.030	GT106.3247.020.22.50.L	5.00	0.20	32	2.95	4.70	1.20	22.00	47.00	6.00
6.040	GT106.3247.020.27.50.L	5.00	0.20	32	2.95	4.70	1.20	27.00	52.00	6.00
6.050	GT106.3247.020.32.50.L	5.00	0.20	32	2.95	4.70	1.20	32.00	57.00	6.00
6.060	GT106.3247.020.37.50.L	5.00	0.20	32	2.95	4.70	1.20	37.00	62.00	6.00
6.070	GT106.3247.020.42.50.L	5.00	0.20	32	2.95	4.70	1.20	42.00	67.00	6.00



**Cutting insert for back boring and profiling**

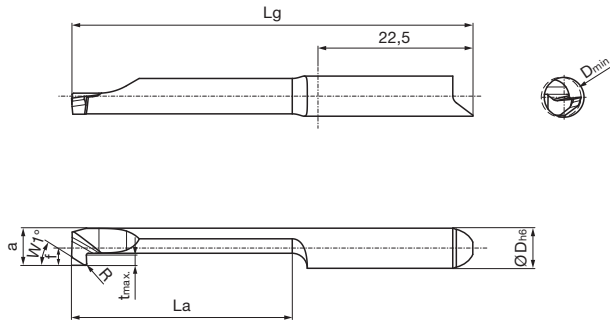


• radial free 32°

for tool holders type GH106/GB106 see from page 62

**GUHRING NAVIGATOR**

Cutting data page 184



Right hand version shown  
Left hand version mirror image

Tool material	Solid carbide		
Type	GT 106	GT 106	GT 106
Surface	<b>S</b>	<b>a</b>	○
	TiN	TiAlN-nanoA	bright



Article no. **25732**    **25734**    **25738**

Cutting direction **(R)**    **(R)**    **(R)**

Code no.	Description	D min	R	W1	f	a	t max	La	Lg	D h6
		mm	mm	°	mm	mm	mm	mm	mm	mm
6.001	GT106.3257.020.22.60.R	6.00	0.20	32	2.70	5.70	2.00	22.00	47.00	6.00
6.002	GT106.3257.020.32.60.R	6.00	0.20	32	2.70	5.70	2.00	32.00	57.00	6.00
6.003	GT106.3257.020.42.60.R	6.00	0.20	32	2.70	5.70	2.00	42.00	67.00	6.00
6.004	GT106.3257.020.52.60.R	6.00	0.20	32	2.70	5.70	2.00	52.00	77.00	6.00
6.013	GT106.3257.020.12.60.R	6.00	0.20	32	2.70	5.70	2.00	12.00	37.00	6.00
6.014	GT106.3257.020.17.60.R	6.00	0.20	32	2.70	5.70	2.00	17.00	42.00	6.00

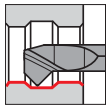
Article no. **25733**    **25735**    **25739**

Cutting direction **(L)**    **(L)**    **(L)**

Code no.	Description	D min	R	W1	f	a	t max	La	Lg	D h6
		mm	mm	°	mm	mm	mm	mm	mm	mm
6.001	GT106.3257.020.22.60.L	6.00	0.20	32	2.70	5.70	2.00	22.00	47.00	6.00
6.002	GT106.3257.020.32.60.L	6.00	0.20	32	2.70	5.70	2.00	32.00	57.00	6.00
6.003	GT106.3257.020.42.60.L	6.00	0.20	32	2.70	5.70	2.00	42.00	67.00	6.00
6.004	GT106.3257.020.52.60.L	6.00	0.20	32	2.70	5.70	2.00	52.00	77.00	6.00
6.013	GT106.3257.020.12.60.L	6.00	0.20	32	2.70	5.70	2.00	12.00	37.00	6.00
6.014	GT106.3257.020.17.60.L	6.00	0.20	32	2.70	5.70	2.00	17.00	42.00	6.00

System 106

Cutting insert for boring out and chamfering

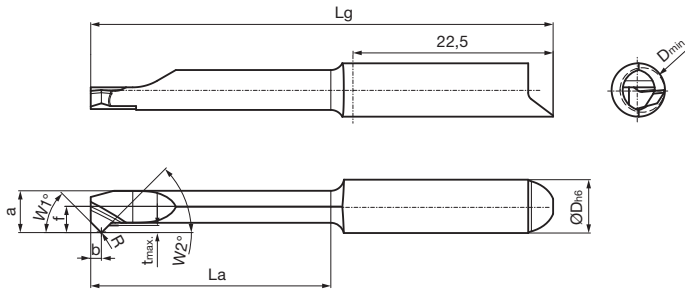


• 45° both sides

for tool holders type GH106/GB106 see from page 62

**GUHRING NAVIGATOR**

Cutting data page 184



Right hand version shown  
Left hand version mirror image

Article no. **25864** **25866** **25870**

Cutting direction

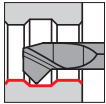
Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
6.010	GT106.4547.010.12.50.R	5.00	0.10	45	45	2.95	4.70	0.80	12.00	37.00	6.00
6.020	GT106.4547.010.17.50.R	5.00	0.10	45	45	2.95	4.70	0.80	17.00	42.00	6.00
6.030	GT106.4547.010.22.50.R	5.00	0.10	45	45	2.95	4.70	0.80	22.00	47.00	6.00
6.040	GT106.4547.010.27.50.R	5.00	0.10	45	45	2.95	4.70	0.80	27.00	52.00	6.00
6.050	GT106.4547.010.32.50.R	5.00	0.10	45	45	2.95	4.70	0.80	32.00	57.00	6.00
6.060	GT106.4547.010.37.50.R	5.00	0.10	45	45	2.95	4.70	0.80	37.00	62.00	6.00
6.070	GT106.4547.015.12.50.R	5.00	0.10	45	45	2.95	4.70	0.80	42.00	67.00	6.00
6.110	GT106.4547.015.12.50.R	5.00	0.15	45	45	2.95	4.70	0.80	12.00	37.00	6.00
6.120	GT106.4547.015.17.50.R	5.00	0.15	45	45	2.95	4.70	0.80	17.00	42.00	6.00
6.130	GT106.4547.015.22.50.R	5.00	0.15	45	45	2.95	4.70	0.80	22.00	47.00	6.00
6.140	GT106.4547.015.27.50.R	5.00	0.15	45	45	2.95	4.70	0.80	27.00	52.00	6.00
6.150	GT106.4547.015.32.50.R	5.00	0.15	45	45	2.95	4.70	0.80	32.00	57.00	6.00
6.160	GT106.4547.015.37.50.R	5.00	0.15	45	45	2.95	4.70	0.80	37.00	62.00	6.00
6.170	GT106.4547.015.42.50.R	5.00	0.15	45	45	2.95	4.70	0.80	42.00	67.00	6.00
6.210	GT106.4547.020.12.50.R	5.00	0.20	45	45	2.95	4.70	0.80	12.00	37.00	6.00
6.220	GT106.4547.020.17.50.R	5.00	0.20	45	45	2.95	4.70	0.80	17.00	42.00	6.00
6.230	GT106.4547.020.22.50.R	5.00	0.20	45	45	2.95	4.70	0.80	22.00	47.00	6.00
6.240	GT106.4547.020.27.50.R	5.00	0.20	45	45	2.95	4.70	0.80	27.00	52.00	6.00
6.250	GT106.4547.020.32.50.R	5.00	0.20	45	45	2.95	4.70	0.80	32.00	57.00	6.00
6.260	GT106.4547.020.37.50.R	5.00	0.20	45	45	2.95	4.70	0.80	37.00	62.00	6.00
6.270	GT106.4547.020.42.50.R	5.00	0.20	45	45	2.95	4.70	0.80	42.00	67.00	6.00
6.310	GT106.4547.030.12.50.R	5.00	0.30	45	45	2.95	4.70	0.80	12.00	37.00	6.00
6.320	GT106.4547.030.17.50.R	5.00	0.30	45	45	2.95	4.70	0.80	17.00	42.00	6.00
6.330	GT106.4547.030.22.50.R	5.00	0.30	45	45	2.95	4.70	0.80	22.00	47.00	6.00
6.340	GT106.4547.030.27.50.R	5.00	0.30	45	45	2.95	4.70	0.80	27.00	52.00	6.00
6.350	GT106.4547.030.32.50.R	5.00	0.30	45	45	2.95	4.70	0.80	32.00	57.00	6.00
6.360	GT106.4547.030.37.50.R	5.00	0.30	45	45	2.95	4.70	0.80	37.00	62.00	6.00
6.370	GT106.4547.030.42.50.R	5.00	0.30	45	45	2.95	4.70	0.80	42.00	67.00	6.00

Article no. **25865** **25867** **25871**Cutting direction   

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
6.010	GT106.4547.010.12.50.L	5.00	0.10	45	45	2.95	4.70	0.80	12.00	37.00	6.00
6.020	GT106.4547.010.17.50.L	5.00	0.10	45	45	2.95	4.70	0.80	17.00	42.00	6.00
6.030	GT106.4547.010.22.50.L	5.00	0.10	45	45	2.95	4.70	0.80	22.00	47.00	6.00
6.040	GT106.4547.010.27.50.L	5.00	0.10	45	45	2.95	4.70	0.80	27.00	52.00	6.00
6.050	GT106.4547.010.32.50.L	5.00	0.10	45	45	2.95	4.70	0.80	32.00	57.00	6.00
6.060	GT106.4547.010.37.50.L	5.00	0.10	45	45	2.95	4.70	0.80	37.00	62.00	6.00
6.070	GT106.4547.010.42.50.L	5.00	0.10	45	45	2.95	4.70	0.80	42.00	67.00	6.00
6.110	GT106.4547.015.12.50.L	5.00	0.15	45	45	2.95	4.70	0.80	12.00	37.00	6.00
6.120	GT106.4547.015.17.50.L	5.00	0.15	45	45	2.95	4.70	0.80	17.00	42.00	6.00
6.130	GT106.4547.015.22.50.L	5.00	0.15	45	45	2.95	4.70	0.80	22.00	47.00	6.00
6.140	GT106.4547.015.27.50.L	5.00	0.15	45	45	2.95	4.70	0.80	27.00	52.00	6.00
6.150	GT106.4547.015.32.50.L	5.00	0.15	45	45	2.95	4.70	0.80	32.00	57.00	6.00
6.160	GT106.4547.015.37.50.L	5.00	0.15	45	45	2.95	4.70	0.80	37.00	62.00	6.00
6.170	GT106.4547.015.42.50.L	5.00	0.15	45	45	2.95	4.70	0.80	42.00	67.00	6.00
6.210	GT106.4547.020.12.50.L	5.00	0.20	45	45	2.95	4.70	0.80	12.00	37.00	6.00
6.220	GT106.4547.020.17.50.L	5.00	0.20	45	45	2.95	4.70	0.80	17.00	42.00	6.00
6.230	GT106.4547.020.22.50.L	5.00	0.20	45	45	2.95	4.70	0.80	22.00	47.00	6.00
6.240	GT106.4547.020.27.50.L	5.00	0.20	45	45	2.95	4.70	0.80	27.00	52.00	6.00
6.250	GT106.4547.020.32.50.L	5.00	0.20	45	45	2.95	4.70	0.80	32.00	57.00	6.00
6.260	GT106.4547.020.37.50.L	5.00	0.20	45	45	2.95	4.70	0.80	37.00	62.00	6.00
6.270	GT106.4547.020.42.50.L	5.00	0.20	45	45	2.95	4.70	0.80	42.00	67.00	6.00
6.310	GT106.4547.030.12.50.L	5.00	0.30	45	45	2.95	4.70	0.80	12.00	37.00	6.00
6.320	GT106.4547.030.17.50.L	5.00	0.30	45	45	2.95	4.70	0.80	17.00	42.00	6.00
6.330	GT106.4547.030.22.50.L	5.00	0.30	45	45	2.95	4.70	0.80	22.00	47.00	6.00
6.340	GT106.4547.030.27.50.L	5.00	0.30	45	45	2.95	4.70	0.80	27.00	52.00	6.00
6.350	GT106.4547.030.32.50.L	5.00	0.30	45	45	2.95	4.70	0.80	32.00	57.00	6.00
6.360	GT106.4547.030.37.50.L	5.00	0.30	45	45	2.95	4.70	0.80	37.00	62.00	6.00
6.370	GT106.4547.030.42.50.L	5.00	0.30	45	45	2.95	4.70	0.80	42.00	67.00	6.00

System 106

**Cutting insert for boring out and chamfering**



• 45° both sides

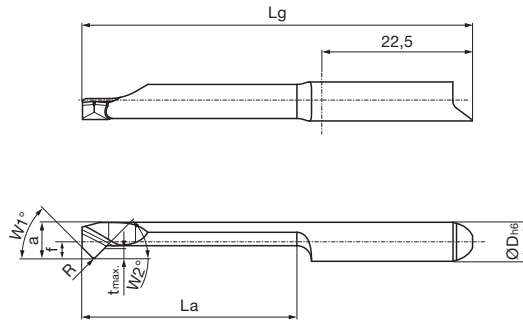
for tool holders type GH106/GB106 see from page 62

**GUHRING NAVIGATOR**

Cutting data page 184

Tool material	Solid carbide		
	GT 106	GT 106	GT 106
Type	GT 106	GT 106	GT 106
Surface	<b>S</b> TiN	<b>a</b> TiAlN-nanoA	○ bright

System 106



Right hand version shown  
Left hand version mirror image

Article no. **25740** **25742** **25746**

Cutting direction **(R)** **(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
6.019	GT106.4557.010.12.60.R	6.00	0.10	45	45	2.70	5.70	1.00	12.00	37.00	6.00
6.020	GT106.4557.010.17.60.R	6.00	0.10	45	45	2.70	5.70	1.00	17.00	42.00	6.00
6.021	GT106.4557.010.22.60.R	6.00	0.10	45	45	2.70	5.70	1.00	22.00	47.00	6.00
6.022	GT106.4557.010.27.60.R	6.00	0.10	45	45	2.70	5.70	1.00	27.00	52.00	6.00
6.023	GT106.4557.010.32.60.R	6.00	0.10	45	45	2.70	5.70	1.00	32.00	57.00	6.00
6.024	GT106.4557.010.37.60.R	6.00	0.10	45	45	2.70	5.70	1.00	37.00	62.00	6.00
6.025	GT106.4557.010.42.60.R	6.00	0.10	45	45	2.70	5.70	1.00	42.00	67.00	6.00
6.026	GT106.4557.010.47.60.R	6.00	0.10	45	45	2.70	5.70	1.00	47.00	72.00	6.00
6.027	GT106.4557.010.52.60.R	6.00	0.10	45	45	2.70	5.70	1.00	52.00	77.00	6.00
6.013	GT106.4557.015.12.60.R	6.00	0.15	45	45	2.70	5.70	1.00	12.00	37.00	6.00
6.014	GT106.4557.015.17.60.R	6.00	0.15	45	45	2.70	5.70	1.00	17.00	42.00	6.00
6.015	GT106.4557.015.22.60.R	6.00	0.15	45	45	2.70	5.70	1.00	22.00	47.00	6.00
6.001	GT106.4557.015.27.60.R	6.00	0.15	45	45	2.70	5.70	1.00	27.00	52.00	6.00
6.002	GT106.4557.015.32.60.R	6.00	0.15	45	45	2.70	5.70	1.00	32.00	57.00	6.00
6.003	GT106.4557.015.37.60.R	6.00	0.15	45	45	2.70	5.70	1.00	37.00	62.00	6.00
6.004	GT106.4557.015.42.60.R	6.00	0.15	45	45	2.70	5.70	1.00	42.00	67.00	6.00
6.005	GT106.4557.015.47.60.R	6.00	0.15	45	45	2.70	5.70	1.00	47.00	72.00	6.00
6.006	GT106.4557.015.52.60.R	6.00	0.15	45	45	2.70	5.70	1.00	52.00	77.00	6.00
6.028	GT106.4557.020.12.60.R	6.00	0.20	45	45	2.70	5.70	1.00	12.00	37.00	6.00
6.029	GT106.4557.020.17.60.R	6.00	0.20	45	45	2.70	5.70	1.00	17.00	42.00	6.00
6.030	GT106.4557.020.22.60.R	6.00	0.20	45	45	2.70	5.70	1.00	22.00	47.00	6.00
6.031	GT106.4557.020.27.60.R	6.00	0.20	45	45	2.70	5.70	1.00	27.00	52.00	6.00
6.032	GT106.4557.020.32.60.R	6.00	0.20	45	45	2.70	5.70	1.00	32.00	57.00	6.00
6.033	GT106.4557.020.37.60.R	6.00	0.20	45	45	2.70	5.70	1.00	37.00	62.00	6.00
6.034	GT106.4557.020.42.60.R	6.00	0.20	45	45	2.70	5.70	1.00	42.00	67.00	6.00
6.035	GT106.4557.020.47.60.R	6.00	0.20	45	45	2.70	5.70	1.00	47.00	72.00	6.00
6.036	GT106.4557.020.52.60.R	6.00	0.20	45	45	2.70	5.70	1.00	52.00	77.00	6.00
6.016	GT106.4557.030.12.60.R	6.00	0.30	45	45	2.70	5.70	1.00	12.00	37.00	6.00
6.017	GT106.4557.030.17.60.R	6.00	0.30	45	45	2.70	5.70	1.00	17.00	42.00	6.00
6.018	GT106.4557.030.22.60.R	6.00	0.30	45	45	2.70	5.70	1.00	22.00	47.00	6.00
6.007	GT106.4557.030.27.60.R	6.00	0.30	45	45	2.70	5.70	1.00	27.00	52.00	6.00
6.008	GT106.4557.030.32.60.R	6.00	0.30	45	45	2.70	5.70	1.00	32.00	57.00	6.00
6.009	GT106.4557.030.37.60.R	6.00	0.30	45	45	2.70	5.70	1.00	37.00	62.00	6.00
6.010	GT106.4557.030.42.60.R	6.00	0.30	45	45	2.70	5.70	1.00	42.00	67.00	6.00
6.011	GT106.4557.030.47.60.R	6.00	0.30	45	45	2.70	5.70	1.00	47.00	72.00	6.00
6.012	GT106.4557.030.52.60.R	6.00	0.30	45	45	2.70	5.70	1.00	52.00	77.00	6.00

Article no. **25741** **25743** **25747**Cutting direction   

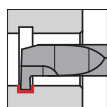
Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
6.019	GT106.4557.010.12.60.L	6.00	0.10	45	45	2.70	5.70	1.00	12.00	37.00	6.00
6.020	GT106.4557.010.17.60.L	6.00	0.10	45	45	2.70	5.70	1.00	17.00	42.00	6.00
6.021	GT106.4557.010.22.60.L	6.00	0.10	45	45	2.70	5.70	1.00	22.00	47.00	6.00
6.022	GT106.4557.010.27.60.L	6.00	0.10	45	45	2.70	5.70	1.00	27.00	52.00	6.00
6.023	GT106.4557.010.32.60.L	6.00	0.10	45	45	2.70	5.70	1.00	32.00	57.00	6.00
6.024	GT106.4557.010.37.60.L	6.00	0.10	45	45	2.70	5.70	1.00	37.00	62.00	6.00
6.025	GT106.4557.010.42.60.L	6.00	0.10	45	45	2.70	5.70	1.00	42.00	67.00	6.00
6.026	GT106.4557.010.47.60.L	6.00	0.10	45	45	2.70	5.70	1.00	47.00	72.00	6.00
6.027	GT106.4557.010.52.60.L	6.00	0.10	45	45	2.70	5.70	1.00	52.00	77.00	6.00
6.013	GT106.4557.015.12.60.L	6.00	0.15	45	45	2.70	5.70	1.00	12.00	37.00	6.00
6.014	GT106.4557.015.17.60.L	6.00	0.15	45	45	2.70	5.70	1.00	17.00	42.00	6.00
6.015	GT106.4557.015.22.60.L	6.00	0.15	45	45	2.70	5.70	1.00	22.00	47.00	6.00
6.001	GT106.4557.015.27.60.L	6.00	0.15	45	45	2.70	5.70	1.00	27.00	52.00	6.00
6.002	GT106.4557.015.32.60.L	6.00	0.15	45	45	2.70	5.70	1.00	32.00	57.00	6.00
6.003	GT106.4557.015.37.60.L	6.00	0.15	45	45	2.70	5.70	1.00	37.00	62.00	6.00
6.004	GT106.4557.015.42.60.L	6.00	0.15	45	45	2.70	5.70	1.00	42.00	67.00	6.00
6.005	GT106.4557.015.47.60.L	6.00	0.15	45	45	2.70	5.70	1.00	47.00	72.00	6.00
6.006	GT106.4557.015.52.60.L	6.00	0.15	45	45	2.70	5.70	1.00	52.00	77.00	6.00
6.028	GT106.4557.020.12.60.L	6.00	0.20	45	45	2.70	5.70	1.00	12.00	37.00	6.00
6.029	GT106.4557.020.17.60.L	6.00	0.20	45	45	2.70	5.70	1.00	17.00	42.00	6.00
6.030	GT106.4557.020.22.60.L	6.00	0.20	45	45	2.70	5.70	1.00	22.00	47.00	6.00
6.031	GT106.4557.020.27.60.L	6.00	0.20	45	45	2.70	5.70	1.00	27.00	52.00	6.00
6.032	GT106.4557.020.32.60.L	6.00	0.20	45	45	2.70	5.70	1.00	32.00	57.00	6.00
6.033	GT106.4557.020.37.60.L	6.00	0.20	45	45	2.70	5.70	1.00	37.00	62.00	6.00
6.034	GT106.4557.020.42.60.L	6.00	0.20	45	45	2.70	5.70	1.00	42.00	67.00	6.00
6.035	GT106.4557.020.47.60.L	6.00	0.20	45	45	2.70	5.70	1.00	47.00	72.00	6.00
6.036	GT106.4557.020.52.60.L	6.00	0.20	45	45	2.70	5.70	1.00	52.00	77.00	6.00
6.016	GT106.4557.030.12.60.L	6.00	0.30	45	45	2.70	5.70	1.00	12.00	37.00	6.00
6.017	GT106.4557.030.17.60.L	6.00	0.30	45	45	2.70	5.70	1.00	17.00	42.00	6.00
6.018	GT106.4557.030.22.60.L	6.00	0.30	45	45	2.70	5.70	1.00	22.00	47.00	6.00
6.007	GT106.4557.030.27.60.L	6.00	0.30	45	45	2.70	5.70	1.00	27.00	52.00	6.00
6.008	GT106.4557.030.32.60.L	6.00	0.30	45	45	2.70	5.70	1.00	32.00	57.00	6.00
6.009	GT106.4557.030.37.60.L	6.00	0.30	45	45	2.70	5.70	1.00	37.00	62.00	6.00
6.010	GT106.4557.030.42.60.L	6.00	0.30	45	45	2.70	5.70	1.00	42.00	67.00	6.00
6.011	GT106.4557.030.47.60.L	6.00	0.30	45	45	2.70	5.70	1.00	47.00	72.00	6.00
6.012	GT106.4557.030.52.60.L	6.00	0.30	45	45	2.70	5.70	1.00	52.00	77.00	6.00

System 106





**Cutting insert for internal grooving, straight slots**



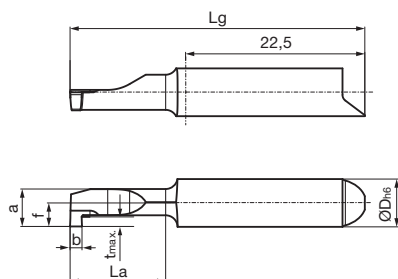
- grooving depth up to 1.2 mm

for tool holders type GH106/GB106 see from page 62

**GUHRING NAVIGATOR**

Cutting data page 184

System 106



Right hand version shown  
Left hand version mirror image

Article no. **25872** **25874** **25878**

Cutting direction

Code no.	Description	D min	b	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
6.010	GE106.0100.000.12.50.R	5.00	1.00	2.95	4.70	1.20	12.00	37.00	6.00
6.020	GE106.0100.000.17.50.R	5.00	1.00	2.95	4.70	1.20	17.00	42.00	6.00
6.030	GE106.0100.000.22.50.R	5.00	1.00	2.95	4.70	1.20	22.00	47.00	6.00
6.040	GE106.0100.000.27.50.R	5.00	1.00	2.95	4.70	1.20	27.00	52.00	6.00
6.050	GE106.0100.000.32.50.R	5.00	1.00	2.95	4.70	1.20	32.00	57.00	6.00
6.060	GE106.0100.000.37.50.R	5.00	1.00	2.95	4.70	1.20	37.00	62.00	6.00
6.070	GE106.0100.000.42.50.R	5.00	1.00	2.95	4.70	1.20	42.00	67.00	6.00
6.110	GE106.0150.000.12.50.R	5.00	1.50	2.95	4.70	1.20	12.00	37.00	6.00
6.120	GE106.0150.000.17.50.R	5.00	1.50	2.95	4.70	1.20	17.00	42.00	6.00
6.130	GE106.0150.000.22.50.R	5.00	1.50	2.95	4.70	1.20	22.00	47.00	6.00
6.140	GE106.0150.000.27.50.R	5.00	1.50	2.95	4.70	1.20	27.00	52.00	6.00
6.150	GE106.0150.000.32.50.R	5.00	1.50	2.95	4.70	1.20	32.00	57.00	6.00
6.160	GE106.0150.000.37.50.R	5.00	1.50	2.95	4.70	1.20	37.00	62.00	6.00
6.170	GE106.0150.000.42.50.R	5.00	1.50	2.95	4.70	1.20	42.00	67.00	6.00
6.210	GE106.0200.000.12.50.R	5.00	2.00	2.95	4.70	1.20	12.00	37.00	6.00
6.220	GE106.0200.000.17.50.R	5.00	2.00	2.95	4.70	1.20	17.00	42.00	6.00
6.230	GE106.0200.000.22.50.R	5.00	2.00	2.95	4.70	1.20	22.00	47.00	6.00
6.240	GE106.0200.000.27.50.R	5.00	2.00	2.95	4.70	1.20	27.00	52.00	6.00
6.250	GE106.0200.000.32.50.R	5.00	2.00	2.95	4.70	1.20	32.00	57.00	6.00
6.260	GE106.0200.000.37.50.R	5.00	2.00	2.95	4.70	1.20	37.00	62.00	6.00
6.270	GE106.0200.000.42.50.R	5.00	2.00	2.95	4.70	1.20	42.00	67.00	6.00

Article no. **25873** **25875** **25879**

Cutting direction

Code no.	Description	D min	b	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
6.010	GE106.0100.000.12.50.L	5.00	1.00	2.95	4.70	1.20	12.00	37.00	6.00
6.020	GE106.0100.000.17.50.L	5.00	1.00	2.95	4.70	1.20	17.00	42.00	6.00
6.030	GE106.0100.000.22.50.L	5.00	1.00	2.95	4.70	1.20	22.00	47.00	6.00
6.040	GE106.0100.000.27.50.L	5.00	1.00	2.95	4.70	1.20	27.00	52.00	6.00
6.050	GE106.0100.000.32.50.L	5.00	1.00	2.95	4.70	1.20	32.00	57.00	6.00
6.060	GE106.0100.000.37.50.L	5.00	1.00	2.95	4.70	1.20	37.00	62.00	6.00

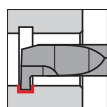
Article no. **25873** **25875** **25879**Cutting direction   

Code no.	Description	D min	b	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
6.070	GE106.0100.000.42.50.L	5.00	1.00	2.95	4.70	1.20	42.00	67.00	6.00
6.110	GE106.0150.000.12.50.L	5.00	1.50	2.95	4.70	1.20	12.00	37.00	6.00
6.120	GE106.0150.000.17.50.L	5.00	1.50	2.95	4.70	1.20	17.00	42.00	6.00
6.130	GE106.0150.000.22.50.L	5.00	1.50	2.95	4.70	1.20	22.00	47.00	6.00
6.140	GE106.0150.000.27.50.L	5.00	1.50	2.95	4.70	1.20	27.00	52.00	6.00
6.150	GE106.0150.000.32.50.L	5.00	1.50	2.95	4.70	1.20	32.00	57.00	6.00
6.160	GE106.0150.000.37.50.L	5.00	1.50	2.95	4.70	1.20	37.00	62.00	6.00
6.170	GE106.0150.000.42.50.L	5.00	1.50	2.95	4.70	1.20	42.00	67.00	6.00
6.210	GE106.0200.000.12.50.L	5.00	2.00	2.95	4.70	1.20	12.00	37.00	6.00
6.220	GE106.0200.000.17.50.L	5.00	2.00	2.95	4.70	1.20	17.00	42.00	6.00
6.230	GE106.0200.000.22.50.L	5.00	2.00	2.95	4.70	1.20	22.00	47.00	6.00
6.240	GE106.0200.000.27.50.L	5.00	2.00	2.95	4.70	1.20	27.00	52.00	6.00
6.250	GE106.0200.000.32.50.L	5.00	2.00	2.95	4.70	1.20	32.00	57.00	6.00
6.260	GE106.0200.000.37.50.L	5.00	2.00	2.95	4.70	1.20	37.00	62.00	6.00
6.270	GE106.0200.000.42.50.L	5.00	2.00	2.95	4.70	1.20	42.00	67.00	6.00

System 106



**Cutting insert for internal grooving, straight slots**

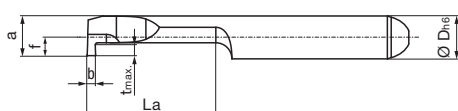
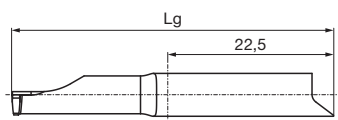


- grooving depth up to 2 mm

for tool holders type GH106/GB106 see from page 62

**GUHRING NAVIGATOR**

Cutting data page 184



Right hand version shown  
Left hand version mirror image

Tool material	Solid carbide		
Type	GE 106	GE 106	GE 106
Surface	<b>S</b>	<b>a</b>	○
	TiN	TiAlN-nanoA	bright



Article no. **25748**    **25750**    **25754**

Cutting direction **(R)**    **(R)**    **(R)**

Code no.	Description	D min	b	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
6.001	GE106.0100.000.12.60.R	6.00	1.00	2.70	5.70	2.00	12.00	37.00	6.00
6.002	GE106.0100.000.17.60.R	6.00	1.00	2.70	5.70	2.00	17.00	42.00	6.00
6.003	GE106.0100.000.22.60.R	6.00	1.00	2.70	5.70	2.00	22.00	47.00	6.00
6.004	GE106.0100.000.27.60.R	6.00	1.00	2.70	5.70	2.00	27.00	52.00	6.00
6.005	GE106.0100.000.32.60.R	6.00	1.00	2.70	5.70	2.00	32.00	57.00	6.00
6.006	GE106.0100.000.37.60.R	6.00	1.00	2.70	5.70	2.00	37.00	62.00	6.00
6.007	GE106.0100.000.42.60.R	6.00	1.00	2.70	5.70	2.00	42.00	67.00	6.00
6.008	GE106.0150.000.12.60.R	6.00	1.50	2.70	5.70	2.00	12.00	37.00	6.00
6.009	GE106.0150.000.17.60.R	6.00	1.50	2.70	5.70	2.00	17.00	42.00	6.00
6.010	GE106.0150.000.22.60.R	6.00	1.50	2.70	5.70	2.00	22.00	47.00	6.00
6.011	GE106.0150.000.27.60.R	6.00	1.50	2.70	5.70	2.00	27.00	52.00	6.00
6.012	GE106.0150.000.32.60.R	6.00	1.50	2.70	5.70	2.00	32.00	57.00	6.00
6.013	GE106.0150.000.37.60.R	6.00	1.50	2.70	5.70	2.00	37.00	62.00	6.00
6.014	GE106.0150.000.42.60.R	6.00	1.50	2.70	5.70	2.00	42.00	67.00	6.00
6.015	GE106.0200.000.12.60.R	6.00	2.00	2.70	5.70	2.00	12.00	37.00	6.00
6.016	GE106.0200.000.17.60.R	6.00	2.00	2.70	5.70	2.00	17.00	42.00	6.00
6.017	GE106.0200.000.22.60.R	6.00	2.00	2.70	5.70	2.00	22.00	47.00	6.00
6.018	GE106.0200.000.27.60.R	6.00	2.00	2.70	5.70	2.00	27.00	52.00	6.00
6.019	GE106.0200.000.32.60.R	6.00	2.00	2.70	5.70	2.00	32.00	57.00	6.00
6.020	GE106.0200.000.37.60.R	6.00	2.00	2.70	5.70	2.00	37.00	62.00	6.00
6.021	GE106.0200.000.42.60.R	6.00	2.00	2.70	5.70	2.00	42.00	67.00	6.00

Article no. **25749**    **25751**    **25755**

Cutting direction **(L)**    **(L)**    **(L)**

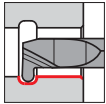
Code no.	Description	D min	b	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
6.001	GE106.0100.000.12.60.L	6.00	1.00	2.70	5.70	2.00	12.00	37.00	6.00
6.002	GE106.0100.000.17.60.L	6.00	1.00	2.70	5.70	2.00	17.00	42.00	6.00
6.003	GE106.0100.000.22.60.L	6.00	1.00	2.70	5.70	2.00	22.00	47.00	6.00
6.004	GE106.0100.000.27.60.L	6.00	1.00	2.70	5.70	2.00	27.00	52.00	6.00
6.005	GE106.0100.000.32.60.L	6.00	1.00	2.70	5.70	2.00	32.00	57.00	6.00
6.006	GE106.0100.000.37.60.L	6.00	1.00	2.70	5.70	2.00	37.00	62.00	6.00

Article no. **25749** **25751** **25755**Cutting direction   

Code no.	Description	D min	b	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
6.007	GE106.0100.000.42.60.L	6.00	1.00	2.70	5.70	2.00	42.00	67.00	6.00
6.008	GE106.0150.000.12.60.L	6.00	1.50	2.70	5.70	2.00	12.00	37.00	6.00
6.009	GE106.0150.000.17.60.L	6.00	1.50	2.70	5.70	2.00	17.00	42.00	6.00
6.010	GE106.0150.000.22.60.L	6.00	1.50	2.70	5.70	2.00	22.00	47.00	6.00
6.011	GE106.0150.000.27.60.L	6.00	1.50	2.70	5.70	2.00	27.00	52.00	6.00
6.012	GE106.0150.000.32.60.L	6.00	1.50	2.70	5.70	2.00	32.00	57.00	6.00
6.013	GE106.0150.000.37.60.L	6.00	1.50	2.70	5.70	2.00	37.00	62.00	6.00
6.014	GE106.0150.000.42.60.L	6.00	1.50	2.70	5.70	2.00	42.00	67.00	6.00
6.015	GE106.0200.000.12.60.L	6.00	2.00	2.70	5.70	2.00	12.00	37.00	6.00
6.016	GE106.0200.000.17.60.L	6.00	2.00	2.70	5.70	2.00	17.00	42.00	6.00
6.017	GE106.0200.000.22.60.L	6.00	2.00	2.70	5.70	2.00	22.00	47.00	6.00
6.018	GE106.0200.000.27.60.L	6.00	2.00	2.70	5.70	2.00	27.00	52.00	6.00
6.019	GE106.0200.000.32.60.L	6.00	2.00	2.70	5.70	2.00	32.00	57.00	6.00
6.020	GE106.0200.000.37.60.L	6.00	2.00	2.70	5.70	2.00	37.00	62.00	6.00
6.021	GE106.0200.000.42.60.L	6.00	2.00	2.70	5.70	2.00	42.00	67.00	6.00

System 106

Cutting insert for internal grooving, full radius slots



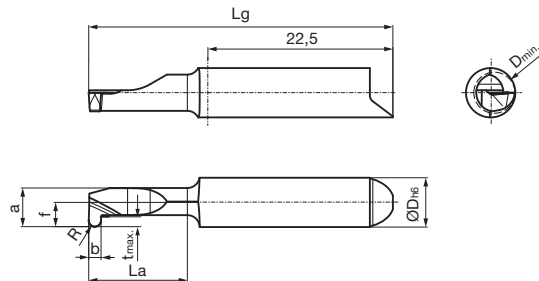
• full radius R0.5-R1.0

for tool holders type GH106/GB106 see from page 62

**GUHRING NAVIGATOR**

Cutting data page 184

System 106



Right hand version shown  
Left hand version mirror image

Tool material	Solid carbide		
	GE 106	GE 106	GE 106
Type	GE 106	GE 106	GE 106
Surface	<b>S</b>	<b>a</b>	○
	TiN	TiAlN-nanoA	bright



Article no. **25880** **25882** **25886**

Cutting direction

Code no.	Description	D min	b	R	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm	mm
6.010	GE106.0100.050.12.50.R	5.00	1.00	0.50	2.95	4.70	1.20	12.00	37.00	6.00
6.020	GE106.0100.050.17.50.R	5.00	1.00	0.50	2.95	4.70	1.20	17.00	42.00	6.00
6.030	GE106.0100.050.22.50.R	5.00	1.00	0.50	2.95	4.70	1.20	22.00	47.00	6.00
6.040	GE106.0100.050.27.50.R	5.00	1.00	0.50	2.95	4.70	1.20	27.00	52.00	6.00
6.050	GE106.0100.050.32.50.R	5.00	1.00	0.50	2.95	4.70	1.20	32.00	57.00	6.00
6.060	GE106.0100.050.37.50.R	5.00	1.00	0.50	2.95	4.70	1.20	37.00	62.00	6.00
6.070	GE106.0100.050.42.50.R	5.00	1.00	0.50	2.95	4.70	1.20	42.00	67.00	6.00
6.110	GE106.0150.075.12.50.R	5.00	1.50	0.75	2.95	4.70	1.20	12.00	37.00	6.00
6.120	GE106.0150.075.17.50.R	5.00	1.50	0.75	2.95	4.70	1.20	17.00	42.00	6.00
6.130	GE106.0150.075.22.50.R	5.00	1.50	0.75	2.95	4.70	1.20	22.00	47.00	6.00
6.140	GE106.0150.075.27.50.R	5.00	1.50	0.75	2.95	4.70	1.20	27.00	52.00	6.00
6.150	GE106.0150.075.32.50.R	5.00	1.50	0.75	2.95	4.70	1.20	32.00	57.00	6.00
6.160	GE106.0150.075.37.50.R	5.00	1.50	0.75	2.95	4.70	1.20	37.00	62.00	6.00
6.170	GE106.0150.075.42.50.R	5.00	1.50	0.75	2.95	4.70	1.20	42.00	67.00	6.00
6.210	GE106.0200.100.12.50.R	5.00	2.00	1.00	2.95	4.70	1.20	12.00	37.00	6.00
6.220	GE106.0200.100.17.50.R	5.00	2.00	1.00	2.95	4.70	1.20	17.00	42.00	6.00
6.230	GE106.0200.100.22.50.R	5.00	2.00	1.00	2.95	4.70	1.20	22.00	47.00	6.00
6.240	GE106.0200.100.27.50.R	5.00	2.00	1.00	2.95	4.70	1.20	27.00	52.00	6.00
6.250	GE106.0200.100.32.50.R	5.00	2.00	1.00	2.95	4.70	1.20	32.00	57.00	6.00
6.260	GE106.0200.100.37.50.R	5.00	2.00	1.00	2.95	4.70	1.20	37.00	62.00	6.00
6.270	GE106.0200.100.42.50.R	5.00	2.00	1.00	2.95	4.70	1.20	42.00	67.00	6.00

Article no. **25881** **25883** **25887**

Cutting direction

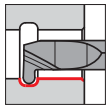
Code no.	Description	D min	b	R	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm	mm
6.010	GE106.0100.050.12.50.L	5.00	1.00	0.50	2.95	4.70	1.20	12.00	37.00	6.00
6.020	GE106.0100.050.17.50.L	5.00	1.00	0.50	2.95	4.70	1.20	17.00	42.00	6.00
6.030	GE106.0100.050.22.50.L	5.00	1.00	0.50	2.95	4.70	1.20	22.00	47.00	6.00
6.040	GE106.0100.050.27.50.L	5.00	1.00	0.50	2.95	4.70	1.20	27.00	52.00	6.00
6.050	GE106.0100.050.32.50.L	5.00	1.00	0.50	2.95	4.70	1.20	32.00	57.00	6.00
6.060	GE106.0100.050.37.50.L	5.00	1.00	0.50	2.95	4.70	1.20	37.00	62.00	6.00

Article no. **25881** **25883** **25887**Cutting direction   

Code no.	Description	D min	b	R	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm	mm
6.070	GE106.0100.050.42.50.L	5.00	1.00	0.50	2.95	4.70	1.20	42.00	67.00	6.00
6.110	GE106.0150.075.12.50.L	5.00	1.50	0.75	2.95	4.70	1.20	12.00	37.00	6.00
6.120	GE106.0150.075.17.50.L	5.00	1.50	0.75	2.95	4.70	1.20	17.00	42.00	6.00
6.130	GE106.0150.075.22.50.L	5.00	1.50	0.75	2.95	4.70	1.20	22.00	47.00	6.00
6.140	GE106.0150.075.27.50.L	5.00	1.50	0.75	2.95	4.70	1.20	27.00	52.00	6.00
6.150	GE106.0150.075.32.50.L	5.00	1.50	0.75	2.95	4.70	1.20	32.00	57.00	6.00
6.160	GE106.0150.075.37.50.L	5.00	1.50	0.75	2.95	4.70	1.20	37.00	62.00	6.00
6.170	GE106.0150.075.42.50.L	5.00	1.50	0.75	2.95	4.70	1.20	42.00	67.00	6.00
6.210	GE106.0200.100.12.50.L	5.00	2.00	1.00	2.95	4.70	1.20	12.00	37.00	6.00
6.220	GE106.0200.100.17.50.L	5.00	2.00	1.00	2.95	4.70	1.20	17.00	42.00	6.00
6.230	GE106.0200.100.22.50.L	5.00	2.00	1.00	2.95	4.70	1.20	22.00	47.00	6.00
6.240	GE106.0200.100.27.50.L	5.00	2.00	1.00	2.95	4.70	1.20	27.00	52.00	6.00
6.250	GE106.0200.100.32.50.L	5.00	2.00	1.00	2.95	4.70	1.20	32.00	57.00	6.00
6.260	GE106.0200.100.37.50.L	5.00	2.00	1.00	2.95	4.70	1.20	37.00	62.00	6.00
6.270	GE106.0200.100.42.50.L	5.00	2.00	1.00	2.95	4.70	1.20	42.00	67.00	6.00

System 106

Cutting insert for internal grooving, full radius slots

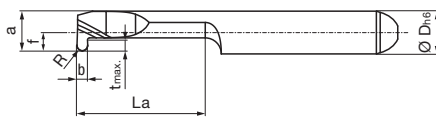
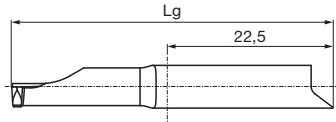


• full radius R0.5-R1.0

for tool holders type GH106/GB106 see from page 62

**GUHRING NAVIGATOR**

Cutting data page 184



Right hand version shown  
Left hand version mirror image



Article no. **25756** **25758** **25762**

Cutting direction

Code no.	Description	D min	b	R	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm	mm
6.001	GE106.0100.050.12.60.R	6.00	1.00	0.50	2.70	5.70	2.00	12.00	37.00	6.00
6.002	GE106.0100.050.17.60.R	6.00	1.00	0.50	2.70	5.70	2.00	17.00	42.00	6.00
6.003	GE106.0100.050.22.60.R	6.00	1.00	0.50	2.70	5.70	2.00	22.00	47.00	6.00
6.004	GE106.0100.050.27.60.R	6.00	1.00	0.50	2.70	5.70	2.00	27.00	52.00	6.00
6.005	GE106.0100.050.32.60.R	6.00	1.00	0.50	2.70	5.70	2.00	32.00	57.00	6.00
6.006	GE106.0100.050.37.60.R	6.00	1.00	0.50	2.70	5.70	2.00	37.00	62.00	6.00
6.007	GE106.0100.050.42.60.R	6.00	1.00	0.50	2.70	5.70	2.00	42.00	67.00	6.00
6.008	GE106.0150.075.12.60.R	6.00	1.50	0.75	2.70	5.70	2.00	12.00	37.00	6.00
6.009	GE106.0150.075.17.60.R	6.00	1.50	0.75	2.70	5.70	2.00	17.00	42.00	6.00
6.010	GE106.0150.075.22.60.R	6.00	1.50	0.75	2.70	5.70	2.00	22.00	47.00	6.00
6.011	GE106.0150.075.27.60.R	6.00	1.50	0.75	2.70	5.70	2.00	27.00	52.00	6.00
6.012	GE106.0150.075.32.60.R	6.00	1.50	0.75	2.70	5.70	2.00	32.00	57.00	6.00
6.013	GE106.0150.075.37.60.R	6.00	1.50	0.75	2.70	5.70	2.00	37.00	62.00	6.00
6.014	GE106.0150.075.42.60.R	6.00	1.50	0.75	2.70	5.70	2.00	42.00	67.00	6.00
6.015	GE106.0200.100.12.60.R	6.00	2.00	1.00	2.70	5.70	2.00	12.00	37.00	6.00
6.016	GE106.0200.100.17.60.R	6.00	2.00	1.00	2.70	5.70	2.00	17.00	42.00	6.00
6.017	GE106.0200.100.22.60.R	6.00	2.00	1.00	2.70	5.70	2.00	22.00	47.00	6.00
6.018	GE106.0200.100.27.60.R	6.00	2.00	1.00	2.70	5.70	2.00	27.00	52.00	6.00
6.019	GE106.0200.100.32.60.R	6.00	2.00	1.00	2.70	5.70	2.00	32.00	57.00	6.00
6.020	GE106.0200.100.37.60.R	6.00	2.00	1.00	2.70	5.70	2.00	37.00	62.00	6.00
6.021	GE106.0200.100.42.60.R	6.00	2.00	1.00	2.70	5.70	2.00	42.00	67.00	6.00

Article no. **25757** **25759** **25763**

Cutting direction

Code no.	Description	D min	b	R	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm	mm
6.001	GE106.0100.050.12.60.L	6.00	1.00	0.50	2.70	5.70	2.00	12.00	37.00	6.00
6.002	GE106.0100.050.17.60.L	6.00	1.00	0.50	2.70	5.70	2.00	17.00	42.00	6.00
6.003	GE106.0100.050.22.60.L	6.00	1.00	0.50	2.70	5.70	2.00	22.00	47.00	6.00
6.004	GE106.0100.050.27.60.L	6.00	1.00	0.50	2.70	5.70	2.00	27.00	52.00	6.00
6.005	GE106.0100.050.32.60.L	6.00	1.00	0.50	2.70	5.70	2.00	32.00	57.00	6.00
6.006	GE106.0100.050.37.60.L	6.00	1.00	0.50	2.70	5.70	2.00	37.00	62.00	6.00

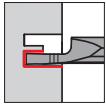
Article no. **25757** **25759** **25763**Cutting direction   

Code no.	Description	D min	b	R	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm	mm
6.007	GE106.0100.050.42.60.L	6.00	1.00	0.50	2.70	5.70	2.00	42.00	67.00	6.00
6.008	GE106.0150.075.12.60.L	6.00	1.50	0.75	2.70	5.70	2.00	12.00	37.00	6.00
6.009	GE106.0150.075.17.60.L	6.00	1.50	0.75	2.70	5.70	2.00	17.00	42.00	6.00
6.010	GE106.0150.075.22.60.L	6.00	1.50	0.75	2.70	5.70	2.00	22.00	47.00	6.00
6.011	GE106.0150.075.27.60.L	6.00	1.50	0.75	2.70	5.70	2.00	27.00	52.00	6.00
6.012	GE106.0150.075.32.60.L	6.00	1.50	0.75	2.70	5.70	2.00	32.00	57.00	6.00
6.013	GE106.0150.075.37.60.L	6.00	1.50	0.75	2.70	5.70	2.00	37.00	62.00	6.00
6.014	GE106.0150.075.42.60.L	6.00	1.50	0.75	2.70	5.70	2.00	42.00	67.00	6.00
6.015	GE106.0200.100.12.60.L	6.00	2.00	1.00	2.70	5.70	2.00	12.00	37.00	6.00
6.016	GE106.0200.100.17.60.L	6.00	2.00	1.00	2.70	5.70	2.00	17.00	42.00	6.00
6.017	GE106.0200.100.22.60.L	6.00	2.00	1.00	2.70	5.70	2.00	22.00	47.00	6.00
6.018	GE106.0200.100.27.60.L	6.00	2.00	1.00	2.70	5.70	2.00	27.00	52.00	6.00
6.019	GE106.0200.100.32.60.L	6.00	2.00	1.00	2.70	5.70	2.00	32.00	57.00	6.00
6.020	GE106.0200.100.37.60.L	6.00	2.00	1.00	2.70	5.70	2.00	37.00	62.00	6.00
6.021	GE106.0200.100.42.60.L	6.00	2.00	1.00	2.70	5.70	2.00	42.00	67.00	6.00

System 106



**Cutting insert for axial grooving bores, straight slots**

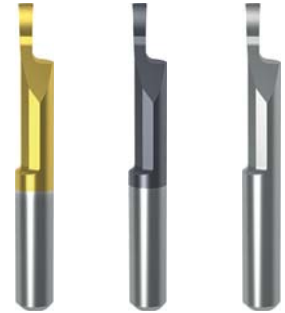
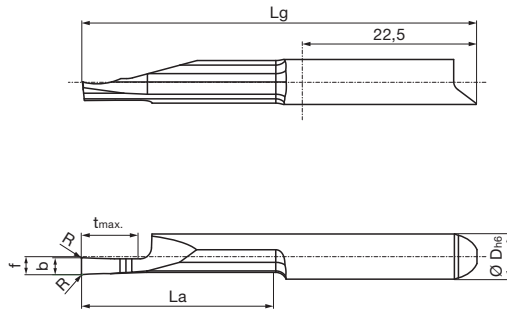


- grooving depth up to 8 mm

for tool holders type GH106/GB106 see from page 62

**GUHRING NAVIGATOR**

Cutting data page 184



Right hand version shown  
Left hand version mirror image

Article no. **25780** **25782** **25786**

Cutting direction

Code no.	Description	D min	b	R	f	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
6.001	GA106.0150.010.17.60.R	6.00	1.50	0.10	2.60	5.00	17.00	42.00	6.00
6.002	GA106.0150.010.22.60.R	6.00	1.50	0.10	2.60	5.00	22.00	47.00	6.00
6.003	GA106.0200.015.17.60.R	6.00	2.00	0.15	2.60	8.00	17.00	42.00	6.00
6.004	GA106.0200.015.22.60.R	6.00	2.00	0.15	2.60	8.00	22.00	47.00	6.00

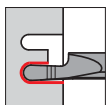
Article no. **25781** **25783** **25787**

Cutting direction

Code no.	Description	D min	b	R	f	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
6.001	GA106.0150.010.17.60.L	6.00	1.50	0.10	2.60	5.00	17.00	42.00	6.00
6.002	GA106.0150.010.22.60.L	6.00	1.50	0.10	2.60	5.00	22.00	47.00	6.00
6.003	GA106.0200.015.17.60.L	6.00	2.00	0.15	2.60	8.00	17.00	42.00	6.00
6.004	GA106.0200.015.22.60.L	6.00	2.00	0.15	2.60	8.00	22.00	47.00	6.00



**Cutting insert for axial grooving bores, full radius slots**

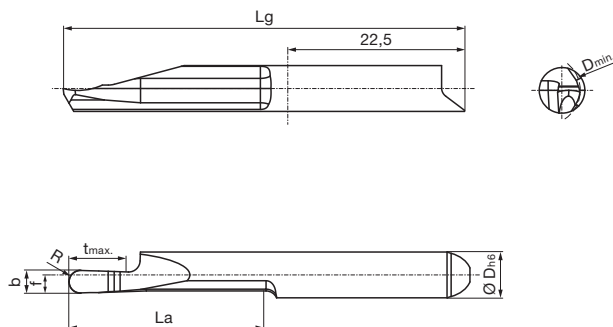


- grooving depth up to 8 mm

for tool holders type GH106/GB106 see from page 62

**GUHRING NAVIGATOR**

Cutting data page 184



Right hand version shown  
Left hand version mirror image



Article no. **25788**    **25790**    **25794**

Cutting direction

Code no.	Description	D min	b	R	f	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
6.001	GA106.0150.075.17.60.R	6.00	1.50	0.75	2.60	5.00	17.00	42.00	6.00
6.002	GA106.0150.075.22.60.R	6.00	1.50	0.75	2.60	5.00	22.00	47.00	6.00
6.003	GA106.0200.100.17.60.R	6.00	2.00	1.00	2.60	8.00	17.00	42.00	6.00
6.004	GA106.0200.100.22.60.R	6.00	2.00	1.00	2.60	8.00	22.00	47.00	6.00

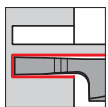
Article no. **25789**    **25791**    **25795**

Cutting direction

Code no.	Description	D min	b	R	f	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
6.001	GA106.0150.075.17.60.L	6.00	1.50	0.75	2.60	5.00	17.00	42.00	6.00
6.002	GA106.0150.075.22.60.L	6.00	1.50	0.75	2.60	5.00	22.00	47.00	6.00
6.003	GA106.0200.100.17.60.L	6.00	2.00	1.00	2.60	8.00	17.00	42.00	6.00
6.004	GA106.0200.100.22.60.L	6.00	2.00	1.00	2.60	8.00	22.00	47.00	6.00

System 106

**Cutting insert for axial grooving studs, straight slots**

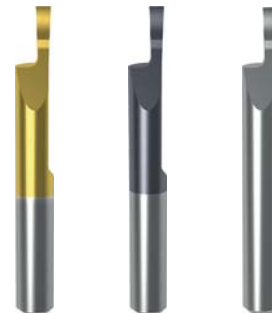
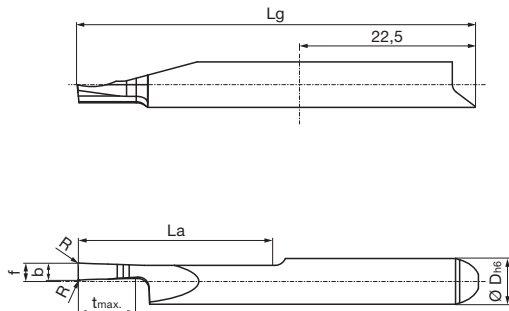


• grooving depth up to 8 mm

for tool holders type GH106/GB106 see from page 62

**GUHRING NAVIGATOR**

Cutting data page 184



Right hand version shown  
Left hand version mirror image

Article no. **25796** **25798** **25802**

Cutting direction

Code no.	Description	D min	b	R	f	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
6.001	GA106.Z150.010.17.60.R	6.00	1.50	0.10	2.60	5.00	17.00	42.00	6.00
6.002	GA106.Z150.010.22.60.R	6.00	1.50	0.10	2.60	5.00	22.00	47.00	6.00
6.003	GA106.Z200.015.17.60.R	6.00	2.00	0.15	2.60	8.00	17.00	42.00	6.00
6.004	GA106.Z200.015.22.60.R	6.00	2.00	0.15	2.60	8.00	22.00	47.00	6.00

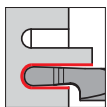
Article no. **25797** **25799** **25803**

Cutting direction

Code no.	Description	D min	b	R	f	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
6.001	GA106.Z150.010.17.60.L	6.00	1.50	0.10	2.60	5.00	17.00	42.00	6.00
6.002	GA106.Z150.010.22.60.L	6.00	1.50	0.10	2.60	5.00	22.00	47.00	6.00
6.003	GA106.Z200.015.17.60.L	6.00	2.00	0.15	2.60	8.00	17.00	42.00	6.00
6.004	GA106.Z200.015.22.60.L	6.00	2.00	0.15	2.60	8.00	22.00	47.00	6.00



**Cutting insert for axial grooving studs, full radius slots**

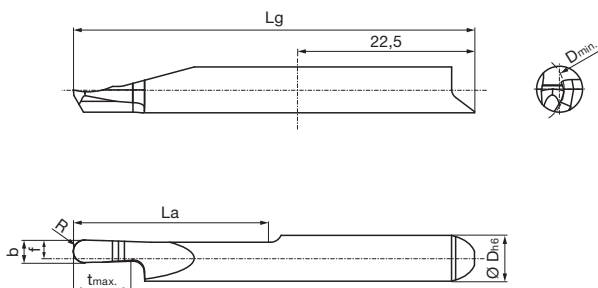


- grooving depth up to 8 mm

for tool holders type GH106/GB106 see from page 62

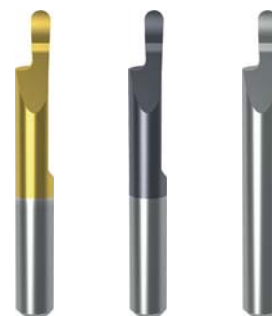
**GUHRING NAVIGATOR**

Cutting data page 184



Right hand version shown  
Left hand version mirror image

Tool material	Solid carbide		
Type	GA 106	GA 106	GA 106
Surface	<b>S</b>	<b>a</b>	○
	TiN	TiAlN-nanoA	bright



System 106

Article no. **25804**    **25806**    **25810**

Cutting direction

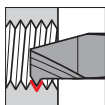
Code no.	Description	D min	b	R	f	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
6.001	GA106.Z150.075.17.60.R	6.00	1.50	0.75	2.60	5.00	17.00	42.00	6.00
6.002	GA106.Z150.075.22.60.R	6.00	1.50	0.75	2.60	5.00	22.00	47.00	6.00
6.003	GA106.Z200.100.17.60.R	6.00	2.00	1.00	2.60	8.00	17.00	42.00	6.00
6.004	GA106.Z200.100.22.60.R	6.00	2.00	1.00	2.60	8.00	22.00	47.00	6.00

Article no. **25805**    **25807**    **25811**

Cutting direction

Code no.	Description	D min	b	R	f	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
6.001	GA106.Z150.075.17.60.L	6.00	1.50	0.75	2.60	5.00	17.00	42.00	6.00
6.002	GA106.Z150.075.22.60.L	6.00	1.50	0.75	2.60	5.00	22.00	47.00	6.00
6.003	GA106.Z200.100.17.60.L	6.00	2.00	1.00	2.60	8.00	17.00	42.00	6.00
6.004	GA106.Z200.100.22.60.L	6.00	2.00	1.00	2.60	8.00	22.00	47.00	6.00

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



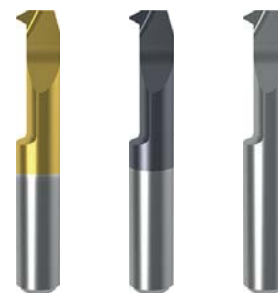
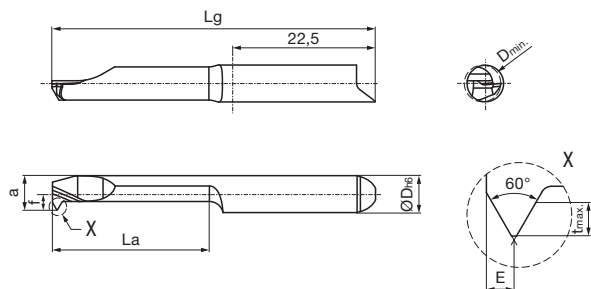
• pitch P = 1.25-1.75

for tool holders type GH106/GB106 see from page 62

**GUHRING NAVIGATOR**

Cutting data page 184

System 106



Right hand version shown  
Left hand version mirror image

Article no. **25764** **25766** **25770**

Cutting direction

Code no.	Description	G	P	D min	f	E	a	t max	La	Lg	D h6
			mm	mm	mm	mm	mm	mm	mm	mm	mm
6.010	GG106.TM08.125.12.68.R	M8	1.25	6.80	2.95	0.70	5.95	0.70	12.00	37.00	6.00
6.001	GG106.TM08.125.17.68.R	M8	1.25	6.80	2.95	0.70	5.95	0.70	17.00	42.00	6.00
6.002	GG106.TM08.125.22.68.R	M8	1.25	6.80	2.95	0.70	5.95	0.70	22.00	47.00	6.00
6.003	GG106.TM08.125.27.68.R	M8	1.25	6.80	2.95	0.70	5.95	0.70	27.00	52.00	6.00
6.011	GG106.TM08.125.32.68.R	M8	1.25	6.80	2.95	0.70	5.95	0.70	32.00	57.00	6.00
6.012	GG106.TM08.125.37.68.R	M8	1.25	6.80	2.95	0.70	5.95	0.70	37.00	62.00	6.00
6.013	GG106.TM08.125.42.68.R	M8	1.25	6.80	2.95	0.70	5.95	0.70	42.00	67.00	6.00
6.014	GG106.TM10.150.12.85.R	M10	1.50	8.50	2.95	0.85	5.95	0.85	12.00	37.00	6.00
6.004	GG106.TM10.150.17.85.R	M10	1.50	8.50	2.95	0.85	5.95	0.85	17.00	42.00	6.00
6.005	GG106.TM10.150.22.85.R	M10	1.50	8.50	2.95	0.85	5.95	0.85	22.00	47.00	6.00
6.006	GG106.TM10.150.27.85.R	M10	1.50	8.50	2.95	0.85	5.95	0.85	27.00	52.00	6.00
6.015	GG106.TM10.150.32.85.R	M10	1.50	8.50	2.95	0.85	5.95	0.85	32.00	57.00	6.00
6.016	GG106.TM10.150.37.85.R	M10	1.50	8.50	2.95	0.85	5.95	0.85	37.00	62.00	6.00
6.017	GG106.TM10.150.42.85.R	M10	1.50	8.50	2.95	0.85	5.95	0.85	42.00	67.00	6.00
6.018	GG106.TM12.175.12.99.R	M12	1.75	10.20	2.95	1.00	5.95	1.00	12.00	37.00	6.00
6.007	GG106.TM12.175.17.99.R	M12	1.75	10.20	2.95	1.00	5.95	1.00	17.00	42.00	6.00
6.008	GG106.TM12.175.22.99.R	M12	1.75	10.20	2.95	1.00	5.95	1.00	22.00	47.00	6.00
6.009	GG106.TM12.175.27.99.R	M12	1.75	10.20	2.95	1.00	5.95	1.00	27.00	52.00	6.00
6.019	GG106.TM12.175.32.99.R	M12	1.75	10.20	2.95	1.00	5.95	1.00	32.00	57.00	6.00
6.020	GG106.TM12.175.37.99.R	M12	1.75	10.20	2.95	1.00	5.95	1.00	37.00	62.00	6.00
6.021	GG106.TM12.175.42.99.R	M12	1.75	10.20	2.95	1.00	5.95	1.00	42.00	67.00	6.00

Article no. **25765** **25767** **25771**

Cutting direction

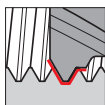
Code no.	Description	G	P	D min	f	E	a	t max	La	Lg	D h6
			mm	mm	mm	mm	mm	mm	mm	mm	mm
6.010	GG106.TM08.125.12.68.L	M8	1.25	6.80	2.95	0.70	5.95	0.70	12.00	37.00	6.00
6.001	GG106.TM08.125.17.68.L	M8	1.25	6.80	2.95	0.70	5.95	0.70	17.00	42.00	6.00
6.002	GG106.TM08.125.22.68.L	M8	1.25	6.80	2.95	0.70	5.95	0.70	22.00	47.00	6.00
6.003	GG106.TM08.125.27.68.L	M8	1.25	6.80	2.95	0.70	5.95	0.70	27.00	52.00	6.00
6.011	GG106.TM08.125.32.68.L	M8	1.25	6.80	2.95	0.70	5.95	0.70	32.00	57.00	6.00
6.012	GG106.TM08.125.37.68.L	M8	1.25	6.80	2.95	0.70	5.95	0.70	37.00	62.00	6.00

Article no. **25765** **25767** **25771**Cutting direction   

Code no.	Description	G	P	D min	f	E	a	t max	La	Lg	D h6
			mm	mm	mm	mm	mm	mm	mm	mm	mm
6.013	GG106.TM08.125.42.68.L	M8	1.25	6.80	2.95	0.70	5.95	0.70	42.00	67.00	6.00
6.014	GG106.TM10.150.12.85.L	M10	1.50	8.50	2.95	0.85	5.95	0.85	12.00	37.00	6.00
6.004	GG106.TM10.150.17.85.L	M10	1.50	8.50	2.95	0.85	5.95	0.85	17.00	42.00	6.00
6.005	GG106.TM10.150.22.85.L	M10	1.50	8.50	2.95	0.85	5.95	0.85	22.00	47.00	6.00
6.006	GG106.TM10.150.27.85.L	M10	1.50	8.50	2.95	0.85	5.95	0.85	27.00	52.00	6.00
6.015	GG106.TM10.150.32.85.L	M10	1.50	8.50	2.95	0.85	5.95	0.85	32.00	57.00	6.00
6.016	GG106.TM10.150.37.85.L	M10	1.50	8.50	2.95	0.85	5.95	0.85	37.00	62.00	6.00
6.017	GG106.TM10.150.42.85.L	M10	1.50	8.50	2.95	0.85	5.95	0.85	42.00	67.00	6.00
6.018	GG106.TM12.175.12.99.L	M12	1.75	10.20	2.95	1.00	5.95	1.00	12.00	37.00	6.00
6.007	GG106.TM12.175.17.99.L	M12	1.75	10.20	2.95	1.00	5.95	1.00	17.00	42.00	6.00
6.008	GG106.TM12.175.22.99.L	M12	1.75	10.20	2.95	1.00	5.95	1.00	22.00	47.00	6.00
6.009	GG106.TM12.175.27.99.L	M12	1.75	10.20	2.95	1.00	5.95	1.00	27.00	52.00	6.00
6.019	GG106.TM12.175.32.99.L	M12	1.75	10.20	2.95	1.00	5.95	1.00	32.00	57.00	6.00
6.020	GG106.TM12.175.37.99.L	M12	1.75	10.20	2.95	1.00	5.95	1.00	37.00	62.00	6.00
6.021	GG106.TM12.175.42.99.L	M12	1.75	10.20	2.95	1.00	5.95	1.00	42.00	67.00	6.00

System 106

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



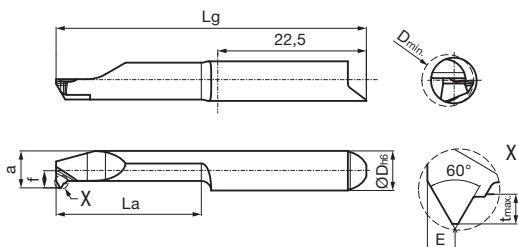
• pitch P = 1-1.75

for tool holders type GH106/GB106 see from page 62

**GUHRING NAVIGATOR**

Cutting data page 184

System 106



Right hand version shown  
Left hand version mirror image

Article no. **25772** **25774** **25778**

Cutting direction

Code no.	Description	G	P	D min	f	E	a	t max	La	Lg	D h6
			mm	mm	mm	mm	mm	mm	mm	mm	mm
6.010	GG106.VM06.100.12.50.R	M6	1.00	5.00	2.95	0.50	4.50	0.60	12.00	37.00	6.00
6.020	GG106.VM06.100.17.50.R	M6	1.00	5.00	2.95	0.50	4.50	0.60	17.00	42.00	6.00
6.030	GG106.VM06.100.22.50.R	M6	1.00	5.00	2.95	0.50	4.50	0.60	22.00	47.00	6.00
6.040	GG106.VM06.100.27.50.R	M6	1.00	5.00	2.95	0.50	4.50	0.60	27.00	52.00	6.00
6.050	GG106.VM06.100.32.50.R	M6	1.00	5.00	2.95	0.50	4.50	0.60	32.00	57.00	6.00
6.060	GG106.VM06.100.37.50.R	M6	1.00	5.00	2.95	0.50	4.50	0.60	37.00	62.00	6.00
6.070	GG106.VM06.100.42.50.R	M6	1.00	5.00	2.95	0.50	4.50	0.60	42.00	67.00	6.00
6.110	GG106.VM08.125.12.68.R	M8	1.25	6.80	2.95	0.70	5.95	0.75	12.00	37.00	6.00
6.120	GG106.VM08.125.17.68.R	M8	1.25	6.80	2.95	0.70	5.95	0.75	17.00	42.00	6.00
6.130	GG106.VM08.125.22.68.R	M8	1.25	6.80	2.95	0.70	5.95	0.75	22.00	47.00	6.00
6.140	GG106.VM08.125.27.68.R	M8	1.25	6.80	2.95	0.70	5.95	0.75	27.00	52.00	6.00
6.150	GG106.VM08.125.32.68.R	M8	1.25	6.80	2.95	0.70	5.95	0.75	32.00	57.00	6.00
6.160	GG106.VM08.125.37.68.R	M8	1.25	6.80	2.95	0.70	5.95	0.75	37.00	62.00	6.00
6.170	GG106.VM08.125.42.68.R	M8	1.25	6.80	2.95	0.70	5.95	0.75	42.00	67.00	6.00
6.210	GG106.VM10.150.12.85.R	M10	1.50	8.50	2.95	0.90	5.95	0.90	12.00	37.00	6.00
6.220	GG106.VM10.150.17.85.R	M10	1.50	8.50	2.95	0.90	5.95	0.90	17.00	42.00	6.00
6.230	GG106.VM10.150.22.85.R	M10	1.50	8.50	2.95	0.90	5.95	0.90	22.00	47.00	6.00
6.240	GG106.VM10.150.27.85.R	M10	1.50	8.50	2.95	0.90	5.95	0.90	27.00	52.00	6.00
6.250	GG106.VM10.150.32.85.R	M10	1.50	8.50	2.95	0.90	5.95	0.90	32.00	57.00	6.00
6.260	GG106.VM10.150.37.85.R	M10	1.50	8.50	2.95	0.90	5.95	0.90	37.00	62.00	6.00
6.270	GG106.VM10.150.42.85.R	M10	1.50	8.50	2.95	0.90	5.95	0.90	42.00	67.00	6.00
6.310	GG106.VM12.175.12.00.R	M12	1.75	10.20	2.95	0.90	5.95	1.05	12.00	37.00	6.00
6.320	GG106.VM12.175.17.00.R	M12	1.75	10.20	2.95	0.90	5.95	1.05	17.00	42.00	6.00
6.330	GG106.VM12.175.22.00.R	M12	1.75	10.20	2.95	0.90	5.95	1.05	22.00	47.00	6.00
6.340	GG106.VM12.175.27.00.R	M12	1.75	10.20	2.95	0.90	5.95	1.05	27.00	52.00	6.00
6.350	GG106.VM12.175.32.00.R	M12	1.75	10.20	2.95	0.90	5.95	1.05	32.00	57.00	6.00
6.360	GG106.VM12.175.37.00.R	M12	1.75	10.20	2.95	0.90	5.95	1.05	37.00	62.00	6.00
6.370	GG106.VM12.175.42.00.R	M12	1.75	10.20	2.95	0.90	5.95	1.05	42.00	67.00	6.00

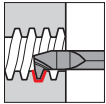
Article no. **25773** **25775** **25779**Cutting direction   

Code no.	Description	G	P	D min	f	E	a	t max	La	Lg	D h6
			mm	mm	mm	mm	mm	mm	mm	mm	mm
6.010	GG106.VM06.100.12.50.L	M6	1.00	5.00	2.95	0.50	4.50	0.60	12.00	37.00	6.00
6.020	GG106.VM06.100.17.50.L	M6	1.00	5.00	2.95	0.50	4.50	0.60	17.00	42.00	6.00
6.030	GG106.VM06.100.22.50.L	M6	1.00	5.00	2.95	0.50	4.50	0.60	22.00	47.00	6.00
6.040	GG106.VM06.100.27.50.L	M6	1.00	5.00	2.95	0.50	4.50	0.60	27.00	52.00	6.00
6.050	GG106.VM06.100.32.50.L	M6	1.00	5.00	2.95	0.50	4.50	0.60	32.00	57.00	6.00
6.060	GG106.VM06.100.37.50.L	M6	1.00	5.00	2.95	0.50	4.50	0.60	37.00	62.00	6.00
6.070	GG106.VM06.100.42.50.L	M6	1.00	5.00	2.95	0.50	4.50	0.60	42.00	67.00	6.00
6.110	GG106.VM08.125.12.68.L	M8	1.25	6.80	2.95	0.70	5.95	0.75	12.00	37.00	6.00
6.120	GG106.VM08.125.17.68.L	M8	1.25	6.80	2.95	0.70	5.95	0.75	17.00	42.00	6.00
6.130	GG106.VM08.125.22.68.L	M8	1.25	6.80	2.95	0.70	5.95	0.75	22.00	47.00	6.00
6.140	GG106.VM08.125.27.68.L	M8	1.25	6.80	2.95	0.70	5.95	0.75	27.00	52.00	6.00
6.150	GG106.VM08.125.32.68.L	M8	1.25	6.80	2.95	0.70	5.95	0.75	32.00	57.00	6.00
6.160	GG106.VM08.125.37.68.L	M8	1.25	6.80	2.95	0.70	5.95	0.75	37.00	62.00	6.00
6.170	GG106.VM08.125.42.68.L	M8	1.25	6.80	2.95	0.70	5.95	0.75	42.00	67.00	6.00
6.210	GG106.VM10.150.12.85.L	M10	1.50	8.50	2.95	0.90	5.95	0.90	12.00	37.00	6.00
6.220	GG106.VM10.150.17.85.L	M10	1.50	8.50	2.95	0.90	5.95	0.90	17.00	42.00	6.00
6.230	GG106.VM10.150.22.85.L	M10	1.50	8.50	2.95	0.90	5.95	0.90	22.00	47.00	6.00
6.240	GG106.VM10.150.27.85.L	M10	1.50	8.50	2.95	0.90	5.95	0.90	27.00	52.00	6.00
6.250	GG106.VM10.150.32.85.L	M10	1.50	8.50	2.95	0.90	5.95	0.90	32.00	57.00	6.00
6.260	GG106.VM10.150.37.85.L	M10	1.50	8.50	2.95	0.90	5.95	0.90	37.00	62.00	6.00
6.270	GG106.VM10.150.42.85.L	M10	1.50	8.50	2.95	0.90	5.95	0.90	42.00	67.00	6.00
6.310	GG106.VM12.175.12.00.L	M12	1.75	10.20	2.95	0.90	5.95	1.05	12.00	37.00	6.00
6.320	GG106.VM12.175.17.00.L	M12	1.75	10.20	2.95	0.90	5.95	1.05	17.00	42.00	6.00
6.330	GG106.VM12.175.22.00.L	M12	1.75	10.20	2.95	0.90	5.95	1.05	22.00	47.00	6.00
6.340	GG106.VM12.175.27.00.L	M12	1.75	10.20	2.95	0.90	5.95	1.05	27.00	52.00	6.00
6.350	GG106.VM12.175.32.00.L	M12	1.75	10.20	2.95	0.90	5.95	1.05	32.00	57.00	6.00
6.360	GG106.VM12.175.37.00.L	M12	1.75	10.20	2.95	0.90	5.95	1.05	37.00	62.00	6.00
6.370	GG106.VM12.175.42.00.L	M12	1.75	10.20	2.95	0.90	5.95	1.05	42.00	67.00	6.00

System 106



Cutting insert for internal threading, part profile - trapezoidal thread



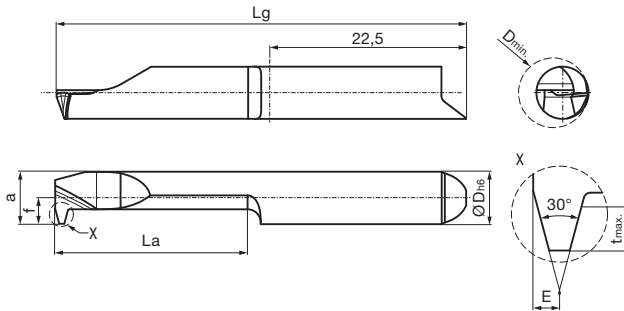
• pitch P = 1.5-3.0

for tool holders type GH106/GB106 see from page 62

**GUHRING NAVIGATOR**

Cutting data page 184

System 106



Right hand version shown  
Left hand version mirror image

Article no. **25824** **25826** **25830**

Cutting direction

Code no.	Description	G	P	D min	f	E	a	t max	La	Lg	D h6
			mm	mm	mm	mm	mm	mm	mm	mm	mm
6.002	GG106.TT08.200.22.60.R	Tr8	2.00	6.00	2.70	0.75	5.70	1.25	22.00	47.00	6.00
6.001	GG106.TT08.150.22.65.R	Tr8	1.50	6.50	2.95	0.60	5.95	0.90	22.00	47.00	6.00
6.003	GG106.TT10.200.22.80.R	Tr10	2.00	8.00	2.95	0.75	5.95	1.25	22.00	47.00	6.00
6.005	GG106.TT10.300.22.70.R	Tr10	3.00	7.00	2.95	1.10	5.95	1.75	22.00	47.00	6.00
6.004	GG106.TT10.200.32.80.R	Tr10	2.00	8.00	2.95	0.75	5.95	1.25	32.00	57.00	6.00
6.006	GG106.TT10.300.32.70.R	Tr10	3.00	7.00	2.95	1.10	5.95	1.75	32.00	57.00	6.00

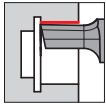
Article no. **25825** **25827** **25831**

Cutting direction

Code no.	Description	G	P	D min	f	E	a	t max	La	Lg	D h6
			mm	mm	mm	mm	mm	mm	mm	mm	mm
6.002	GG106.TT08.200.22.60.L	Tr8	2.00	6.00	2.70	0.75	5.70	1.25	22.00	47.00	6.00
6.001	GG106.TT08.150.22.65.L	Tr8	1.50	6.50	2.95	0.60	5.95	0.90	22.00	47.00	6.00
6.003	GG106.TT10.200.22.80.L	Tr10	2.00	8.00	2.95	0.75	5.95	1.25	22.00	47.00	6.00
6.005	GG106.TT10.300.22.70.L	Tr10	3.00	7.00	2.95	1.10	5.95	1.75	22.00	47.00	6.00
6.004	GG106.TT10.200.32.80.L	Tr10	2.00	8.00	2.95	0.75	5.95	1.25	32.00	57.00	6.00
6.006	GG106.TT10.300.32.70.L	Tr10	3.00	7.00	2.95	1.10	5.95	1.75	32.00	57.00	6.00



**Cutting insert for broaching longitudinal slots**



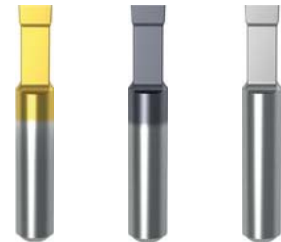
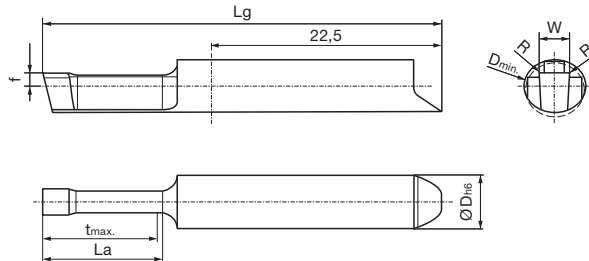
• tolerance class C11, P9, JS9

for tool holders type GB106 Art. No. 25302 see page 74

**GUHRING NAVIGATOR**

Cutting data page 184

Tool material	Solid carbide		
Type	GN 106	GN 106	GN 106
Surface	<b>S</b>	<b>a</b>	○
	TiN	TiAlN-nanoA	bright



Article no. **25812** **25813** **25815**

Code no.	Description	for slot width	D min	W	R	f	t max	La	Lg	D h6
			mm	mm	mm	mm	mm	mm	mm	mm
6.001	GN106.0198.010.12.06.N	2 P9	6.00	1.98	0.10	1.50	11.50	12.00	37.00	6.00
6.002	GN106.0298.010.12.06.N	3 P9	6.00	2.98	0.10	1.50	11.50	12.00	37.00	6.00
6.003	GN106.0398.010.12.06.N	4 P9	6.00	3.98	0.10	1.50	11.50	12.00	37.00	6.00
6.004	GN106.0498.020.12.07.N	5 P9	7.00	4.98	0.20	1.50	11.50	12.00	37.00	6.00

Article no. **25816** **25817** **25819**

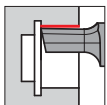
Code no.	Description	for slot width	D min	W	R	f	t max	La	Lg	D h6
			mm	mm	mm	mm	mm	mm	mm	mm
6.001	GN106.0200.010.12.06.N	2 JS9	6.00	2.00	0.10	1.50	11.50	12.00	37.00	6.00
6.002	GN106.0300.010.12.06.N	3 JS9	6.00	3.00	0.10	1.50	11.50	12.00	37.00	6.00
6.003	GN106.0400.010.12.06.N	4 JS9	6.00	4.00	0.10	1.50	11.50	12.00	37.00	6.00
6.004	GN106.0500.020.12.07.N	5 JS9	7.00	5.00	0.20	1.50	11.50	12.00	37.00	6.00

Article no. **25820** **25821** **25823**

Code no.	Description	for slot width	D min	W	R	f	t max	La	Lg	D h6
			mm	mm	mm	mm	mm	mm	mm	mm
6.001	GN106.0211.035.12.06.N	2 C11	6.00	2.11	0.35	1.50	11.50	12.00	37.00	6.00
6.002	GN106.0311.035.12.06.N	3 C11	6.00	3.11	0.35	1.50	11.50	12.00	37.00	6.00
6.003	GN106.0413.050.12.06.N	4 C11	6.00	4.13	0.50	1.50	11.50	12.00	37.00	6.00
6.004	GN106.0513.050.12.07.N	5 C11	7.00	5.13	0.50	1.50	11.50	12.00	37.00	6.00

System 106

**Cutting insert for internal hexagon**

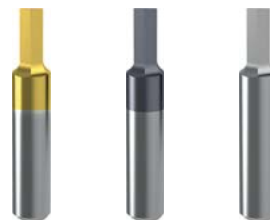
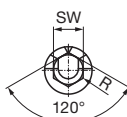
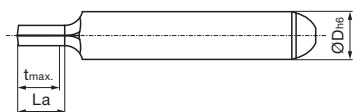
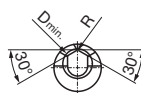
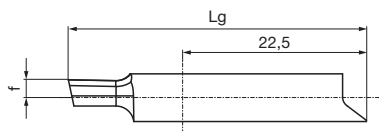


• SW 4.0-10.0

for tool holders type GB106 Art. No. 25302 see page 74

**GÜHRING NAVIGATOR**

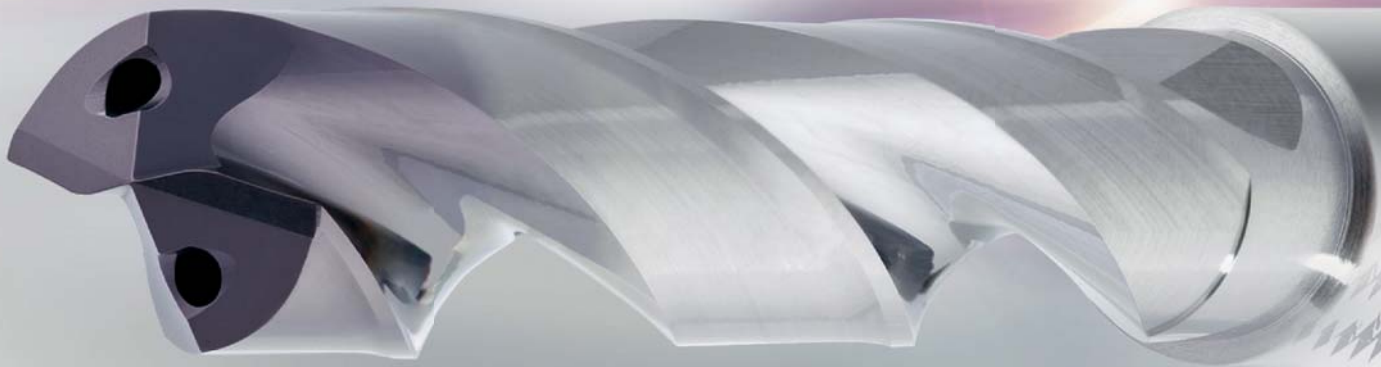
Cutting data page 184



Article no. **25896** **25897** **25898**

Code no.	Description	SW	D min	R	f	t max	La	Lg	D h6
			mm	mm	mm	mm	mm	mm	mm
6.001	GN106.SW40.010.06.40.N	4,00-4,50	4.00	0.10	1.50	6.00	6.50	37.00	6.00
6.002	GN106.SW45.010.07.45.N	4,50-5,00	4.50	0.10	1.50	7.00	7.50	37.00	6.00
6.003	GN106.SW50.010.09.50.N	5,00-8,00	5.00	0.10	1.50	9.00	9.50	37.00	6.00
6.004	GN106.SW80.010.12.80.N	8,00-10,00	8.00	0.10	1.50	12.00	12.50	37.00	6.00

# RT 100 S



RT 100 S

## THE RT 100 S

– FOR DEMANDING MACHINING JOBS

- ▶ Top quality tools for top performance
- ▶ The ideal tool for use with structural and free-cutting steels, alloyed and non-alloyed heat-treatable steels, alloyed and non-alloyed case-hardened steels, tool and high-speed steels

# 108





# SYSTEM 108

## MICRO-PRECISION TOOLS



Round shank holder

from page 124

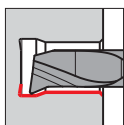


Square shank holder

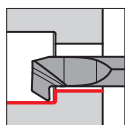
from page 128

Tool holder

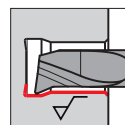
System 108



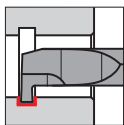
Boring out  
and profiling, type GT  
from page 130



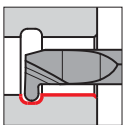
Back boring  
and profiling, type GT  
from page 138



Boring out  
with Wiper, type GJ  
from page 136



Internal grooving,  
straight slots, type GE  
from page 140



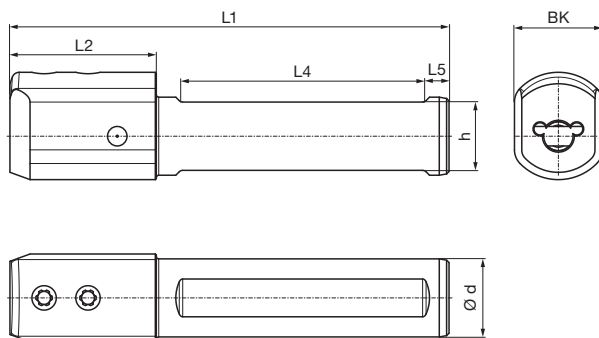
Internal grooving,  
full radius slots, type GE  
from page 144

Cutting inserts from hole-Ø 7 mm

**Round shank holder, clamping screw top**

- for inserts type 108
- with internal coolant supply

Type GB 108



System 108

Article no. 27000

Code no.	Description	d	h	L1	L2	L4	L5	BK
		mm	mm	mm	mm	mm	mm	mm
8.001	GB108.0010.090.00.22.N.IK	10.00	9.00	90.00	30.00	50.00	5.00	16.5
8.002	GB108.0012.090.00.22.N.IK	12.00	11.00	90.00	30.00	50.00	5.00	16.5
8.015	GB108.0500.354.00.22.N.IK	12.70	11.00	89.92	26.67	54.86	5.00	16.5
8.016	GB108.0625.354.00.22.N.IK	15.87	14.00	89.92	26.67	54.86	5.00	16.5
8.003	GB108.0016.090.00.22.N.IK	16.00	14.00	90.00	30.00	50.00	5.00	16.5
8.017	GB108.0750.415.00.22.N.IK	19.05	17.00	105.41	26.67	69.85	5.00	20.5
8.004	GB108.0020.095.00.22.N.IK	20.00	18.00	95.00	30.00	55.00	5.00	20.5
8.005	GB108.0022.095.00.22.N.IK	22.00	20.00	95.00	30.00	55.00	5.00	
8.006	GB108.0025.100.00.22.N.IK	25.00	23.00	100.00		55.00	5.00	
8.018	GB108.1000.415.00.22.N.IK	25.40	23.40	105.41		69.85	5.00	

**Spare parts**

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

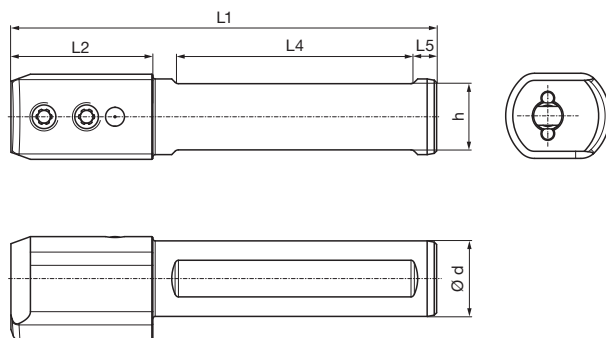
Article no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle



### Round shank holder, clamping screw lateral

- for inserts type 108
- with internal coolant supply

Type GB 108



System 108

Article no. 27001

Code no.	Description	d	h	L1	L2	L4	L5
		mm	mm	mm	mm	mm	mm
8.001	GB108.0010.090.00.22.N.IK.90	10.00	9.00	90.00	30.00	50.00	5.00
8.002	GB108.0012.090.00.22.N.IK.90	12.00	11.00	90.00	30.00	50.00	5.00
8.015	GB108.0500.354.00.22.N.IK.90	12.70	11.00	89.92	26.67	54.86	5.00
8.016	GB108.0625.354.00.22.N.IK.90	15.87	14.00	89.92	26.67	54.86	5.00
8.003	GB108.0016.090.00.22.N.IK.90	16.00	14.00	90.00	30.00	50.00	5.00
8.017	GB108.0750.415.00.22.N.IK.90	19.05	17.00	105.41	26.67	69.85	5.00
8.004	GB108.0020.095.00.22.N.IK.90	20.00	18.00	95.00	30.00	55.00	5.00
8.005	GB108.0022.095.00.22.N.IK.90	22.00	20.00	95.00	30.00	55.00	5.00
8.006	GB108.0025.100.00.22.N.IK.90	25.00	23.00	100.00		55.00	5.00
8.018	GB108.1000.415.00.22.N.IK.90	25.40	23.40	105.41		69.85	5.00

### Spare parts

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

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



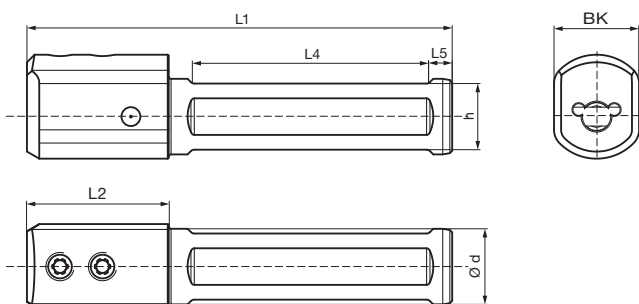


**Round shank holder, clamping screw above, four clamping surfaces**

- for inserts type 108
- with internal coolant supply

Type GB 108

System 108



Article no. **27002**

version left and right

Code no.	Description	d	h	L1	L2	L4	L5	BK
		mm	mm	mm	mm	mm	mm	mm
8.010	GB108.0016.090.00.22.N.IK.VSP	16.00	14.00	90.00	30.00	50.00	5.00	16.5
8.020	GB108.0020.095.00.22.N.IK.VSP	20.00	18.00	95.00	30.00	55.00	5.00	20.5
8.030	GB108.0022.095.00.22.N.IK.VSP	22.00	20.00	95.00	30.00	55.00	5.00	
8.040	GB108.0025.100.00.22.N.IK.VSP	25.00	23.00	100.00		55.00	5.00	

**Spare parts**

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

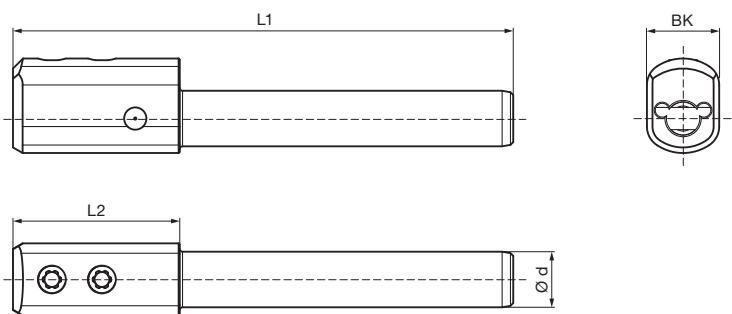
Article no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle



**Round shank holder, clamping screw above, without clamping surfaces**

- for inserts type 108
- with internal coolant supply

Type	GB 108
------	--------



System 108

Article no. **27003**  
version left and right

Code no.	Description	d	L1	L2	BK
		mm	mm	mm	mm
8.010	GB108.0010.090.00.22.N.IK.RND	10.00	90.00	30.00	16.5
8.020	GB108.0012.090.00.22.N.IK.RND	12.00	90.00	30.00	16.5
8.030	GB108.0016.090.00.22.N.IK.RND	16.00	90.00	30.00	16.5

**Spare parts**

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

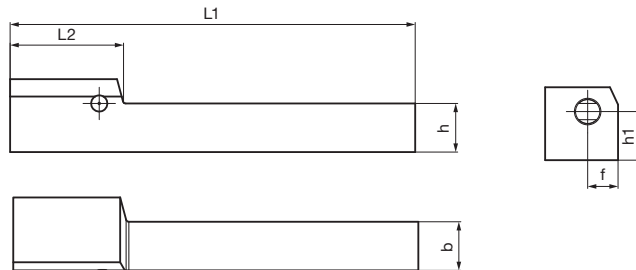
Article no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle

**Square shank holder, straight 0°**

- for inserts type 108
- without internal coolant supply

Type GH 108

System 108



Right hand version shown  
Left hand version mirror image

Article no. **27007**

version right-hand

Code no.	Description	b	h	h1	f	L1	L2
		mm	mm	mm	mm	mm	mm
8.110	GH108.0375.350.00.22.R	9.52	9.52	9.52	7.62	88.90	27.94
8.010	GH108.1010.100.00.22.R	10.00	10.00	10.00	7.50	100.00	28.00
8.020	GH108.1212.100.00.22.R	12.00	12.00	12.00	7.50	100.00	28.00
8.120	GH108.0500.350.00.22.R	12.70	12.70	12.70	7.62	88.90	27.94
8.130	GH108.0625.400.00.22.R	15.87	15.87	15.87	7.62	101.60	27.94
8.030	GH108.1616.120.00.22.R	16.00	16.00	16.00	7.50	120.00	28.00

Article no. **27008**

version left-hand

Code no.	Description	b	h	h1	f	L1	L2
		mm	mm	mm	mm	mm	mm
8.110	GH108.0375.350.00.22.L	9.52	9.52	9.52	7.62	88.90	27.94
8.010	GH108.1010.100.00.22.L	10.00	10.00	10.00	7.50	100.00	28.00
8.020	GH108.1212.100.00.22.L	12.00	12.00	12.00	7.50	100.00	28.00
8.120	GH108.0500.350.00.22.L	12.70	12.70	12.70	7.62	88.90	27.94
8.130	GH108.0625.400.00.22.L	15.87	15.87	15.87	7.62	101.60	27.94
8.030	GH108.1616.120.00.22.L	16.00	16.00	16.00	7.50	120.00	28.00

**Spare parts**

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

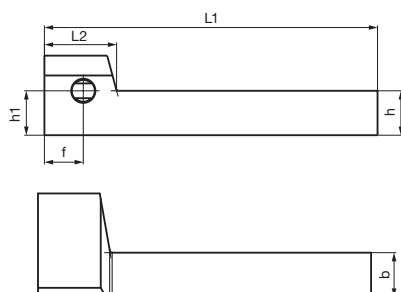
Article no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle



### Square shank holder, 90° offset

- for inserts type 108
- without internal coolant supply

Type GH 108



System 108

Right hand version shown  
Left hand version mirror image

Article no. **27009**

version right-hand

Code no.	Description	b	h	h1	f	L1	L2
		mm	mm	mm	mm	mm	mm
8.010	GH108.0375.350.90.22.R	9.52	9.52	9.52	11.43	88.90	20.32
8.001	GH108.1010.090.90.22.R	10.00	10.00	10.00	11.50	90.00	20.50
8.002	GH108.1212.090.90.22.R	12.00	12.00	12.00	11.50	90.00	20.50
8.011	GH108.0500.350.90.22.R	12.70	12.70	12.70	11.43	88.90	20.32
8.012	GH108.0625.400.90.22.R	15.87	15.87	15.87	11.43	101.60	20.32
8.003	GH108.1616.120.90.22.R	16.00	16.00	16.00	11.50	120.00	20.50

Article no. **27010**

version left-hand

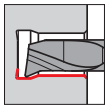
Code no.	Description	b	h	h1	f	L1	L2
		mm	mm	mm	mm	mm	mm
8.010	GH108.0375.350.90.22.L	9.52	9.52	9.52	11.43	88.90	20.32
8.001	GH108.1010.090.90.22.L	10.00	10.00	10.00	11.50	90.00	20.50
8.002	GH108.1212.090.90.22.L	12.00	12.00	12.00	11.50	90.00	20.50
8.011	GH108.0500.350.90.22.L	12.70	12.70	12.70	11.43	88.90	20.32
8.012	GH108.0625.400.90.22.L	15.87	15.87	15.87	11.43	101.60	20.32
8.003	GH108.1616.120.90.22.L	16.00	16.00	16.00	11.50	120.00	20.50

### Spare parts

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

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

**Cutting insert for boring out and profiling**



• radial free 23°

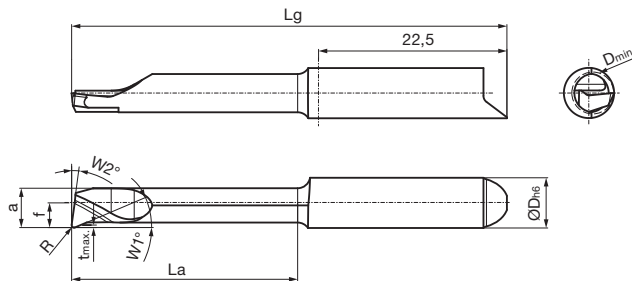
for tool holders type GH108/GB108 see from page 124

**GUHRING NAVIGATOR**

Cutting data page 184

Tool material	Solid carbide	
Type	GT 108	GT 108
Surface		
	TiAlN-nanoA	bright

System 108



Right hand version shown  
Left hand version mirror image

Article no.	<b>27100</b>	<b>27102</b>
Cutting direction		

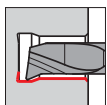
Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
8.120	GT108.2367.010.17.70.R	7.00	0.10	23	8	3.95	6.70	0.50	17.00	42.00	8.00
8.140	GT108.2367.010.27.70.R	7.00	0.10	23	8	3.95	6.70	0.50	27.00	52.00	8.00
8.160	GT108.2367.010.37.70.R	7.00	0.10	23	8	3.95	6.70	0.50	37.00	62.00	8.00
8.170	GT108.2367.010.42.70.R	7.00	0.10	23	8	3.95	6.70	0.50	42.00	67.00	8.00
8.180	GT108.2367.010.47.70.R	7.00	0.10	23	8	3.95	6.70	0.50	47.00	72.00	8.00
8.190	GT108.2367.010.52.70.R	7.00	0.10	23	8	3.95	6.70	0.50	52.00	77.00	8.00
8.320	GT108.2367.020.17.70.R	7.00	0.20	23	8	3.95	6.70	0.50	17.00	42.00	8.00
8.340	GT108.2367.020.27.70.R	7.00	0.20	23	8	3.95	6.70	0.50	27.00	52.00	8.00
8.360	GT108.2367.020.37.70.R	7.00	0.20	23	8	3.95	6.70	0.50	37.00	62.00	8.00
8.370	GT108.2367.020.42.70.R	7.00	0.20	23	8	3.95	6.70	0.50	42.00	67.00	8.00
8.380	GT108.2367.020.47.70.R	7.00	0.20	23	8	3.95	6.70	0.50	47.00	72.00	8.00
8.390	GT108.2367.020.52.70.R	7.00	0.20	23	8	3.95	6.70	0.50	52.00	77.00	8.00

Article no.	<b>27101</b>	<b>27103</b>
Cutting direction		

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
8.120	GT108.2367.010.17.70.L	7.00	0.10	23	8	3.95	6.70	0.50	17.00	42.00	8.00
8.140	GT108.2367.010.27.70.L	7.00	0.10	23	8	3.95	6.70	0.50	27.00	52.00	8.00
8.160	GT108.2367.010.37.70.L	7.00	0.10	23	8	3.95	6.70	0.50	37.00	62.00	8.00
8.170	GT108.2367.010.42.70.L	7.00	0.10	23	8	3.95	6.70	0.50	42.00	67.00	8.00
8.180	GT108.2367.010.47.70.L	7.00	0.10	23	8	3.95	6.70	0.50	47.00	72.00	8.00
8.190	GT108.2367.010.52.70.L	7.00	0.10	23	8	3.95	6.70	0.50	52.00	77.00	8.00
8.320	GT108.2367.020.17.70.L	7.00	0.20	23	8	3.95	6.70	0.50	17.00	42.00	8.00
8.340	GT108.2367.020.27.70.L	7.00	0.20	23	8	3.95	6.70	0.50	27.00	52.00	8.00
8.360	GT108.2367.020.37.70.L	7.00	0.20	23	8	3.95	6.70	0.50	37.00	62.00	8.00
8.370	GT108.2367.020.42.70.L	7.00	0.20	23	8	3.95	6.70	0.50	42.00	67.00	8.00
8.380	GT108.2367.020.47.70.L	7.00	0.20	23	8	3.95	6.70	0.50	47.00	72.00	8.00
8.390	GT108.2367.020.52.70.L	7.00	0.20	23	8	3.95	6.70	0.50	52.00	77.00	8.00



**Cutting insert for boring out and profiling**

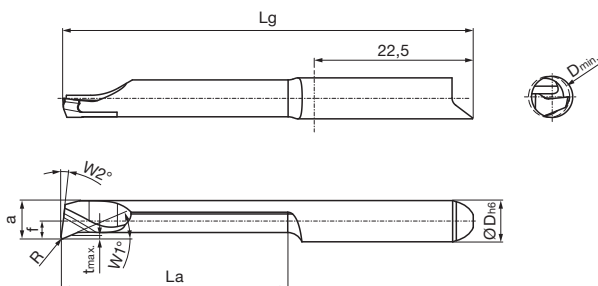


• radial free 23°

for tool holders type GH108/GB108 see from page 124

**GUHRING NAVIGATOR**

Cutting data page 184



Right hand version shown  
Left hand version mirror image



System 108

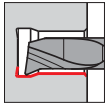
Article no.	<b>27200</b>	<b>27202</b>
Cutting direction		

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
8.120	GT108.2377.010.17.80.R	8.00	0.10	23	8	3.70	7.70	0.60	17.00	42.00	8.00
8.140	GT108.2377.010.27.80.R	8.00	0.10	23	8	3.70	7.70	0.60	27.00	52.00	8.00
8.160	GT108.2377.010.37.80.R	8.00	0.10	23	8	3.70	7.70	0.60	37.00	62.00	8.00
8.170	GT108.2377.010.42.80.R	8.00	0.10	23	8	3.70	7.70	0.60	42.00	67.00	8.00
8.180	GT108.2377.010.47.80.R	8.00	0.10	23	8	3.70	7.70	0.60	47.00	72.00	8.00
8.190	GT108.2377.010.52.80.R	8.00	0.10	23	8	3.70	7.70	0.60	52.00	77.00	8.00
8.320	GT108.2377.020.17.80.R	8.00	0.20	23	8	3.70	7.70	0.60	17.00	42.00	8.00
8.340	GT108.2377.020.27.80.R	8.00	0.20	23	8	3.70	7.70	0.60	27.00	52.00	8.00
8.360	GT108.2377.020.37.80.R	8.00	0.20	23	8	3.70	7.70	0.60	37.00	62.00	8.00
8.370	GT108.2377.020.42.80.R	8.00	0.20	23	8	3.70	7.70	0.60	42.00	67.00	8.00
8.380	GT108.2377.020.47.80.R	8.00	0.20	23	8	3.70	7.70	0.60	47.00	72.00	8.00
8.390	GT108.2377.020.52.80.R	8.00	0.20	23	8	3.70	7.70	0.60	52.00	77.00	8.00

Article no.	<b>27201</b>	<b>27203</b>
Cutting direction		

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
8.120	GT108.2377.010.17.80.L	8.00	0.10	23	8	3.70	7.70	0.60	17.00	42.00	8.00
8.140	GT108.2377.010.27.80.L	8.00	0.10	23	8	3.70	7.70	0.60	27.00	52.00	8.00
8.160	GT108.2377.010.37.80.L	8.00	0.10	23	8	3.70	7.70	0.60	37.00	62.00	8.00
8.170	GT108.2377.010.42.80.L	8.00	0.10	23	8	3.70	7.70	0.60	42.00	67.00	8.00
8.180	GT108.2377.010.47.80.L	8.00	0.10	23	8	3.70	7.70	0.60	47.00	72.00	8.00
8.190	GT108.2377.010.52.80.L	8.00	0.10	23	8	3.70	7.70	0.60	52.00	77.00	8.00
8.320	GT108.2377.020.17.80.L	8.00	0.20	23	8	3.70	7.70	0.60	17.00	42.00	8.00
8.340	GT108.2377.020.27.80.L	8.00	0.20	23	8	3.70	7.70	0.60	27.00	52.00	8.00
8.360	GT108.2377.020.37.80.L	8.00	0.20	23	8	3.70	7.70	0.60	37.00	62.00	8.00
8.370	GT108.2377.020.42.80.L	8.00	0.20	23	8	3.70	7.70	0.60	42.00	67.00	8.00
8.380	GT108.2377.020.47.80.L	8.00	0.20	23	8	3.70	7.70	0.60	47.00	72.00	8.00
8.390	GT108.2377.020.52.80.L	8.00	0.20	23	8	3.70	7.70	0.60	52.00	77.00	8.00

**Cutting insert for boring out and profiling**



- radial free 47°, tmax 0.8

Tool material **Solid carbide**

Type GT 108 GT 108

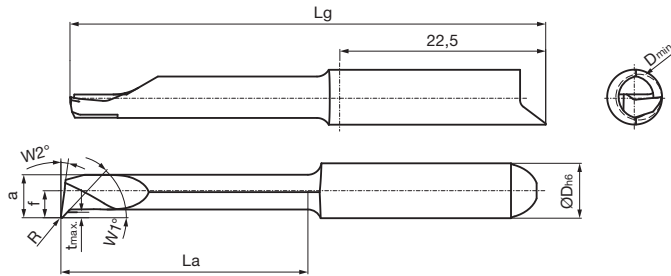
Surface **a** ○

TiAlN-nanoA bright

for tool holders type GH108/GB108 see from page 124

**GUHRING NAVIGATOR**

Cutting data page 184



Right hand version shown  
Left hand version mirror image

Article no. **27104** **27106**

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
8.120	GT108.4767.010.17.70.R	7.00	0.10	47	8	3.95	6.70	0.80	17.00	42.00	8.00
8.140	GT108.4767.010.27.70.R	7.00	0.10	47	8	3.95	6.70	0.80	27.00	52.00	8.00
8.160	GT108.4767.010.37.70.R	7.00	0.10	47	8	3.95	6.70	0.80	37.00	62.00	8.00
8.170	GT108.4767.010.42.70.R	7.00	0.10	47	8	3.95	6.70	0.80	42.00	67.00	8.00
8.180	GT108.4767.010.47.70.R	7.00	0.10	47	8	3.95	6.70	0.80	47.00	72.00	8.00
8.320	GT108.4767.020.17.70.R	7.00	0.20	47	8	3.95	6.70	0.80	17.00	42.00	8.00
8.340	GT108.4767.020.27.70.R	7.00	0.20	47	8	3.95	6.70	0.80	27.00	52.00	8.00
8.360	GT108.4767.020.37.70.R	7.00	0.20	47	8	3.95	6.70	0.80	37.00	62.00	8.00
8.370	GT108.4767.020.42.70.R	7.00	0.20	47	8	3.95	6.70	0.80	42.00	67.00	8.00
8.380	GT108.4767.020.47.70.R	7.00	0.20	47	8	3.95	6.70	0.80	47.00	72.00	8.00

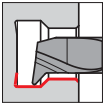
Article no. **27105** **27107**

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
8.120	GT108.4767.010.17.70.L	7.00	0.10	47	8	3.95	6.70	0.80	17.00	42.00	8.00
8.140	GT108.4767.010.27.70.L	7.00	0.10	47	8	3.95	6.70	0.80	27.00	52.00	8.00
8.160	GT108.4767.010.37.70.L	7.00	0.10	47	8	3.95	6.70	0.80	37.00	62.00	8.00
8.170	GT108.4767.010.42.70.L	7.00	0.10	47	8	3.95	6.70	0.80	42.00	67.00	8.00
8.180	GT108.4767.010.47.70.L	7.00	0.10	47	8	3.95	6.70	0.80	47.00	72.00	8.00
8.320	GT108.4767.020.17.70.L	7.00	0.20	47	8	3.95	6.70	0.80	17.00	42.00	8.00
8.340	GT108.4767.020.27.70.L	7.00	0.20	47	8	3.95	6.70	0.80	27.00	52.00	8.00
8.360	GT108.4767.020.37.70.L	7.00	0.20	47	8	3.95	6.70	0.80	37.00	62.00	8.00
8.370	GT108.4767.020.42.70.L	7.00	0.20	47	8	3.95	6.70	0.80	42.00	67.00	8.00
8.380	GT108.4767.020.47.70.L	7.00	0.20	47	8	3.95	6.70	0.80	47.00	72.00	8.00



**Cutting insert for boring out and profiling**



• radial free 47°, tmax 1

Tool material **Solid carbide**

Type GT 108 GT 108

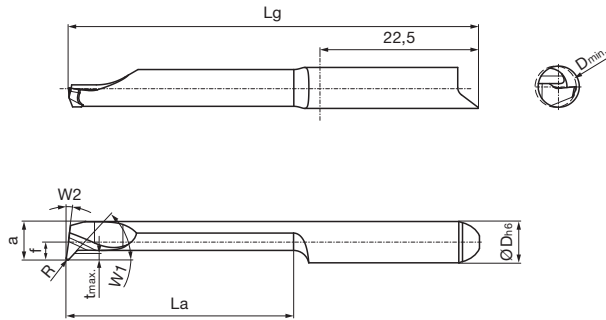
Surface **a** ○

TiAlN-nanoA bright

for tool holders type GH108/GB108 see from page 124

**GUHRING NAVIGATOR**

Cutting data page 184



Right hand version shown  
Left hand version mirror image



System 108

Article no. **27204** **27206**

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

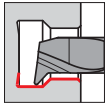
Article no. **27205** **27207**

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



**Cutting insert for boring out and profiling**



• radial free 47°, tmax 2

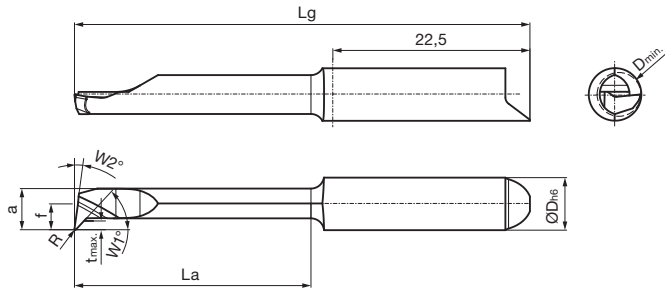
for tool holders type GH108/GB108 see from page 124

**GUHRING NAVIGATOR**

Cutting data page 184

Tool material	Solid carbide	
Type	GT 108	GT 108
Surface		
	TiAlN-nanoA	bright

System 108



Right hand version shown  
Left hand version mirror image

Article no.	<b>27108</b>	<b>27110</b>
Cutting direction		

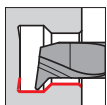
Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
8.120	GT108.4767.010.17.70.R	7.00	0.10	47	8	3.95	6.70	2.00	17.00	42.00	8.00
8.140	GT108.4767.010.27.70.R	7.00	0.10	47	8	3.95	6.70	2.00	27.00	52.00	8.00
8.160	GT108.4767.010.37.70.R	7.00	0.10	47	8	3.95	6.70	2.00	37.00	62.00	8.00
8.170	GT108.4767.010.42.70.R	7.00	0.10	47	8	3.95	6.70	2.00	42.00	67.00	8.00
8.320	GT108.4767.020.17.70.R	7.00	0.20	47	8	3.95	6.70	2.00	17.00	42.00	8.00
8.340	GT108.4767.020.27.70.R	7.00	0.20	47	8	3.95	6.70	2.00	27.00	52.00	8.00
8.360	GT108.4767.020.37.70.R	7.00	0.20	47	8	3.95	6.70	2.00	37.00	62.00	8.00
8.370	GT108.4767.020.42.70.R	7.00	0.20	47	8	3.95	6.70	2.00	42.00	67.00	8.00

Article no.	<b>27109</b>	<b>27111</b>
Cutting direction		

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
8.120	GT108.4767.010.17.70.L	7.00	0.10	47	8	3.95	6.70	2.00	17.00	42.00	8.00
8.140	GT108.4767.010.27.70.L	7.00	0.10	47	8	3.95	6.70	2.00	27.00	52.00	8.00
8.160	GT108.4767.010.37.70.L	7.00	0.10	47	8	3.95	6.70	2.00	37.00	62.00	8.00
8.170	GT108.4767.010.42.70.L	7.00	0.10	47	8	3.95	6.70	2.00	42.00	67.00	8.00
8.320	GT108.4767.020.17.70.L	7.00	0.20	47	8	3.95	6.70	2.00	17.00	42.00	8.00
8.340	GT108.4767.020.27.70.L	7.00	0.20	47	8	3.95	6.70	2.00	27.00	52.00	8.00
8.360	GT108.4767.020.37.70.L	7.00	0.20	47	8	3.95	6.70	2.00	37.00	62.00	8.00
8.370	GT108.4767.020.42.70.L	7.00	0.20	47	8	3.95	6.70	2.00	42.00	67.00	8.00



**Cutting insert for boring out and profiling**



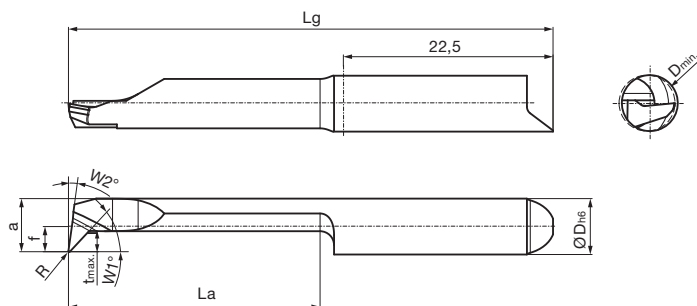
• radial free 47°, tmax 2.5

for tool holders type GH108/GB108 see from page 124

**GUHRING NAVIGATOR**

Cutting data page 184

Tool material	Solid carbide	
Type	GT 108	GT 108
Surface		
	TiAlN-nanoA	bright



Right hand version shown  
Left hand version mirror image



System 108

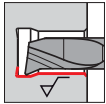
Article no.	<b>27208</b>	<b>27210</b>
Cutting direction		

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
8.120	GT108.4777.010.17.80.R	8.00	0.10	47	8	3.70	7.70	2.50	17.00	42.00	8.00
8.140	GT108.4777.010.27.80.R	8.00	0.10	47	8	3.70	7.70	2.50	27.00	52.00	8.00
8.160	GT108.4777.010.37.80.R	8.00	0.10	47	8	3.70	7.70	2.50	37.00	62.00	8.00
8.170	GT108.4777.010.42.80.R	8.00	0.10	47	8	3.70	7.70	2.50	42.00	72.00	8.00
8.320	GT108.4777.020.17.80.R	8.00	0.20	47	8	3.70	7.70	2.50	17.00	42.00	8.00
8.340	GT108.4777.020.27.80.R	8.00	0.20	47	8	3.70	7.70	2.50	27.00	52.00	8.00
8.360	GT108.4777.020.37.80.R	8.00	0.20	47	8	3.70	7.70	2.50	37.00	62.00	8.00
8.370	GT108.4777.020.42.80.R	8.00	0.20	47	8	3.70	7.70	2.50	42.00	72.00	8.00

Article no.	<b>27209</b>	<b>27211</b>
Cutting direction		

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
8.120	GT108.4777.010.17.80.L	8.00	0.10	47	8	3.70	7.70	2.50	17.00	42.00	8.00
8.140	GT108.4777.010.27.80.L	8.00	0.10	47	8	3.70	7.70	2.50	27.00	52.00	8.00
8.160	GT108.4777.010.37.80.L	8.00	0.10	47	8	3.70	7.70	2.50	37.00	62.00	8.00
8.170	GT108.4777.010.42.80.L	8.00	0.10	47	8	3.70	7.70	2.50	42.00	72.00	8.00
8.320	GT108.4777.020.17.80.L	8.00	0.20	47	8	3.70	7.70	2.50	17.00	42.00	8.00
8.340	GT108.4777.020.27.80.L	8.00	0.20	47	8	3.70	7.70	2.50	27.00	52.00	8.00
8.360	GT108.4777.020.37.80.L	8.00	0.20	47	8	3.70	7.70	2.50	37.00	62.00	8.00
8.370	GT108.4777.020.42.80.L	8.00	0.20	47	8	3.70	7.70	2.50	42.00	72.00	8.00

**Cutting insert for boring out and profiling**



• WIPER-geometry

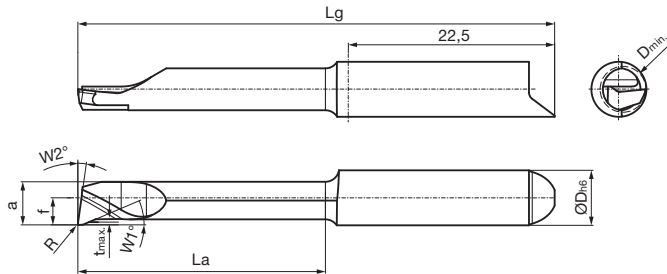
for tool holders type GH108/GB108 see from page 124

**GUHRING NAVIGATOR**

Cutting data page 184

Tool material	Solid carbide	
Type	GJ 108	GJ 108
Surface		
	TiAlN-nanoA	bright

System 108



Right hand version shown  
Left hand version mirror image

Article no.	<b>27116</b>	<b>27118</b>
Cutting direction		

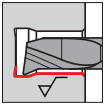
Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
8.120	GJ108.2367.010.17.70.R	7.00	0.10	23	8	3.95	6.70	0.50	17.00	42.00	8.00
8.140	GJ108.2367.010.27.70.R	7.00	0.10	23	8	3.95	6.70	0.50	27.00	52.00	8.00
8.160	GJ108.2367.010.37.70.R	7.00	0.10	23	8	3.95	6.70	0.50	37.00	62.00	8.00
8.170	GJ108.2367.010.42.70.R	7.00	0.10	23	8	3.95	6.70	0.50	42.00	67.00	8.00
8.180	GJ108.2367.010.47.70.R	7.00	0.10	23	8	3.95	6.70	0.50	47.00	72.00	8.00
8.190	GJ108.2367.010.52.70.R	7.00	0.10	23	8	3.95	6.70	0.50	52.00	77.00	8.00
8.320	GJ108.2367.020.17.70.R	7.00	0.20	23	8	3.95	6.70	0.50	17.00	42.00	8.00
8.340	GJ108.2367.020.27.70.R	7.00	0.20	23	8	3.95	6.70	0.50	27.00	52.00	8.00
8.360	GJ108.2367.020.37.70.R	7.00	0.20	23	8	3.95	6.70	0.50	37.00	62.00	8.00
8.370	GJ108.2367.020.42.70.R	7.00	0.20	23	8	3.95	6.70	0.50	42.00	67.00	8.00
8.380	GJ108.2367.020.47.70.R	7.00	0.20	23	8	3.95	6.70	0.50	47.00	72.00	8.00
8.390	GJ108.2367.020.52.70.R	7.00	0.20	23	8	3.95	6.70	0.50	52.00	77.00	8.00

Article no.	<b>27117</b>	<b>27119</b>
Cutting direction		

Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
8.120	GJ108.2367.010.17.70.L	7.00	0.10	23	8	3.95	6.70	0.50	17.00	42.00	8.00
8.140	GJ108.2367.010.27.70.L	7.00	0.10	23	8	3.95	6.70	0.50	27.00	52.00	8.00
8.160	GJ108.2367.010.37.70.L	7.00	0.10	23	8	3.95	6.70	0.50	37.00	62.00	8.00
8.170	GJ108.2367.010.42.70.L	7.00	0.10	23	8	3.95	6.70	0.50	42.00	67.00	8.00
8.180	GJ108.2367.010.47.70.L	7.00	0.10	23	8	3.95	6.70	0.50	47.00	72.00	8.00
8.190	GJ108.2367.010.52.70.L	7.00	0.10	23	8	3.95	6.70	0.50	52.00	77.00	8.00
8.320	GJ108.2367.020.17.70.L	7.00	0.20	23	8	3.95	6.70	0.50	17.00	42.00	8.00
8.340	GJ108.2367.020.27.70.L	7.00	0.20	23	8	3.95	6.70	0.50	27.00	52.00	8.00
8.360	GJ108.2367.020.37.70.L	7.00	0.20	23	8	3.95	6.70	0.50	37.00	62.00	8.00
8.370	GJ108.2367.020.42.70.L	7.00	0.20	23	8	3.95	6.70	0.50	42.00	67.00	8.00
8.380	GJ108.2367.020.47.70.L	7.00	0.20	23	8	3.95	6.70	0.50	47.00	72.00	8.00
8.390	GJ108.2367.020.52.70.L	7.00	0.20	23	8	3.95	6.70	0.50	52.00	77.00	8.00



**Cutting insert for boring out and profiling**



• WIPER-geometry

Tool material **Solid carbide**

Type GJ 108 GJ 108

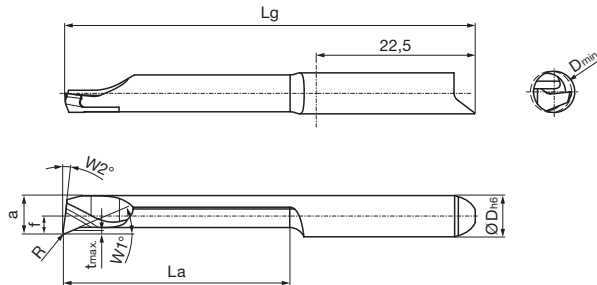
Surface **a** ○

TiAlN-nanoA bright

for tool holders type GH108/GB108 see from page 124

**GUHRING NAVIGATOR**

Cutting data page 184



System 108

Right hand version shown  
Left hand version mirror image

Article no. **27216** **27218**

Cutting direction **R** **R**

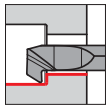
Code no.	Description	D min	R	W1	W2	f	a	t max	La	Lg	D h6
		mm	mm	°	°	mm	mm	mm	mm	mm	mm
8.120	GJ108.2377.010.17.80.R	8.00	0.10	23	8	3.70	7.70	0.60	17.00	42.00	8.00
8.140	GJ108.2377.010.27.80.R	8.00	0.10	23	8	3.70	7.70	0.60	27.00	52.00	8.00
8.160	GJ108.2377.010.37.80.R	8.00	0.10	23	8	3.70	7.70	0.60	37.00	62.00	8.00
8.170	GJ108.2377.010.42.80.R	8.00	0.10	23	8	3.70	7.70	0.60	42.00	67.00	8.00
8.180	GJ108.2377.010.47.80.R	8.00	0.10	23	8	3.70	7.70	0.60	47.00	72.00	8.00
8.190	GJ108.2377.010.52.80.R	8.00	0.10	23	8	3.70	7.70	0.60	52.00	77.00	8.00
8.320	GJ108.2377.020.17.80.R	8.00	0.20	23	8	3.70	7.70	0.60	17.00	42.00	8.00
8.340	GJ108.2377.020.27.80.R	8.00	0.20	23	8	3.70	7.70	0.60	27.00	52.00	8.00
8.360	GJ108.2377.020.37.80.R	8.00	0.20	23	8	3.70	7.70	0.60	37.00	62.00	8.00
8.370	GJ108.2377.020.42.80.R	8.00	0.20	23	8	3.70	7.70	0.60	42.00	67.00	8.00
8.380	GJ108.2377.020.47.80.R	8.00	0.20	23	8	3.70	7.70	0.60	47.00	72.00	8.00
8.390	GJ108.2377.020.52.80.R	8.00	0.20	23	8	3.70	7.70	0.60	52.00	77.00	8.00

Article no. **27217** **27219**

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
8.120	GJ108.2377.010.17.80.L	8.00	0.10	23	8	3.70	7.70	0.60	17.00	42.00	8.00
8.140	GJ108.2377.010.27.80.L	8.00	0.10	23	8	3.70	7.70	0.60	27.00	52.00	8.00
8.160	GJ108.2377.010.37.80.L	8.00	0.10	23	8	3.70	7.70	0.60	37.00	62.00	8.00
8.170	GJ108.2377.010.42.80.L	8.00	0.10	23	8	3.70	7.70	0.60	42.00	67.00	8.00
8.180	GJ108.2377.010.47.80.L	8.00	0.10	23	8	3.70	7.70	0.60	47.00	72.00	8.00
8.190	GJ108.2377.010.52.80.L	8.00	0.10	23	8	3.70	7.70	0.60	52.00	77.00	8.00
8.320	GJ108.2377.020.17.80.L	8.00	0.20	23	8	3.70	7.70	0.60	17.00	42.00	8.00
8.340	GJ108.2377.020.27.80.L	8.00	0.20	23	8	3.70	7.70	0.60	27.00	52.00	8.00
8.360	GJ108.2377.020.37.80.L	8.00	0.20	23	8	3.70	7.70	0.60	37.00	62.00	8.00
8.370	GJ108.2377.020.42.80.L	8.00	0.20	23	8	3.70	7.70	0.60	42.00	67.00	8.00
8.380	GJ108.2377.020.47.80.L	8.00	0.20	23	8	3.70	7.70	0.60	47.00	72.00	8.00
8.390	GJ108.2377.020.52.80.L	8.00	0.20	23	8	3.70	7.70	0.60	52.00	77.00	8.00

**Cutting insert for back boring and profiling**



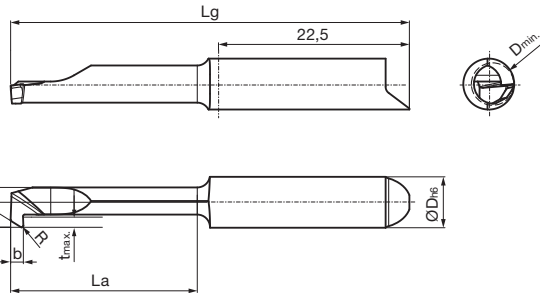
• radial free 32°

for tool holders type GH108/GB108 see from page 124

**GUHRING NAVIGATOR**

Cutting data page 184

Tool material	Solid carbide	
Type	GT 108	GT 108
Surface		
	TiAlN-nanoA	bright



Right hand version shown  
Left hand version mirror image

Article no.	<b>27120</b>	<b>27122</b>
Cutting direction		

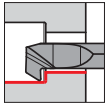
Code no.	Description	D min	R	W1	f	a	t max	La	Lg	D h6
		mm	mm	°	mm	mm	mm	mm	mm	mm
8.010	GT108.3267.020.17.70.R	7.00	0.20	32	3.95	6.70	1.80	17.00	42.00	8.00
8.020	GT108.3267.020.27.70.R	7.00	0.20	32	3.95	6.70	1.80	27.00	52.00	8.00
8.030	GT108.3267.020.37.70.R	7.00	0.20	32	3.95	6.70	1.80	37.00	62.00	8.00
8.040	GT108.3267.020.42.70.R	7.00	0.20	32	3.95	6.70	1.80	42.00	67.00	8.00
8.050	GT108.3267.020.47.70.R	7.00	0.20	32	3.95	6.70	1.80	47.00	72.00	8.00
8.060	GT108.3267.020.52.70.R	7.00	0.20	32	3.95	6.70	1.80	52.00	77.00	8.00

Article no.	<b>27121</b>	<b>27123</b>
Cutting direction		

Code no.	Description	D min	R	W1	f	a	t max	La	Lg	D h6
		mm	mm	°	mm	mm	mm	mm	mm	mm
8.010	GT108.3267.020.17.70.L	7.00	0.20	32	3.95	6.70	1.80	17.00	42.00	8.00
8.020	GT108.3267.020.27.70.L	7.00	0.20	32	3.95	6.70	1.80	27.00	52.00	8.00
8.030	GT108.3267.020.37.70.L	7.00	0.20	32	3.95	6.70	1.80	37.00	62.00	8.00
8.040	GT108.3267.020.42.70.L	7.00	0.20	32	3.95	6.70	1.80	42.00	67.00	8.00
8.050	GT108.3267.020.47.70.L	7.00	0.20	32	3.95	6.70	1.80	47.00	72.00	8.00
8.060	GT108.3267.020.52.70.L	7.00	0.20	32	3.95	6.70	1.80	52.00	77.00	8.00



**Cutting insert for back boring and profiling**



• radial free 32°

Tool material **Solid carbide**

Type GT 108 GT 108

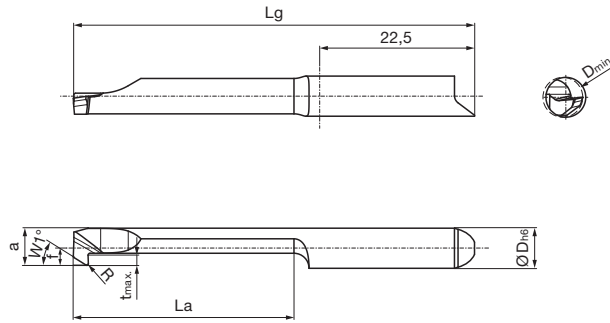
Surface **a** ○

TiAlN-nanoA bright

for tool holders type GH108/GB108 see from page 124

**GUHRING NAVIGATOR**

Cutting data page 184



Right hand version shown  
Left hand version mirror image



System 108

Article no. **27220** **27222**

Cutting direction **R** **R**

Code no.	Description	D min	R	W1	f	a	t max	La	Lg	D h6
		mm	mm	°	mm	mm	mm	mm	mm	mm
8.010	GT108.3277.020.17.80.R	8.00	0.20	32	3.70	7.70	2.20	17.00	42.00	8.00
8.020	GT108.3277.020.27.80.R	8.00	0.20	32	3.70	7.70	2.20	27.00	52.00	8.00
8.030	GT108.3277.020.37.80.R	8.00	0.20	32	3.70	7.70	2.20	37.00	62.00	8.00
8.040	GT108.3277.020.42.80.R	8.00	0.20	32	3.70	7.70	2.20	42.00	67.00	8.00
8.050	GT108.3277.020.47.80.R	8.00	0.20	32	3.70	7.70	2.20	47.00	72.00	8.00
8.060	GT108.3277.020.52.80.R	8.00	0.20	32	3.70	7.70	2.20	52.00	77.00	8.00

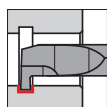
Article no. **27221** **27223**

Cutting direction **L** **L**

Code no.	Description	D min	R	W1	f	a	t max	La	Lg	D h6
		mm	mm	°	mm	mm	mm	mm	mm	mm
8.010	GT108.3277.020.17.80.L	8.00	0.20	32	3.70	7.70	2.20	17.00	42.00	8.00
8.020	GT108.3277.020.27.80.L	8.00	0.20	32	3.70	7.70	2.20	27.00	52.00	8.00
8.030	GT108.3277.020.37.80.L	8.00	0.20	32	3.70	7.70	2.20	37.00	62.00	8.00
8.040	GT108.3277.020.42.80.L	8.00	0.20	32	3.70	7.70	2.20	42.00	67.00	8.00
8.050	GT108.3277.020.47.80.L	8.00	0.20	32	3.70	7.70	2.20	47.00	72.00	8.00
8.060	GT108.3277.020.52.80.L	8.00	0.20	32	3.70	7.70	2.20	52.00	77.00	8.00



**Cutting insert for internal grooving, straight slots**



- grooving depth up to 2.5 mm

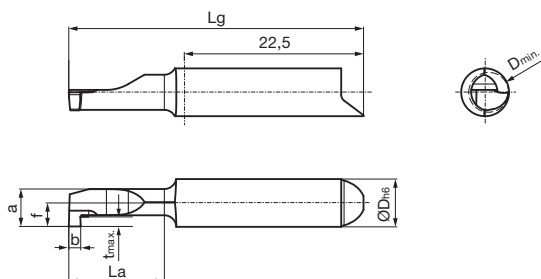
for tool holders type GH108/GB108 see from page 124

**GUHRING NAVIGATOR**

Cutting data page 184

Tool material	Solid carbide	
Type	GE 108	GE 108
Surface		
	TiAlN-nanoA	bright

System 108




Right hand version shown  
Left hand version mirror image

Article no.	<b>27124</b>	<b>27126</b>
Cutting direction		

Code no.	Description	D min	b	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
8.010	GE108.0150.000.17.70.R	7.00	1.50	3.95	6.70	2.50	17.00	42.00	8.00
8.020	GE108.0150.000.27.70.R	7.00	1.50	3.95	6.70	2.50	27.00	52.00	8.00
8.030	GE108.0150.000.37.70.R	7.00	1.50	3.95	6.70	2.50	37.00	62.00	8.00
8.040	GE108.0150.000.42.70.R	7.00	1.50	3.95	6.70	2.50	42.00	67.00	8.00
8.050	GE108.0150.000.47.70.R	7.00	1.50	3.95	6.70	2.50	47.00	72.00	8.00
8.110	GE108.0200.000.17.70.R	7.00	2.00	3.95	6.70	2.50	17.00	42.00	8.00
8.120	GE108.0200.000.27.70.R	7.00	2.00	3.95	6.70	2.50	27.00	52.00	8.00
8.130	GE108.0200.000.37.70.R	7.00	2.00	3.95	6.70	2.50	37.00	62.00	8.00
8.140	GE108.0200.000.42.70.R	7.00	2.00	3.95	6.70	2.50	42.00	67.00	8.00
8.150	GE108.0200.000.47.70.R	7.00	2.00	3.95	6.70	2.50	47.00	72.00	8.00
8.210	GE108.0250.000.17.70.R	7.00	2.50	3.95	6.70	2.50	17.00	42.00	8.00
8.220	GE108.0250.000.27.70.R	7.00	2.50	3.95	6.70	2.50	27.00	52.00	8.00
8.230	GE108.0250.000.37.70.R	7.00	2.50	3.95	6.70	2.50	37.00	62.00	8.00
8.240	GE108.0250.000.42.70.R	7.00	2.50	3.95	6.70	2.50	42.00	67.00	8.00
8.250	GE108.0250.000.47.70.R	7.00	2.50	3.95	6.70	2.50	47.00	72.00	8.00
8.310	GE108.0300.000.17.70.R	7.00	3.00	3.95	6.70	2.50	17.00	42.00	8.00
8.320	GE108.0300.000.27.70.R	7.00	3.00	3.95	6.70	2.50	27.00	52.00	8.00
8.330	GE108.0300.000.37.70.R	7.00	3.00	3.95	6.70	2.50	37.00	62.00	8.00
8.340	GE108.0300.000.42.70.R	7.00	3.00	3.95	6.70	2.50	42.00	67.00	8.00
8.350	GE108.0300.000.47.70.R	7.00	3.00	3.95	6.70	2.50	47.00	72.00	8.00

Article no.	<b>27125</b>	<b>27127</b>
Cutting direction		

Code no.	Description	D min	b	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
8.010	GE108.0150.000.17.70.L	7.00	1.50	3.95	6.70	2.50	17.00	42.00	8.00
8.020	GE108.0150.000.27.70.L	7.00	1.50	3.95	6.70	2.50	27.00	52.00	8.00
8.030	GE108.0150.000.37.70.L	7.00	1.50	3.95	6.70	2.50	37.00	62.00	8.00
8.040	GE108.0150.000.42.70.L	7.00	1.50	3.95	6.70	2.50	42.00	67.00	8.00
8.050	GE108.0150.000.47.70.L	7.00	1.50	3.95	6.70	2.50	47.00	72.00	8.00
8.110	GE108.0200.000.17.70.L	7.00	2.00	3.95	6.70	2.50	17.00	42.00	8.00

Article no. **27125** **27127**Cutting direction  

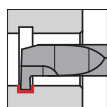
Code no.	Description	D min	b	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
8.120	GE108.0200.000.27.70.L	7.00	2.00	3.95	6.70	2.50	27.00	52.00	8.00
8.130	GE108.0200.000.37.70.L	7.00	2.00	3.95	6.70	2.50	37.00	62.00	8.00
8.140	GE108.0200.000.42.70.L	7.00	2.00	3.95	6.70	2.50	42.00	67.00	8.00
8.150	GE108.0200.000.47.70.L	7.00	2.00	3.95	6.70	2.50	47.00	72.00	8.00
8.210	GE108.0250.000.17.70.L	7.00	2.50	3.95	6.70	2.50	17.00	42.00	8.00
8.220	GE108.0250.000.27.70.L	7.00	2.50	3.95	6.70	2.50	27.00	52.00	8.00
8.230	GE108.0250.000.37.70.L	7.00	2.50	3.95	6.70	2.50	37.00	62.00	8.00
8.240	GE108.0250.000.42.70.L	7.00	2.50	3.95	6.70	2.50	42.00	67.00	8.00
8.250	GE108.0250.000.47.70.L	7.00	2.50	3.95	6.70	2.50	47.00	72.00	8.00
8.310	GE108.0300.000.17.70.L	7.00	3.00	3.95	6.70	2.50	17.00	42.00	8.00
8.320	GE108.0300.000.27.70.L	7.00	3.00	3.95	6.70	2.50	27.00	52.00	8.00
8.330	GE108.0300.000.37.70.L	7.00	3.00	3.95	6.70	2.50	37.00	62.00	8.00
8.340	GE108.0300.000.42.70.L	7.00	3.00	3.95	6.70	2.50	42.00	67.00	8.00
8.350	GE108.0300.000.47.70.L	7.00	3.00	3.95	6.70	2.50	47.00	72.00	8.00

System 108





**Cutting insert for internal grooving, straight slots**



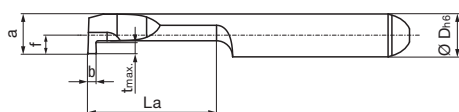
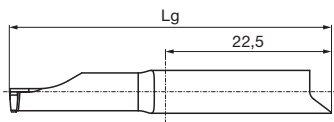
- grooving depth up to 3 mm

for tool holders type GH108/GB108 see from page 124

**GUHRING NAVIGATOR**

Cutting data page 184

Tool material	Solid carbide	
Type	GE 108	GE 108
Surface		
	TiAlN-nanoA	bright



Right hand version shown  
Left hand version mirror image



System 108

Article no.	<b>27224</b>	<b>27225</b>
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Cutting direction

Code no.	Description	D min	b	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
8.010	GE108.0150.000.17.80.R	8.00	1.50	3.70	7.70	3.00	17.00	42.00	8.00
8.020	GE108.0150.000.27.80.R	8.00	1.50	3.70	7.70	3.00	27.00	52.00	8.00
8.030	GE108.0150.000.37.80.R	8.00	1.50	3.70	7.70	3.00	37.00	62.00	8.00
8.040	GE108.0150.000.42.80.R	8.00	1.50	3.70	7.70	3.00	42.00	67.00	8.00
8.050	GE108.0150.000.47.80.R	8.00	1.50	3.70	7.70	3.00	47.00	72.00	8.00
8.110	GE108.0200.000.17.80.R	8.00	2.00	3.70	7.70	3.00	17.00	42.00	8.00
8.120	GE108.0200.000.27.80.R	8.00	2.00	3.70	7.70	3.00	27.00	52.00	8.00
8.130	GE108.0200.000.37.80.R	8.00	2.00	3.70	7.70	3.00	37.00	62.00	8.00
8.140	GE108.0200.000.42.80.R	8.00	2.00	3.70	7.70	3.00	42.00	67.00	8.00
8.150	GE108.0200.000.47.80.R	8.00	2.00	3.70	7.70	3.00	47.00	72.00	8.00
8.210	GE108.0250.000.17.80.R	8.00	2.50	3.70	7.70	3.00	17.00	42.00	8.00
8.220	GE108.0250.000.27.80.R	8.00	2.50	3.70	7.70	3.00	27.00	52.00	8.00
8.230	GE108.0250.000.37.80.R	8.00	2.50	3.70	7.70	3.00	37.00	62.00	8.00
8.240	GE108.0250.000.42.80.R	8.00	2.50	3.70	7.70	3.00	42.00	67.00	8.00
8.250	GE108.0250.000.47.80.R	8.00	2.50	3.70	7.70	3.00	47.00	72.00	8.00
8.310	GE108.0300.000.17.80.R	8.00	3.00	3.70	7.70	3.00	17.00	42.00	8.00
8.320	GE108.0300.000.27.80.R	8.00	3.00	3.70	7.70	3.00	27.00	52.00	8.00
8.330	GE108.0300.000.37.80.R	8.00	3.00	3.70	7.70	3.00	37.00	62.00	8.00
8.340	GE108.0300.000.42.80.R	8.00	3.00	3.70	7.70	3.00	42.00	67.00	8.00
8.350	GE108.0300.000.47.80.R	8.00	3.00	3.70	7.70	3.00	47.00	72.00	8.00

Article no.	<b>27226</b>	<b>27227</b>
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Cutting direction

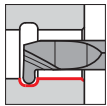
Code no.	Description	D min	b	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
8.010	GE108.0150.000.17.80.L	8.00	1.50	3.70	7.70	3.00	17.00	42.00	8.00
8.020	GE108.0150.000.27.80.L	8.00	1.50	3.70	7.70	3.00	27.00	52.00	8.00
8.030	GE108.0150.000.37.80.L	8.00	1.50	3.70	7.70	3.00	37.00	62.00	8.00
8.040	GE108.0150.000.42.80.L	8.00	1.50	3.70	7.70	3.00	42.00	67.00	8.00
8.050	GE108.0150.000.47.80.L	8.00	1.50	3.70	7.70	3.00	47.00	72.00	8.00
8.110	GE108.0200.000.17.80.L	8.00	2.00	3.70	7.70	3.00	17.00	42.00	8.00

Article no. **27226** **27227**Cutting direction  

Code no.	Description	D min	b	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm
8.120	GE108.0200.000.27.80.L	8.00	2.00	3.70	7.70	3.00	27.00	52.00	8.00
8.130	GE108.0200.000.37.80.L	8.00	2.00	3.70	7.70	3.00	37.00	62.00	8.00
8.140	GE108.0200.000.42.80.L	8.00	2.00	3.70	7.70	3.00	42.00	67.00	8.00
8.150	GE108.0200.000.47.80.L	8.00	2.00	3.70	7.70	3.00	47.00	72.00	8.00
8.210	GE108.0250.000.17.80.L	8.00	2.50	3.70	7.70	3.00	17.00	42.00	8.00
8.220	GE108.0250.000.27.80.L	8.00	2.50	3.70	7.70	3.00	27.00	52.00	8.00
8.230	GE108.0250.000.37.80.L	8.00	2.50	3.70	7.70	3.00	37.00	62.00	8.00
8.240	GE108.0250.000.42.80.L	8.00	2.50	3.70	7.70	3.00	42.00	67.00	8.00
8.250	GE108.0250.000.47.80.L	8.00	2.50	3.70	7.70	3.00	47.00	72.00	8.00
8.310	GE108.0300.000.17.80.L	8.00	3.00	3.70	7.70	3.00	17.00	42.00	8.00
8.320	GE108.0300.000.27.80.L	8.00	3.00	3.70	7.70	3.00	27.00	52.00	8.00
8.330	GE108.0300.000.37.80.L	8.00	3.00	3.70	7.70	3.00	37.00	62.00	8.00
8.340	GE108.0300.000.42.80.L	8.00	3.00	3.70	7.70	3.00	42.00	67.00	8.00
8.350	GE108.0300.000.47.80.L	8.00	3.00	3.70	7.70	3.00	47.00	72.00	8.00

System 108

**Cutting insert for internal grooving, full radius slots**



• full radius R0.75-R1.5

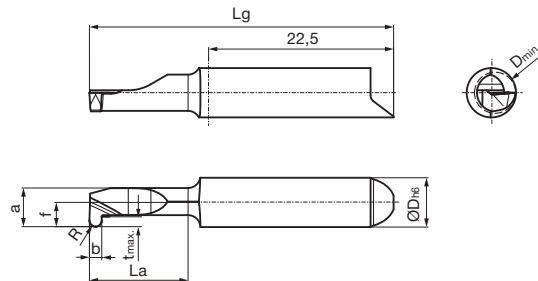
for tool holders type GH108/GB108 see from page 124

**GUHRING NAVIGATOR**

Cutting data page 184

Tool material	Solid carbide	
Type	GE 108	GE 108
Surface		
	TiAlN-nanoA	bright

System 108



Right hand version shown  
Left hand version mirror image

Article no.	<b>27128</b>	<b>27130</b>
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Cutting direction		
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Code no.	Description	D min	b	R	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm	mm
8.010	GE108.0150.075.17.70.R	7.00	1.50	0.75	3.95	6.70	2.50	17.00	42.00	8.00
8.020	GE108.0150.075.27.70.R	7.00	1.50	0.75	3.95	6.70	2.50	27.00	52.00	8.00
8.030	GE108.0150.075.37.70.R	7.00	1.50	0.75	3.95	6.70	2.50	37.00	62.00	8.00
8.040	GE108.0150.075.42.70.R	7.00	1.50	0.75	3.95	6.70	2.50	42.00	67.00	8.00
8.050	GE108.0150.075.47.70.R	7.00	1.50	0.75	3.95	6.70	2.50	47.00	72.00	8.00
8.110	GE108.0200.100.17.70.R	7.00	2.00	1.00	3.95	6.70	2.50	17.00	42.00	8.00
8.120	GE108.0200.100.27.70.R	7.00	2.00	1.00	3.95	6.70	2.50	27.00	52.00	8.00
8.130	GE108.0200.100.37.70.R	7.00	2.00	1.00	3.95	6.70	2.50	37.00	62.00	8.00
8.140	GE108.0200.100.42.70.R	7.00	2.00	1.00	3.95	6.70	2.50	42.00	67.00	8.00
8.150	GE108.0200.100.47.70.R	7.00	2.00	1.00	3.95	6.70	2.50	47.00	72.00	8.00
8.210	GE108.0250.125.17.70.R	7.00	2.50	1.25	3.95	6.70	2.50	17.00	42.00	8.00
8.220	GE108.0250.125.27.70.R	7.00	2.50	1.25	3.95	6.70	2.50	27.00	52.00	8.00
8.230	GE108.0250.125.37.70.R	7.00	2.50	1.25	3.95	6.70	2.50	37.00	62.00	8.00
8.240	GE108.0250.125.42.70.R	7.00	2.50	1.25	3.95	6.70	2.50	42.00	67.00	8.00
8.250	GE108.0250.125.47.70.R	7.00	2.50	1.25	3.95	6.70	2.50	47.00	72.00	8.00
8.310	GE108.0300.150.17.70.R	7.00	3.00	1.50	3.95	6.70	2.50	17.00	42.00	8.00
8.320	GE108.0300.150.27.70.R	7.00	3.00	1.50	3.95	6.70	2.50	27.00	52.00	8.00
8.330	GE108.0300.150.37.70.R	7.00	3.00	1.50	3.95	6.70	2.50	37.00	62.00	8.00
8.340	GE108.0300.150.42.70.R	7.00	3.00	1.50	3.95	6.70	2.50	42.00	67.00	8.00
8.350	GE108.0300.150.47.70.R	7.00	3.00	1.50	3.95	6.70	2.50	47.00	72.00	8.00

Article no.	<b>27129</b>	<b>27131</b>
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Cutting direction		
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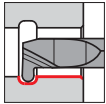
Code no.	Description	D min	b	R	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm	mm
8.010	GE108.0150.075.17.70.L	7.00	1.50	0.75	3.95	6.70	2.50	17.00	42.00	8.00
8.020	GE108.0150.075.27.70.L	7.00	1.50	0.75	3.95	6.70	2.50	27.00	52.00	8.00
8.030	GE108.0150.075.37.70.L	7.00	1.50	0.75	3.95	6.70	2.50	37.00	62.00	8.00
8.040	GE108.0150.075.42.70.L	7.00	1.50	0.75	3.95	6.70	2.50	42.00	67.00	8.00
8.050	GE108.0150.075.47.70.L	7.00	1.50	0.75	3.95	6.70	2.50	47.00	72.00	8.00
8.110	GE108.0200.100.17.70.L	7.00	2.00	1.00	3.95	6.70	2.50	17.00	42.00	8.00

Article no. **27129** **27131**Cutting direction  

Code no.	Description	D min	b	R	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm	mm
8.120	GE108.0200.100.27.70.L	7.00	2.00	1.00	3.95	6.70	2.50	27.00	52.00	8.00
8.130	GE108.0200.100.37.70.L	7.00	2.00	1.00	3.95	6.70	2.50	37.00	62.00	8.00
8.140	GE108.0200.100.42.70.L	7.00	2.00	1.00	3.95	6.70	2.50	42.00	67.00	8.00
8.150	GE108.0200.100.47.70.L	7.00	2.00	1.00	3.95	6.70	2.50	47.00	72.00	8.00
8.210	GE108.0250.125.17.70.L	7.00	2.50	1.25	3.95	6.70	2.50	17.00	42.00	8.00
8.220	GE108.0250.125.27.70.L	7.00	2.50	1.25	3.95	6.70	2.50	27.00	52.00	8.00
8.230	GE108.0250.125.37.70.L	7.00	2.50	1.25	3.95	6.70	2.50	37.00	62.00	8.00
8.240	GE108.0250.125.42.70.L	7.00	2.50	1.25	3.95	6.70	2.50	42.00	67.00	8.00
8.250	GE108.0250.125.47.70.L	7.00	2.50	1.25	3.95	6.70	2.50	47.00	72.00	8.00
8.310	GE108.0300.150.17.70.L	7.00	3.00	1.50	3.95	6.70	2.50	17.00	42.00	8.00
8.320	GE108.0300.150.27.70.L	7.00	3.00	1.50	3.95	6.70	2.50	27.00	52.00	8.00
8.330	GE108.0300.150.37.70.L	7.00	3.00	1.50	3.95	6.70	2.50	37.00	62.00	8.00
8.340	GE108.0300.150.42.70.L	7.00	3.00	1.50	3.95	6.70	2.50	42.00	67.00	8.00
8.350	GE108.0300.150.47.70.L	7.00	3.00	1.50	3.95	6.70	2.50	47.00	72.00	8.00

System 108

**Cutting insert for internal grooving, full radius slots**



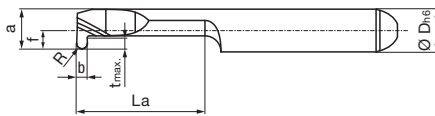
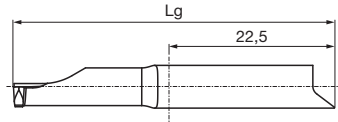
• full radius R0.75-R1.5

for tool holders type GH108/GB108 see from page 124

**GUHRING NAVIGATOR**

Cutting data page 184

Tool material	Solid carbide	
Type	GE 108	GE 108
Surface		
	TiAlN-nanoA	bright



Right hand version shown  
Left hand version mirror image

Article no. **27228** **27230**

Cutting direction

Code no.	Description	D min	b	R	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm	mm
8.010	GE108.0150.075.17.80.R	8.00	1.50	0.75	3.70	7.70	3.00	17.00	42.00	8.00
8.020	GE108.0150.075.27.80.R	8.00	1.50	0.75	3.70	7.70	3.00	27.00	52.00	8.00
8.030	GE108.0150.075.37.80.R	8.00	1.50	0.75	3.70	7.70	3.00	37.00	62.00	8.00
8.040	GE108.0150.075.42.80.R	8.00	1.50	0.75	3.70	7.70	3.00	42.00	67.00	8.00
8.050	GE108.0150.075.47.80.R	8.00	1.50	0.75	3.70	7.70	3.00	47.00	72.00	8.00
8.110	GE108.0200.100.17.80.R	8.00	2.00	1.00	3.70	7.70	3.00	17.00	42.00	8.00
8.120	GE108.0200.100.27.80.R	8.00	2.00	1.00	3.70	7.70	3.00	27.00	52.00	8.00
8.130	GE108.0200.100.37.80.R	8.00	2.00	1.00	3.70	7.70	3.00	37.00	62.00	8.00
8.140	GE108.0200.100.42.80.R	8.00	2.00	1.00	3.70	7.70	3.00	42.00	67.00	8.00
8.150	GE108.0200.100.47.80.R	8.00	2.00	1.00	3.70	7.70	3.00	47.00	72.00	8.00
8.210	GE108.0250.125.17.80.R	8.00	2.50	1.25	3.70	7.70	3.00	17.00	42.00	8.00
8.220	GE108.0250.125.27.80.R	8.00	2.50	1.25	3.70	7.70	3.00	27.00	52.00	8.00
8.230	GE108.0250.125.37.80.R	8.00	2.50	1.25	3.70	7.70	3.00	37.00	62.00	8.00
8.240	GE108.0250.125.42.80.R	8.00	2.50	1.25	3.70	7.70	3.00	42.00	67.00	8.00
8.250	GE108.0250.125.47.80.R	8.00	2.50	1.25	3.70	7.70	3.00	47.00	72.00	8.00
8.310	GE108.0300.150.17.80.R	8.00	3.00	1.50	3.70	7.70	3.00	17.00	42.00	8.00
8.320	GE108.0300.150.27.80.R	8.00	3.00	1.50	3.70	7.70	3.00	27.00	52.00	8.00
8.330	GE108.0300.150.37.80.R	8.00	3.00	1.50	3.70	7.70	3.00	37.00	62.00	8.00
8.340	GE108.0300.150.42.80.R	8.00	3.00	1.50	3.70	7.70	3.00	42.00	67.00	8.00
8.350	GE108.0300.150.47.70.R	8.00	3.00	1.50	3.70	7.70	3.00	47.00	72.00	8.00

Article no. **27229** **27231**

Cutting direction

Code no.	Description	D min	b	R	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm	mm
8.010	GE108.0150.075.17.80.L	8.00	1.50	0.75	3.70	7.70	3.00	17.00	42.00	8.00
8.020	GE108.0150.075.27.80.L	8.00	1.50	0.75	3.70	7.70	3.00	27.00	52.00	8.00
8.030	GE108.0150.075.37.80.L	8.00	1.50	0.75	3.70	7.70	3.00	37.00	62.00	8.00
8.040	GE108.0150.075.42.80.L	8.00	1.50	0.75	3.70	7.70	3.00	42.00	67.00	8.00
8.050	GE108.0150.075.47.80.L	8.00	1.50	0.75	3.70	7.70	3.00	47.00	72.00	8.00
8.110	GE108.0200.100.17.80.L	8.00	2.00	1.00	3.70	7.70	3.00	17.00	42.00	8.00

Article no. **27229** **27231**Cutting direction  

Code no.	Description	D min	b	R	f	a	t max	La	Lg	D h6
		mm	mm	mm	mm	mm	mm	mm	mm	mm
8.120	GE108.0200.100.27.80.L	8.00	2.00	1.00	3.70	7.70	3.00	27.00	52.00	8.00
8.130	GE108.0200.100.37.80.L	8.00	2.00	1.00	3.70	7.70	3.00	37.00	62.00	8.00
8.140	GE108.0200.100.42.80.L	8.00	2.00	1.00	3.70	7.70	3.00	42.00	67.00	8.00
8.150	GE108.0200.100.47.80.L	8.00	2.00	1.00	3.70	7.70	3.00	47.00	72.00	8.00
8.210	GE108.0250.125.17.80.L	8.00	2.50	1.25	3.70	7.70	3.00	17.00	42.00	8.00
8.220	GE108.0250.125.27.80.L	8.00	2.50	1.25	3.70	7.70	3.00	27.00	52.00	8.00
8.230	GE108.0250.125.37.80.L	8.00	2.50	1.25	3.70	7.70	3.00	37.00	62.00	8.00
8.240	GE108.0250.125.42.80.L	8.00	2.50	1.25	3.70	7.70	3.00	42.00	67.00	8.00
8.250	GE108.0250.125.47.80.L	8.00	2.50	1.25	3.70	7.70	3.00	47.00	72.00	8.00
8.310	GE108.0300.150.17.80.L	8.00	3.00	1.50	3.70	7.70	3.00	17.00	42.00	8.00
8.320	GE108.0300.150.27.80.L	8.00	3.00	1.50	3.70	7.70	3.00	27.00	52.00	8.00
8.330	GE108.0300.150.37.80.L	8.00	3.00	1.50	3.70	7.70	3.00	37.00	62.00	8.00
8.340	GE108.0300.150.42.80.L	8.00	3.00	1.50	3.70	7.70	3.00	42.00	67.00	8.00
8.350	GE108.0300.150.47.70.L	8.00	3.00	1.50	3.70	7.70	3.00	47.00	72.00	8.00

System 108

# 110





# SYSTEM 110

## MICRO-PRECISION TOOLS



Tool holder

System 110



# 110

## SPECIAL SOLUTIONS

When designing custom-made special tools, Guhring can tap into decades of experience and its substantial tool expertise in advising customers.

The 110 tool system offers a stable special solution in such cases. We keep blanks with a shank diameter of 10 mm up to a total length of 112 mm available at the factory in order to be able to offer the best possible solution for most difficult applications. We are happy to inspect the design of even longer tools for you.

The shank diameter of 10 mm offers great stability in challenging cases. Whether long overhangs, large recessing widths or large machining depths for recesses, the 110 tool system offers a myriad of options.

The 110 tool system is being launched on the market with a standard range of round shaft holders.

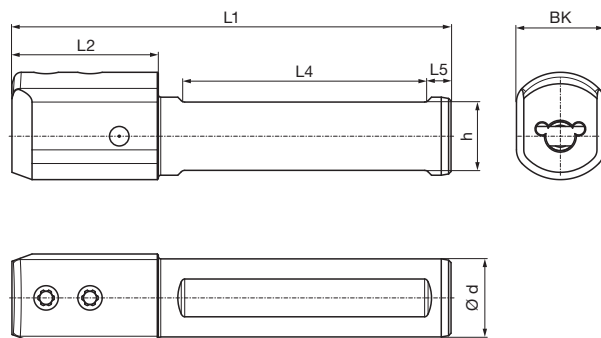




### Round shank holder, clamping screw top

- for inserts type 110
- with internal coolant supply

Type GB 110



Article no. 27050

System 110

Code no.	Description	d	h	L1	L2	L4	L5	BK
		mm	mm	mm	mm	mm	mm	mm
10.001	GB110.0010.090.00.22.N.IK	10.00	9.00	90.00	30.00	50.00	5.00	20.0
10.002	GB110.0012.090.00.22.N.IK	12.00	11.00	90.00	30.00	50.00	5.00	20.0
10.015	GB110.0500.354.00.22.N.IK	12.70	11.00	89.92	26.67	54.86	5.00	20.0
10.016	GB110.0625.354.00.22.N.IK	15.87	14.00	89.92	26.67	54.86	5.00	20.0
10.003	GB110.0016.090.00.22.N.IK	16.00	14.00	90.00	30.00	50.00	5.00	20.0
10.017	GB110.0750.415.00.22.N.IK	19.05	17.00	105.41	26.67	69.85	5.00	20.5
10.004	GB110.0020.095.00.22.N.IK	20.00	18.00	95.00	30.00	55.00	5.00	20.5
10.005	GB110.0022.095.00.22.N.IK	22.00	20.00	95.00	30.00	55.00	5.00	
10.006	GB110.0025.100.00.22.N.IK	25.00	23.00	100.00		55.00	5.00	
10.018	GB110.1000.415.00.22.N.IK	25.40	23.40	105.41		69.85	5.00	

### Spare parts

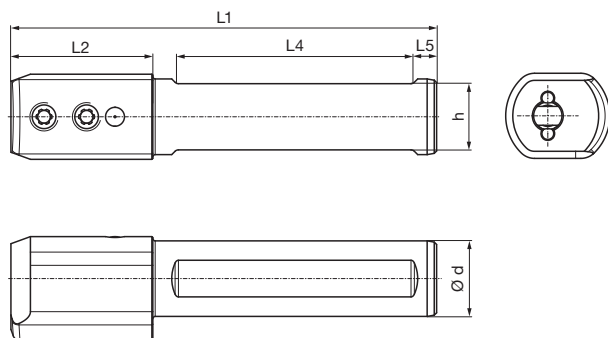
Article no.	Clamping screw	Tightening torque
25900		Nm
Code 6.000	M6x7.5x15IP	4-4.5

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

**Round shank holder, clamping screw lateral**

- for inserts type 110
- with internal coolant supply

Type GB 110



Article no. 27051

Code no.	Description	d	h	L1	L2	L4	L5
		mm	mm	mm	mm	mm	mm
10.001	GB110.0010.090.00.22.N.IK90	10.00	9.00	90.00	30.00	50.00	5.00
10.002	GB110.0012.090.00.22.N.IK90	12.00	11.00	90.00	30.00	50.00	5.00
10.015	GB110.0500.354.00.22.N.IK90	12.70	11.00	89.92	26.67	54.86	5.00
10.016	GB110.0625.354.00.22.N.IK90	15.87	14.00	89.92	26.67	54.86	5.00
10.003	GB110.0016.090.00.22.N.IK90	16.00	14.00	90.00	30.00	50.00	5.00
10.017	GB110.0750.415.00.22.N.IK90	19.05	17.00	105.41	26.67	69.85	5.00
10.004	GB110.0020.095.00.22.N.IK90	20.00	18.00	95.00	30.00	55.00	5.00
10.005	GB110.0022.095.00.22.N.IK90	22.00	20.00	95.00	30.00	55.00	5.00
10.006	GB110.0025.100.00.22.N.IK90	25.00	23.00	100.00		55.00	5.00
10.018	GB110.1000.415.00.22.N.IK90	25.40	23.40	105.41		69.85	5.00

**Spare parts**

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

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

# MICRO-PRECISION TOOLS

Guhring's micro-precision tools range from micro-precision drills with a radius of 0.05 mm to special solutions in larger sizes and from HSS to solid carbide. The micro-precision tool range comprises 75 types in over 2,400 sizes and therefore offers stocked tool solutions for a variety of applications. Specially adapted geometries, substrates and surfaces guarantee optimum performance and processing safety for drilling, milling, reaming and threading in micro applications.



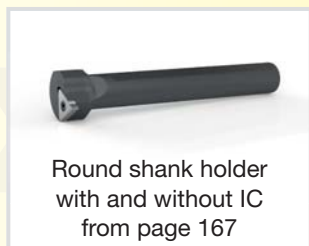
# 305





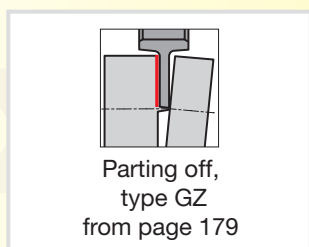
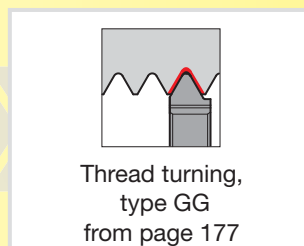
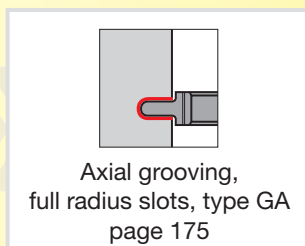
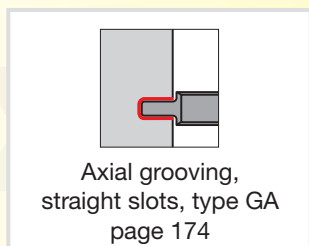
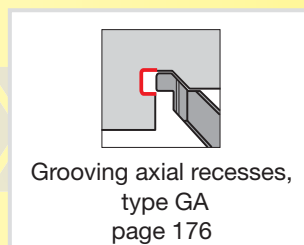
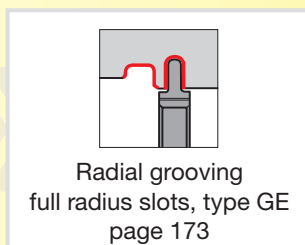
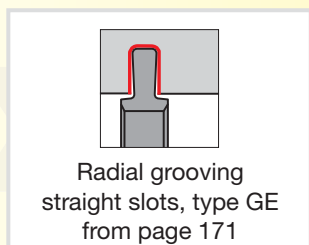
# SYSTEM 305

## GROOVING AND PARTING OFF



Tool holder

System 305



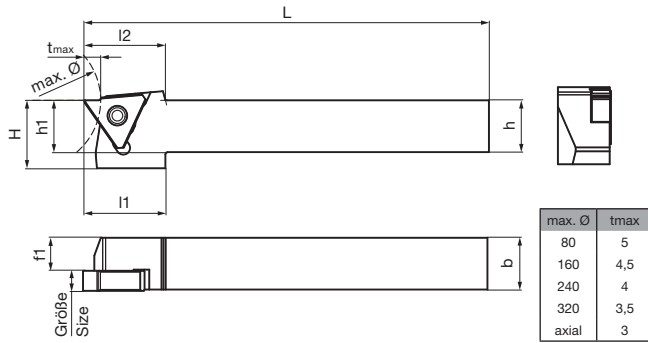
Indexable inserts

**Square shank holder straight, external machining, without IC**

- grooving depth up to 5 mm
- without internal coolant supply

Type GH 305

for indexable inserts type 305 see from page 171



Right hand version shown  
Left hand version mirror image

Article no. **25350**

version right-hand

System 305

Code no.	Description	t max	h	b	L	h1	H	l1	l2	f1	Size
		mm	mm	mm	mm	mm	mm	mm	mm	mm	
12.013	GH305.1010.125.00.04.R	5.00	10.00	10.00	125.00	10.00	20.00	24.00	25.00	8.20	04
12.014	GH305.1212.125.00.04.R	5.00	12.00	12.00	125.00	12.00	20.00	24.00	25.00	8.20	04
12.021	GH305.0625.500.00.04.R	5.00	15.87	15.87	127.00	15.87	20.87	25.40	25.40	12.07	04
12.001	GH305.1616.125.00.04.R	5.00	16.00	16.00	125.00	16.00	21.00	25.00	25.00	12.20	04
12.022	GH305.0750.500.00.04.R	5.00	19.05	19.05	127.00	19.05	24.05	25.40	25.40	15.25	04
12.002	GH305.2020.125.00.04.R	5.00	20.00	20.00	125.00	20.00	25.00	25.00	25.00	16.20	04
12.003	GH305.2525.150.00.04.R	5.00	25.00	25.00	150.00	25.00	30.00	25.00	25.00	21.20	04
12.023	GH305.1000.600.00.04.R	5.00	25.40	25.40	152.40	25.40	30.40	25.40	25.40	21.60	04
12.015	GH305.1010.125.00.06.R	5.00	10.00	10.00	125.00	10.00	20.00	24.00	25.00	8.20	06
12.016	GH305.1212.125.00.06.R	5.00	12.00	12.00	125.00	12.00	20.00	24.00	25.00	8.20	06
12.024	GH305.0625.500.00.06.R	5.00	15.87	15.87	127.00	15.87	20.87	25.40	25.40	10.07	06
12.004	GH305.1616.125.00.06.R	5.00	16.00	16.00	125.00	16.00	21.00	25.00	25.00	10.20	06
12.025	GH305.0750.500.00.06.R	5.00	19.05	19.05	127.00	19.05	24.05	25.40	25.40	13.25	06
12.005	GH305.2020.125.00.06.R	5.00	20.00	20.00	125.00	20.00	25.00	25.00	25.00	14.20	06
12.006	GH305.2525.150.00.06.R	5.00	25.00	25.00	150.00	25.00	30.00	25.00	25.00	19.20	06
12.026	GH305.1000.600.00.06.R	5.00	25.40	25.40	152.40	25.40	30.40	25.40	25.40	19.60	06
12.017	GH305.1010.125.00.08.R	5.00	10.00	10.00	125.00	10.00	20.00	24.00	25.00	8.20	08
12.018	GH305.1212.125.00.08.R	5.00	12.00	12.00	125.00	12.00	20.00	24.00	25.00	8.20	08
12.027	GH305.0625.500.00.08.R	5.00	15.87	15.87	127.00	15.87	20.87	25.40	25.40	8.07	08
12.007	GH305.1616.125.00.08.R	5.00	16.00	16.00	125.00	16.00	21.00	25.00	25.00	8.20	08
12.028	GH305.0750.500.00.08.R	5.00	19.05	19.05	127.00	19.05	24.05	25.40	25.40	11.25	08
12.008	GH305.2020.125.00.08.R	5.00	20.00	20.00	125.00	20.00	25.00	25.00	25.00	12.20	08
12.009	GH305.2525.150.00.08.R	5.00	25.00	25.00	150.00	25.00	30.00	25.00	25.00	17.20	08
12.029	GH305.1000.600.00.08.R	5.00	25.40	25.40	152.40	25.40	30.40	25.40	25.40	17.60	08
12.019	GH305.1010.125.00.12.R	5.00	10.00	10.00	125.00	10.00	20.00	24.00	25.00	8.20	12
12.020	GH305.1212.125.00.12.R	5.00	12.00	12.00	125.00	12.00	20.00	24.00	25.00	8.20	12
12.030	GH305.0625.500.00.12.R	5.00	15.87	15.87	127.00	15.87	20.87	24.40	25.40	8.27	12
12.010	GH305.1616.125.00.12.R	5.00	16.00	16.00	125.00	16.00	21.00	24.00	25.00	8.60	12
12.031	GH305.0750.500.00.12.R	5.00	19.05	19.05	127.00	19.05	24.05	25.40	25.40	7.25	12
12.011	GH305.2020.125.00.12.R	5.00	20.00	20.00	125.00	20.00	25.00	25.00	25.00	8.20	12
12.012	GH305.2525.150.00.12.R	5.00	25.00	25.00	150.00	25.00	30.00	25.00	25.00	13.20	12
12.032	GH305.1000.600.00.12.R	5.00	25.40	25.40	152.40	25.40	30.40	25.40	25.40	13.60	12



Article no. **25351**

version left-hand

Code no.	Description	t max	h	b	L	h1	H	l1	l2	f1	Size
		mm	mm	mm	mm	mm	mm	mm	mm	mm	
12.013	GH305.1010.125.00.04.L	5.00	10.00	10.00	125.00	10.00	20.00	24.00	25.00	8.20	04
12.014	GH305.1212.125.00.04.L	5.00	12.00	12.00	125.00	12.00	20.00	24.00	25.00	8.20	04
12.021	GH305.0625.500.00.04.L	5.00	15.87	15.87	127.00	15.87	20.87	25.40	25.40	12.07	04
12.001	GH305.1616.125.00.04.L	5.00	16.00	16.00	125.00	16.00	21.00	25.00	25.00	12.20	04
12.022	GH305.0750.500.00.04.L	5.00	19.05	19.05	127.00	19.05	24.05	25.40	25.40	15.25	04
12.002	GH305.2020.125.00.04.L	5.00	20.00	20.00	125.00	20.00	25.00	25.00	25.00	16.20	04
12.003	GH305.2525.150.00.04.L	5.00	25.00	25.00	150.00	25.00	30.00	25.00	25.00	21.20	04
12.023	GH305.1000.600.00.04.L	5.00	25.40	25.40	152.40	25.40	30.40	25.40	25.40	21.60	04
12.015	GH305.1010.125.00.06.L	5.00	10.00	10.00	125.00	10.00	20.00	24.00	25.00	8.20	06
12.016	GH305.1212.125.00.06.L	5.00	12.00	12.00	125.00	12.00	20.00	24.00	25.00	8.20	06
12.024	GH305.0625.500.00.06.L	5.00	15.87	15.87	127.00	15.87	20.87	25.40	25.40	10.07	06
12.004	GH305.1616.125.00.06.L	5.00	16.00	16.00	125.00	16.00	21.00	25.00	25.00	10.20	06
12.025	GH305.0750.500.00.06.L	5.00	19.05	19.05	127.00	19.05	24.05	25.40	25.40	13.25	06
12.005	GH305.2020.125.00.06.L	5.00	20.00	20.00	125.00	20.00	25.00	25.00	25.00	14.20	06
12.006	GH305.2525.150.00.06.L	5.00	25.00	25.00	150.00	25.00	30.00	25.00	25.00	19.20	06
12.026	GH305.1000.600.00.06.L	5.00	25.40	25.40	152.40	25.40	30.40	25.40	25.40	19.60	06
12.017	GH305.1010.125.00.08.L	5.00	10.00	10.00	125.00	10.00	20.00	24.00	25.00	8.20	08
12.018	GH305.1212.125.00.08.L	5.00	12.00	12.00	125.00	12.00	20.00	24.00	25.00	8.20	08
12.027	GH305.0625.500.00.08.L	5.00	15.87	15.87	127.00	15.87	20.87	25.40	25.40	8.07	08
12.007	GH305.1616.125.00.08.L	5.00	16.00	16.00	125.00	16.00	21.00	25.00	25.00	8.20	08
12.028	GH305.0750.500.00.08.L	5.00	19.05	19.05	127.00	19.05	24.05	25.40	25.40	11.25	08
12.008	GH305.2020.125.00.08.L	5.00	20.00	20.00	125.00	20.00	25.00	25.00	25.00	12.20	08
12.009	GH305.2525.150.00.08.L	5.00	25.00	25.00	150.00	25.00	30.00	25.00	25.00	17.20	08
12.029	GH305.1000.600.00.08.L	5.00	25.40	25.40	152.40	25.40	30.40	25.40	25.40	17.60	08
12.019	GH305.1010.125.00.12.L	5.00	10.00	10.00	125.00	10.00	20.00	24.00	25.00	8.20	12
12.020	GH305.1212.125.00.12.L	5.00	12.00	12.00	125.00	12.00	20.00	24.00	25.00	8.20	12
12.030	GH305.0625.500.00.12.L	5.00	15.87	15.87	127.00	15.87	20.87	24.40	25.40	8.27	12
12.010	GH305.1616.125.00.12.L	5.00	16.00	16.00	125.00	16.00	21.00	24.00	25.00	8.60	12
12.031	GH305.0750.500.00.12.L	5.00	19.05	19.05	127.00	19.05	24.05	25.40	25.40	7.25	12
12.011	GH305.2020.125.00.12.L	5.00	20.00	20.00	125.00	20.00	25.00	25.00	25.00	8.20	12
12.012	GH305.2525.150.00.12.L	5.00	25.00	25.00	150.00	25.00	30.00	25.00	25.00	13.20	12
12.032	GH305.1000.600.00.12.L	5.00	25.40	25.40	152.40	25.40	30.40	25.40	25.40	13.60	12

System 305

**Spare parts**

Article no.	Clamping screw	Tightening torque	Size	Description
25901		Nm		
Code 4.002	M4x11x15IP	4-4.5	04-06	GH305.1010.125....; GH305.1212.125...
Code 4.000	M4x15x15IP	4-4.5	04-06	GH305.0625.500....; GH305.0750.500...
Code 4.000	M4x15x15IP	4-4.5	04-06	GH305.1616.125....; GH305.1000.600...
Code 4.000	M4x15x15IP	4-4.5	04-06	GH305.2020.125....; GH305.2525.150...
Code 4.000	M4x15x15IP	4-4.5	08	GH305....
Code 4.003	M4x17x15IP	4-4.5	12	GH305....

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

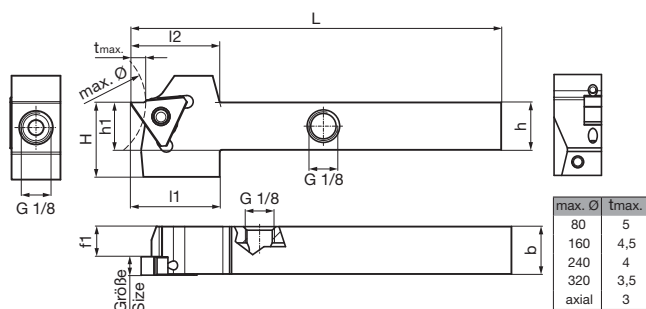


**Square shank holder straight, external machining, with IC**

- grooving depth up to 5 mm
- with internal coolant supply from above and below

Type GH 305

for indexable inserts type 305 see from page 171



Right hand version shown  
Left hand version mirror image

Article no. **25352**

version right-hand

Code no.	Description	t max	h	b	L	h1	H	l1	l2	f1	Size
		mm	mm	mm	mm	mm	mm	mm	mm	mm	
12.014	GH305.1212.125.00.04.R.IK	5.00	12.00	12.00	125.00	12.00	21.00	30.00	30.00	8.20	04
12.021	GH305.0625.500.00.04.R.IK	5.00	15.87	15.87	127.00	15.87	24.87	30.48	30.48	12.07	04
12.001	GH305.1616.125.00.04.R.IK	5.00	16.00	16.00	125.00	16.00	25.00	30.00	30.00	12.20	04
12.022	GH305.0750.500.00.04.R.IK	5.00	19.05	19.05	127.00	19.05	24.05	30.48	30.48	15.25	04
12.002	GH305.2020.125.00.04.R.IK	5.00	20.00	20.00	125.00	20.00	25.00	30.00	30.00	16.20	04
12.003	GH305.2525.150.00.04.R.IK	5.00	25.00	25.00	150.00	25.00	30.00	30.00	30.00	21.20	04
12.023	GH305.1000.600.00.04.R.IK	5.00	25.40	25.40	152.40	25.40	30.40	30.48	30.48	21.60	04
12.016	GH305.1212.125.00.06.R.IK	5.00	12.00	12.00	125.00	12.00	21.00	30.00	30.00	6.20	06
12.024	GH305.0625.500.00.06.R.IK	5.00	15.87	15.87	127.00	15.87	24.87	30.48	30.48	10.07	06
12.004	GH305.1616.125.00.06.R.IK	5.00	16.00	16.00	125.00	16.00	25.00	30.00	30.00	10.20	06
12.025	GH305.0750.500.00.06.R.IK	5.00	19.05	19.05	127.00	19.05	24.05	30.48	30.48	13.25	06
12.005	GH305.2020.125.00.06.R.IK	5.00	20.00	20.00	125.00	20.00	25.00	30.00	30.00	14.20	06
12.006	GH305.2525.150.00.06.R.IK	5.00	25.00	25.00	150.00	25.00	30.00	30.00	30.00	19.20	06
12.026	GH305.1000.600.00.06.R.IK	5.00	25.40	25.40	152.40	25.40	30.40	30.48	30.48	19.60	06
12.018	GH305.1212.125.00.08.R.IK	5.00	12.00	12.00	125.00	12.00	21.00	30.00	30.00	4.20	08
12.027	GH305.0625.500.00.08.R.IK	5.00	15.87	15.87	127.00	15.87	24.87	30.48	30.48	8.07	08
12.007	GH305.1616.125.00.08.R.IK	5.00	16.00	16.00	125.00	16.00	25.00	30.00	30.00	8.20	08
12.028	GH305.0750.500.00.08.R.IK	5.00	19.05	19.05	127.00	19.05	24.05	30.48	30.48	11.25	08
12.008	GH305.2020.125.00.08.R.IK	5.00	20.00	20.00	125.00	20.00	25.00	30.00	30.00	12.20	08
12.009	GH305.2525.150.00.08.R.IK	5.00	25.00	25.00	150.00	25.00	30.00	30.00	30.00	17.20	08
12.029	GH305.1000.600.00.08.R.IK	5.00	25.40	25.40	152.40	25.40	30.40	30.48	30.48	17.60	08
12.020	GH305.1212.125.00.12.R.IK	5.00	12.00	12.00	125.00	12.00	25.00	30.00	30.00	0.20	12
12.030	GH305.0625.500.00.12.R.IK	5.00	15.87	15.87	127.00	15.87	24.87	30.48	30.48	4.07	12
12.010	GH305.1616.125.00.12.R.IK	5.00	16.00	16.00	125.00	16.00	25.00	30.00	30.00	4.20	12
12.031	GH305.0750.500.00.12.R.IK	5.00	19.05	19.05	127.00	19.05	24.05	30.48	30.48	7.25	12
12.011	GH305.2020.125.00.12.R.IK	5.00	20.00	20.00	125.00	20.00	25.00	30.00	30.00	8.20	12
12.012	GH305.2525.150.00.12.R.IK	5.00	25.00	25.00	150.00	25.00	30.00	30.00	30.00	13.20	12
12.032	GH305.1000.600.00.12.R.IK	5.00	25.40	25.40	152.40	25.40	30.40	30.48	30.48	13.60	12

Article no. **25353**

version left-hand

Code no.	Description	t max	h	b	L	h1	H	l1	l2	f1	Size
		mm	mm	mm	mm	mm	mm	mm	mm	mm	
12.014	GH305.1212.125.00.04.L.IK	5.00	12.00	12.00	125.00	12.00	21.00	30.00	30.00	8.20	04
12.021	GH305.0625.500.00.04.L.IK	5.00	15.87	15.87	127.00	15.87	24.87	30.48	30.48	12.07	04
12.001	GH305.1616.125.00.04.L.IK	5.00	16.00	16.00	125.00	16.00	25.00	30.00	30.00	12.20	04
12.022	GH305.0750.500.00.04.L.IK	5.00	19.05	19.05	127.00	19.05	24.05	30.48	30.48	15.25	04
12.002	GH305.2020.125.00.04.L.IK	5.00	20.00	20.00	125.00	20.00	25.00	30.00	30.00	16.20	04
12.003	GH305.2525.150.00.04.L.IK	5.00	25.00	25.00	150.00	25.00	30.00	30.00	30.00	21.20	04
12.023	GH305.1000.600.00.04.L.IK	5.00	25.40	25.40	152.40	25.40	30.40	30.48	30.48	21.60	04
12.016	GH305.1212.125.00.06.L.IK	5.00	12.00	12.00	125.00	12.00	21.00	30.00	30.00	6.20	06
12.024	GH305.0625.500.00.06.L.IK	5.00	15.87	15.87	127.00	15.87	24.87	30.48	30.48	10.07	06
12.004	GH305.1616.125.00.04.L.IK	5.00	16.00	16.00	125.00	16.00	25.00	30.00	30.00	10.20	06
12.025	GH305.0750.500.00.06.L.IK	5.00	19.05	19.05	127.00	19.05	24.05	30.48	30.48	13.25	06
12.005	GH305.2020.125.00.06.L.IK	5.00	20.00	20.00	125.00	20.00	25.00	30.00	30.00	14.20	06
12.006	GH305.2525.150.00.06.L.IK	5.00	25.00	25.00	150.00	25.00	30.00	30.00	30.00	19.20	06
12.026	GH305.1000.600.00.06.L.IK	5.00	25.40	25.40	152.40	25.40	30.40	30.48	30.48	19.60	06
12.018	GH305.1212.125.00.08.L.IK	5.00	12.00	12.00	125.00	12.00	21.00	30.00	30.00	4.20	08
12.027	GH305.0625.500.00.08.L.IK	5.00	15.87	15.87	127.00	15.87	24.87	30.48	30.48	8.07	08
12.007	GH305.1616.125.00.08.L.IK	5.00	16.00	16.00	125.00	16.00	25.00	30.00	30.00	8.20	08
12.028	GH305.0750.500.00.08.L.IK	5.00	19.05	19.05	127.00	19.05	24.05	30.48	30.48	11.25	08
12.008	GH305.2020.125.00.08.L.IK	5.00	20.00	20.00	125.00	20.00	25.00	30.00	30.00	12.20	08
12.009	GH305.2525.150.00.08.L.IK	5.00	25.00	25.00	150.00	25.00	30.00	30.00	30.00	17.20	08
12.029	GH305.1000.600.00.08.L.IK	5.00	25.40	25.40	152.40	25.40	30.40	30.48	30.48	17.60	08
12.020	GH305.1212.125.00.12.L.IK	5.00	12.00	12.00	125.00	12.00	25.00	30.00	30.00	0.20	12
12.030	GH305.0625.500.00.12.L.IK	5.00	15.87	15.87	127.00	15.87	24.87	30.48	30.48	4.07	12
12.010	GH305.1616.125.00.12.L.IK	5.00	16.00	16.00	125.00	16.00	25.00	30.00	30.00	4.20	12
12.031	GH305.0750.500.00.12.L.IK	5.00	19.05	19.05	127.00	19.05	24.05	30.48	30.48	7.25	12
12.011	GH305.2020.125.00.12.L.IK	5.00	20.00	20.00	125.00	20.00	25.00	30.00	30.00	8.20	12
12.012	GH305.2525.150.00.12.L.IK	5.00	25.00	25.00	150.00	25.00	30.00	30.00	30.00	13.20	12
12.032	GH305.1000.600.00.12.L.IK	5.00	25.40	25.40	152.40	25.40	30.40	30.48	30.48	13.60	12

System 305

**Spare parts**

Article no.	Clamping screw	Tightening torque	Size	Description
25901		Nm		
Code 4.002	M4x11x15IP	4-4.5	04-06	GH305.1010.125....; GH305.1212.125...
Code 4.000	M4x15x15IP	4-4.5	04-06	GH305.0625.500....; GH305.0750.500...
Code 4.000	M4x15x15IP	4-4.5	04-06	GH305.1616.125....; GH305.1000.600...
Code 4.000	M4x15x15IP	4-4.5	04-06	GH305.2020.125....; GH305.2525.150...
Code 4.000	M4x15x15IP	4-4.5	08	GH305....
Code 4.003	M4x17x15IP	4-4.5	12	GH305....

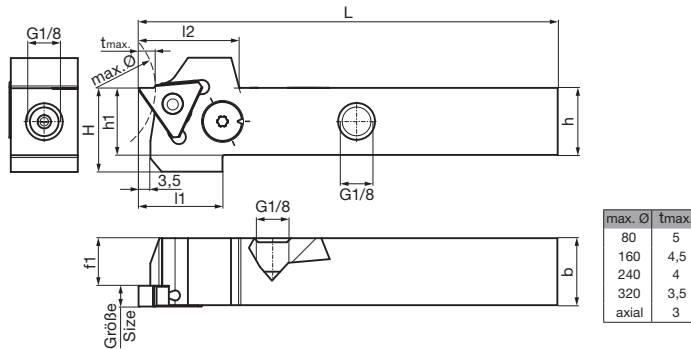
Article no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle

**Square shank holder straight, external machining, IC adjustable**

- grooving depth up to 5 mm
- with internal coolant supply

Type GH 305

for indexable inserts type 305 see from page 171



Right hand version shown  
Left hand version mirror image

Article no. **25372**

version right-hand

Code no.	Description	t max	h	b	L	h1	H	l1	l2	f1	Size
		mm	mm	mm	mm	mm	mm	mm	mm	mm	
12.002	GH305.2020.125.00.04.R.IK.EST	5.00	20.00	20.00	125.00	20.00	25.00	30.00	30.00	16.20	04
12.003	GH305.2525.150.00.04.R.IK.EST	5.00	25.00	25.00	150.00	25.00	30.00	30.00	30.00	21.20	04
12.005	GH305.2020.125.00.06.R.IK.EST	5.00	20.00	20.00	125.00	20.00	25.00	30.00	30.00	14.20	06
12.006	GH305.2525.150.00.06.R.IK.EST	5.00	25.00	25.00	150.00	25.00	30.00	30.00	30.00	19.20	06

Article no. **25373**

version left-hand

Code no.	Description	t max	h	b	L	h1	H	l1	l2	f1	Size
		mm	mm	mm	mm	mm	mm	mm	mm	mm	
12.002	GH305.2020.125.00.04.L.IK.EST	5.00	20.00	20.00	125.00	20.00	25.00	30.00	30.00	16.20	04
12.003	GH305.2525.150.00.04.L.IK.EST	5.00	25.00	25.00	150.00	25.00	30.00	30.00	30.00	21.20	04
12.005	GH305.2020.125.00.06.L.IK.EST	5.00	20.00	20.00	125.00	20.00	25.00	30.00	30.00	14.20	06
12.006	GH305.2525.150.00.06.L.IK.EST	5.00	25.00	25.00	150.00	25.00	30.00	30.00	30.00	19.20	06

**Spare parts**

Article no.	Clamping screw	Tightening torque	Size	Description
25901		Nm		
Code 4.002	M4x11x15IP	4-4.5	04-06	GH305.1010.125....; GH305.1212.125...
Code 4.000	M4x15x15IP	4-4.5	04-06	GH305.0625.500....; GH305.0750.500...
Code 4.000	M4x15x15IP	4-4.5	04-06	GH305.1616.125....; GH305.1000.600...
Code 4.000	M4x15x15IP	4-4.5	04-06	GH305.2020.125....; GH305.2525.150...
Code 4.000	M4x15x15IP	4-4.5	08	GH305....
Code 4.003	M4x17x15IP	4-4.5	12	GH305....

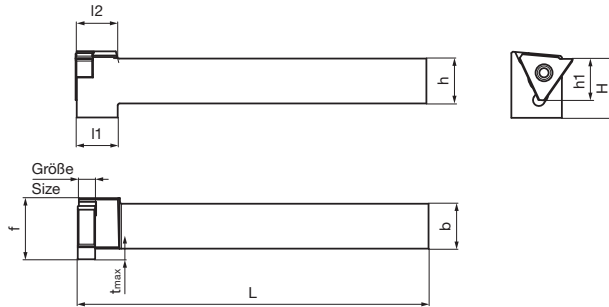
Article no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle


**Square shank holder 90° offset, external machining, without IC**

- grooving depth up to 3.5 mm
- without internal coolant supply

Type GH 305

for indexable inserts type 305 see from page 171



Right hand version shown  
Left hand version mirror image

Article no. **25356**  
version right-hand

Code no.	Description	t max	h	b	L	h1	H	l1	l2	f	Size
		mm	mm	mm	mm	mm	mm	mm	mm	mm	
12.013	GH305.1010.125.90.04.R	3.50	10.00	10.00	125.00	10.00	19.00	14.60	14.60	13.80	04
12.014	GH305.1212.125.90.04.R	3.50	12.00	12.00	125.00	12.00	21.00	14.60	14.60	15.80	04
12.021	GH305.0625.500.90.04.R	3.50	15.87	15.87	127.00	15.87	20.87	14.84	14.84	19.67	04
12.001	GH305.1616.125.90.04.R	3.50	16.00	16.00	125.00	16.00	21.00	14.60	14.60	19.80	04
12.022	GH305.0750.500.90.04.R	3.50	19.05	19.05	127.00	19.05	24.05	14.84	14.84	22.85	04
12.002	GH305.2020.125.90.04.R	3.50	20.00	20.00	125.00	20.00	25.00	14.60	14.60	23.80	04
12.003	GH305.2525.150.90.04.R	3.50	25.00	25.00	150.00	25.00	30.00	14.60	14.60	28.80	04
12.023	GH305.1000.600.90.04.R	3.50	25.40	25.40	152.40	25.40	30.40	14.84	14.84	29.20	04
12.015	GH305.1010.125.90.06.R	3.50	10.00	10.00	125.00	10.00	19.00	14.60	14.60	13.80	06
12.016	GH305.1212.125.90.06.R	3.50	12.00	12.00	125.00	12.00	21.00	14.60	14.60	15.80	06
12.024	GH305.0625.500.90.06.R	3.50	15.87	15.87	127.00	15.87	20.87	14.84	14.84	19.67	06
12.004	GH305.1616.125.90.06.R	3.50	16.00	16.00	125.00	16.00	21.00	14.60	14.60	19.80	06
12.025	GH305.0750.500.90.06.R	3.50	19.05	19.05	127.00	19.05	24.05	14.84	14.84	22.85	06
12.005	GH305.2020.125.90.06.R	3.50	20.00	20.00	125.00	20.00	25.00	14.60	14.60	23.80	06
12.006	GH305.2525.150.90.06.R	3.50	25.00	25.00	150.00	25.00	30.00	14.60	14.60	28.80	06
12.026	GH305.1000.600.90.06.R	3.50	25.40	25.40	152.40	25.40	30.40	14.84	14.84	29.20	06
12.017	GH305.1010.125.90.08.R	3.50	10.00	10.00	125.00	10.00	19.00	16.60	16.60	13.80	08
12.018	GH305.1212.125.90.08.R	3.50	12.00	12.00	125.00	12.00	21.00	16.60	16.60	15.80	08
12.027	GH305.0625.500.90.08.R	3.50	15.87	15.87	127.00	15.87	20.87	16.84	16.84	19.67	08
12.007	GH305.1616.125.90.08.R	3.50	16.00	16.00	125.00	16.00	21.00	16.60	16.60	19.80	08
12.028	GH305.0750.500.90.08.R	3.50	19.05	19.05	127.00	19.05	24.05	16.84	16.84	22.85	08
12.008	GH305.2020.125.90.08.R	3.50	20.00	20.00	125.00	20.00	25.00	16.60	16.60	23.80	08
12.009	GH305.2525.150.90.08.R	3.50	25.00	25.00	150.00	25.00	30.00	16.60	16.60	28.80	08
12.029	GH305.1000.600.90.08.R	3.50	25.40	25.40	152.40	25.40	30.40	16.84	16.84	29.20	08
12.019	GH305.1010.125.90.12.R	3.50	10.00	10.00	125.00	10.00	19.00	16.60	20.60	13.80	12
12.020	GH305.1212.125.90.12.R	3.50	12.00	12.00	125.00	12.00	21.00	20.60	20.60	15.80	12
12.030	GH305.0625.500.90.12.R	3.50	15.87	15.87	127.00	15.87	20.87	20.84	20.84	19.67	12
12.010	GH305.1616.125.90.12.R	3.50	16.00	16.00	125.00	16.00	21.00	20.60	20.60	19.80	12
12.031	GH305.0750.500.90.12.R	3.50	19.05	19.05	127.00	19.05	24.05	20.84	20.84	22.85	12
12.011	GH305.2020.125.90.12.R	3.50	20.00	20.00	125.00	20.00	25.00	20.60	20.60	23.80	12
12.012	GH305.2525.150.90.12.R	3.50	25.00	25.00	150.00	25.00	30.00	20.60	20.60	28.80	12
12.032	GH305.1000.600.90.12.R	3.50	25.40	25.40	152.40	25.40	30.40	20.84	20.84	29.20	12

Code no.	Description	t max	h	b	L	h1	H	l1	l2	f	Size
		mm	mm	mm	mm	mm	mm	mm	mm	mm	
12.013	GH305.1010.125.90.04.L	3.50	10.00	10.00	125.00	10.00	19.00	14.60	14.60	13.80	04
12.014	GH305.1212.125.90.04.L	3.50	12.00	12.00	125.00	12.00	21.00	14.60	14.60	15.80	04
12.021	GH305.0625.500.90.04.L	3.50	15.87	15.87	127.00	15.87	20.87	14.84	14.84	19.67	04
12.001	GH305.1616.125.90.04.L	3.50	16.00	16.00	125.00	16.00	21.00	14.60	14.60	19.80	04
12.022	GH305.0750.500.90.04.L	3.50	19.05	19.05	127.00	19.05	24.05	14.84	14.84	22.85	04
12.002	GH305.2020.125.90.04.L	3.50	20.00	20.00	125.00	20.00	25.00	14.60	14.60	23.80	04
12.003	GH305.2525.150.90.04.L	3.50	25.00	25.00	150.00	25.00	30.00	14.60	14.60	28.80	04
12.023	GH305.1000.600.90.04.L	3.50	25.40	25.40	152.40	25.40	30.40	14.84	14.84	29.20	04
12.015	GH305.1010.125.90.06.L	3.50	10.00	10.00	125.00	10.00	19.00	14.60	14.60	13.80	06
12.016	GH305.1212.125.90.06.L	3.50	12.00	12.00	125.00	12.00	21.00	14.60	14.60	15.80	06
12.024	GH305.0625.500.90.06.L	3.50	15.87	15.87	127.00	15.87	20.87	14.84	14.84	19.67	06
12.004	GH305.1616.125.90.06.L	3.50	16.00	16.00	125.00	16.00	21.00	14.60	14.60	19.80	06
12.025	GH305.0750.500.90.06.L	3.50	19.05	19.05	127.00	19.05	24.05	14.84	14.84	22.85	06
12.005	GH305.2020.125.90.06.L	3.50	20.00	20.00	125.00	20.00	25.00	14.60	14.60	23.80	06
12.006	GH305.2525.150.90.06.L	3.50	25.00	25.00	150.00	25.00	30.00	14.60	14.60	28.80	06
12.026	GH305.1000.600.90.06.L	3.50	25.40	25.40	152.40	25.40	30.40	14.84	14.84	29.20	06
12.017	GH305.1010.125.90.08.L	3.50	10.00	10.00	125.00	10.00	19.00	16.60	16.60	13.80	08
12.018	GH305.1212.125.90.08.L	3.50	12.00	12.00	125.00	12.00	21.00	16.60	16.60	15.80	08
12.027	GH305.0625.500.90.08.L	3.50	15.87	15.87	127.00	15.87	20.87	16.84	16.84	19.67	08
12.007	GH305.1616.125.90.08.L	3.50	16.00	16.00	125.00	16.00	21.00	16.60	16.60	19.80	08
12.028	GH305.0750.500.90.08.L	3.50	19.05	19.05	127.00	19.05	24.05	16.84	16.84	22.85	08
12.008	GH305.2020.125.90.08.L	3.50	20.00	20.00	125.00	20.00	25.00	16.60	16.60	23.80	08
12.009	GH305.2525.150.90.08.L	3.50	25.00	25.00	150.00	25.00	30.00	16.60	16.60	28.80	08
12.029	GH305.1000.600.90.08.L	3.50	25.40	25.40	152.40	25.40	30.40	16.84	16.84	29.20	08
12.019	GH305.1010.125.90.12.L	3.50	10.00	10.00	125.00	10.00	19.00	16.60	20.60	13.80	12
12.020	GH305.1212.125.90.12.L	3.50	12.00	12.00	125.00	12.00	21.00	20.60	20.60	15.80	12
12.030	GH305.0625.500.90.12.L	3.50	15.87	15.87	127.00	15.87	20.87	20.84	20.84	19.67	12
12.010	GH305.1616.125.90.12.L	3.50	16.00	16.00	125.00	16.00	21.00	20.60	20.60	19.80	12
12.031	GH305.0750.500.90.12.L	3.50	19.05	19.05	127.00	19.05	24.05	20.84	20.84	22.85	12
12.011	GH305.2020.125.90.12.L	3.50	20.00	20.00	125.00	20.00	25.00	20.60	20.60	23.80	12
12.012	GH305.2525.150.90.12.L	3.50	25.00	25.00	150.00	25.00	30.00	20.60	20.60	28.80	12
12.032	GH305.1000.600.90.12.L	3.50	25.40	25.40	152.40	25.40	30.40	20.84	20.84	29.20	12

System 305

**Spare parts**

Article no.	Clamping screw	Tightening torque	Size
25901		Nm	
Code 4.000	M4x15x15IP	4-4.5	04-08
Code 4.003	M4x17x15IP	4-4.5	12

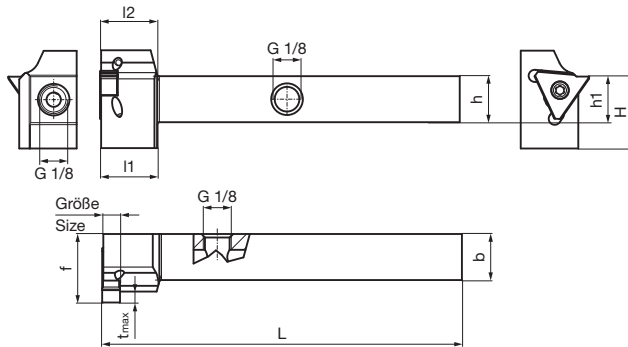
Article no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle


**Square shank holder 90° offset, external machining, with IC**

- grooving depth up to 3.5 mm
- with internal coolant supply from above and below

Type GH 305

for indexable inserts type 305 see from page 171


 Right hand version shown  
 Left hand version mirror image

 Article no. **25358**

version right-hand

Code no.	Description	t max	h	b	L	h1	H	l1	l2	f	Size
		mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
12.014	GH305.1212.125.90.04.R.IK	3.50	12.00	12.00	125.00	12.00	21.00	21.60	21.60	23.80	04
12.021	GH305.0625.500.90.04.R.IK	3.50	15.87	15.87	127.00	15.87	24.87	19.92	19.92	24.12	04
12.001	GH305.1616.125.90.04.R.IK	3.50	16.00	16.00	125.00	16.00	25.00	19.60	19.60	23.80	04
12.022	GH305.0750.500.90.04.R.IK	3.50	19.05	19.05	127.00	19.05	24.05	19.92	19.92	22.85	04
12.002	GH305.2020.125.90.04.R.IK	3.50	20.00	20.00	125.00	20.00	25.00	19.60	19.60	23.80	04
12.003	GH305.2525.150.90.04.R.IK	3.50	25.00	25.00	150.00	25.00	30.00	19.60	19.60	28.80	04
12.023	GH305.1000.600.90.04.R.IK	3.50	25.40	25.40	152.40	25.40	30.40	19.92	19.92	29.20	04
12.016	GH305.1212.125.90.06.R.IK	3.50	12.00	12.00	125.00	12.00	21.00	21.60	21.60	23.80	06
12.024	GH305.0625.500.90.06.R.IK	3.50	15.87	15.87	127.00	15.87	24.87	19.92	19.92	24.12	06
12.004	GH305.1616.125.90.06.R.IK	3.50	16.00	16.00	125.00	16.00	25.00	19.60	19.60	23.80	06
12.025	GH305.0750.500.90.06.R.IK	3.50	19.05	19.05	127.00	19.05	24.05	19.92	19.92	22.85	06
12.005	GH305.2020.125.90.06.R.IK	3.50	20.00	20.00	125.00	20.00	25.00	19.60	19.60	23.80	06
12.006	GH305.2525.150.90.06.R.IK	3.50	25.00	25.00	150.00	25.00	30.00	19.60	19.60	28.80	06
12.026	GH305.1000.600.90.06.R.IK	3.50	25.40	25.40	152.40	25.40	30.40	19.92	19.92	29.20	06
12.018	GH305.1212.125.90.08.R.IK	3.50	12.00	12.00	125.00	12.00	21.00	23.60	23.60	23.80	08
12.027	GH305.0625.500.90.08.R.IK	3.50	15.87	15.87	127.00	15.87	24.87	21.92	21.92	24.12	08
12.007	GH305.1616.125.90.08.R.IK	3.50	16.00	16.00	125.00	16.00	25.00	19.60	19.60	23.80	08
12.028	GH305.0750.500.90.08.R.IK	3.50	19.05	19.05	127.00	19.05	24.05	19.92	19.92	22.85	08
12.008	GH305.2020.125.90.08.R.IK	3.50	20.00	20.00	125.00	20.00	25.00	19.60	19.60	23.80	08
12.009	GH305.2525.150.90.08.R.IK	3.50	25.00	25.00	150.00	25.00	30.00	19.60	19.60	28.80	08
12.029	GH305.1000.600.90.08.R.IK	3.50	25.40	25.40	152.40	25.40	30.40	19.92	19.92	29.20	08
12.020	GH305.1212.125.90.12.R.IK	3.50	12.00	12.00	125.00	12.00	21.00	27.60	27.60	23.80	12
12.030	GH305.0625.500.90.12.R.IK	3.50	15.87	15.87	127.00	15.87	24.87	25.92	25.92	24.12	12
12.010	GH305.1616.125.90.12.R.IK	3.50	16.00	16.00	125.00	16.00	25.00	27.60	27.60	23.80	12
12.031	GH305.0750.500.90.12.R.IK	3.50	19.05	19.05	127.00	19.05	24.05	25.92	25.92	24.12	12
12.011	GH305.2020.125.90.12.R.IK	3.50	20.00	20.00	125.00	20.00	25.00	27.60	27.60	23.80	12
12.012	GH305.2525.150.90.12.R.IK	3.50	25.00	25.00	150.00	25.00	30.00	27.60	27.60	28.80	12
12.032	GH305.1000.600.90.12.R.IK	3.50	25.40	25.40	152.40	25.40	30.40	25.92	25.92	29.20	12

System 305

Code no.	Description	t max	h	b	L	h1	H	l1	l2	f	Size
		mm	mm	mm	mm	mm	mm	mm	mm	mm	
12.014	GH305.1212.125.90.04.L.IK	3.50	12.00	12.00	125.00	12.00	21.00	21.60	21.60	23.80	04
12.021	GH305.0625.500.90.04.L.IK	3.50	15.87	15.87	127.00	15.87	24.87	19.92	19.92	24.12	04
12.001	GH305.1616.125.90.04.L.IK	3.50	16.00	16.00	125.00	16.00	25.00	19.60	19.60	23.80	04
12.022	GH305.0750.500.90.04.L.IK	3.50	19.05	19.05	127.00	19.05	24.05	19.92	19.92	22.85	04
12.002	GH305.2020.125.90.04.L.IK	3.50	20.00	20.00	125.00	20.00	25.00	19.60	19.60	23.80	04
12.003	GH305.2525.150.90.04.L.IK	3.50	25.00	25.00	150.00	25.00	30.00	19.60	19.60	28.80	04
12.023	GH305.1000.600.90.04.L.IK	3.50	25.40	25.40	152.40	25.40	30.40	19.92	19.92	29.20	04
12.016	GH305.1212.125.90.06.L.IK	3.50	12.00	12.00	125.00	12.00	21.00	21.60	21.60	23.80	06
12.024	GH305.0625.500.90.06.L.IK	3.50	15.87	15.87	127.00	15.87	24.87	19.92	19.92	24.12	06
12.004	GH305.1616.125.90.06.L.IK	3.50	16.00	16.00	125.00	16.00	25.00	19.60	19.60	23.80	06
12.025	GH305.0750.500.90.06.L.IK	3.50	19.05	19.05	127.00	19.05	24.05	19.92	19.92	22.85	06
12.005	GH305.2020.125.90.06.L.IK	3.50	20.00	20.00	125.00	20.00	25.00	19.60	19.60	23.80	06
12.006	GH305.2525.150.90.06.L.IK	3.50	25.00	25.00	150.00	25.00	30.00	19.60	19.60	28.80	06
12.026	GH305.1000.600.90.06.L.IK	3.50	25.40	25.40	152.40	25.40	30.40	19.92	19.92	29.20	06
12.018	GH305.1212.125.90.08.L.IK	3.50	12.00	12.00	125.00	12.00	21.00	23.60	23.60	23.80	08
12.027	GH305.0625.500.90.08.L.IK	3.50	15.87	15.87	127.00	15.87	24.87	21.92	21.92	24.12	08
12.007	GH305.1616.125.90.08.L.IK	3.50	16.00	16.00	125.00	16.00	25.00	19.60	19.60	23.80	08
12.028	GH305.0750.500.90.08.L.IK	3.50	19.05	19.05	127.00	19.05	24.05	19.92	19.92	22.85	08
12.008	GH305.2020.125.90.08.L.IK	3.50	20.00	20.00	125.00	20.00	25.00	19.60	19.60	23.80	08
12.009	GH305.2525.150.90.08.L.IK	3.50	25.00	25.00	150.00	25.00	30.00	19.60	19.60	28.80	08
12.029	GH305.1000.600.90.08.L.IK	3.50	25.40	25.40	152.40	25.40	30.40	19.92	19.92	29.20	08
12.020	GH305.1212.125.90.12.L.IK	3.50	12.00	12.00	125.00	12.00	21.00	27.60	27.60	23.80	12
12.030	GH305.0625.500.90.12.L.IK	3.50	15.87	15.87	127.00	15.87	24.87	25.92	25.92	24.12	12
12.010	GH305.1616.125.90.12.L.IK	3.50	16.00	16.00	125.00	16.00	25.00	27.60	27.60	23.80	12
12.031	GH305.0750.500.90.12.L.IK	3.50	19.05	19.05	127.00	19.05	24.05	25.92	25.92	24.12	12
12.011	GH305.2020.125.90.12.L.IK	3.50	20.00	20.00	125.00	20.00	25.00	27.60	27.60	23.80	12
12.012	GH305.2525.150.90.12.L.IK	3.50	25.00	25.00	150.00	25.00	30.00	27.60	27.60	28.80	12
12.032	GH305.1000.600.90.12.L.IK	3.50	25.40	25.40	152.40	25.40	30.40	25.92	25.92	29.20	12

System 305

**Spare parts**

Article no.	Clamping screw	Tightening torque	Size
25901		Nm	
Code 4.000	M4x15x15IP	4-4.5	04-08
Code 4.003	M4x17x15IP	4-4.5	12

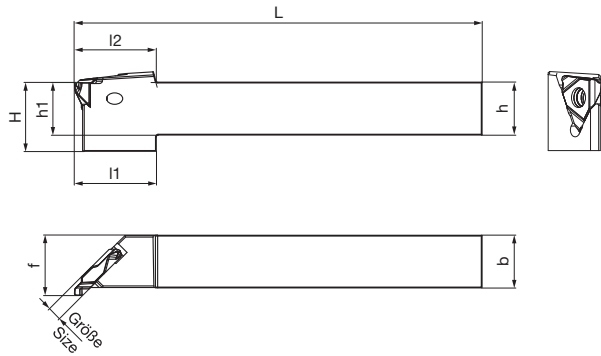
Article no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle


**Square shank holder 45° offset, external machining, without IC**

- grooving depth up to 2 mm
- without internal coolant supply

Type GH 305

for indexable inserts type 305 see page 176


 Right hand version shown  
 Left hand version mirror image

 Article no. **25362**

version right-hand

Code no.	Description	h	b	L	h1	H	l1	l2	f	Size
		mm	mm	mm	mm	mm	mm	mm	mm	
12.004	GH305.1010.125.45.04.R	10.00	10.00	125.00	10.00	21.00	25.66	25.66	12.56	04
12.005	GH305.1212.125.45.04.R	12.00	12.00	125.00	12.00	21.00	25.66	25.66	14.56	04
12.021	GH305.0625.500.45.04.R	15.87	15.87	127.00	15.87	20.87	26.06	26.06	18.44	04
12.001	GH305.1616.125.45.04.R	16.00	16.00	125.00	16.00	21.00	25.66	25.66	18.56	04
12.022	GH305.0750.500.45.04.R	19.05	19.05	127.00	19.05	24.05	26.06	26.06	21.61	04
12.002	GH305.2020.125.45.04.R	20.00	20.00	125.00	20.00	25.00	25.66	25.66	22.56	04
12.003	GH305.2525.150.45.04.R	25.00	25.00	150.00	25.00	30.00	30.66	30.66	27.56	04
12.023	GH305.1000.600.45.04.R	25.40	25.40	152.40	25.40	30.40	31.14	31.14	27.96	04

 Article no. **25363**

version left-hand

Code no.	Description	h	b	L	h1	H	l1	l2	f	Size
		mm	mm	mm	mm	mm	mm	mm	mm	
12.004	GH305.1010.125.45.04.L	10.00	10.00	125.00	10.00	21.00	25.66	25.66	12.56	04
12.005	GH305.1212.125.45.04.L	12.00	12.00	125.00	12.00	21.00	25.66	25.66	14.56	04
12.021	GH305.0625.500.45.04.L	15.87	15.87	127.00	15.87	20.87	26.06	26.06	18.44	04
12.001	GH305.1616.125.45.04.L	16.00	16.00	125.00	16.00	21.00	25.66	25.66	18.56	04
12.022	GH305.0750.500.45.04.L	19.05	19.05	127.00	19.05	24.05	26.06	26.06	21.61	04
12.002	GH305.2020.125.45.04.L	20.00	20.00	125.00	20.00	25.00	25.66	25.66	22.56	04
12.003	GH305.2525.150.45.04.L	25.00	25.00	150.00	25.00	30.00	30.66	30.66	27.56	04
12.023	GH305.1000.600.45.04.L	25.40	25.40	152.40	25.40	30.40	31.14	31.14	27.96	04

**Spare parts**

Article no.	Clamping screw	Tightening torque
25902		Nm
Code 4.001	M4x0.5x7x15IP	4-4.5

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

System 305

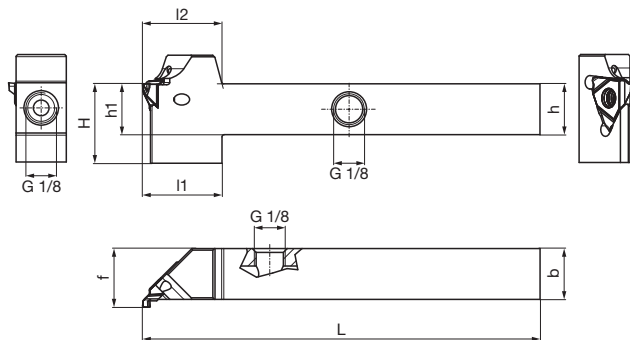


**Square shank holder 45° offset, external machining, with IC**

- grooving depth up to 2 mm
- with internal coolant supply from above

Type GH 305

for indexable inserts type 305 see page 176



Right hand version shown  
Left hand version mirror image



Article no. **25364**  
version right-hand

Code no.	Description	h	b	L	h1	H	l1	l2	f	Size
		mm	mm	mm	mm	mm	mm	mm	mm	
12.005	GH305.1212.125.45.04.R.IK	12.00	12.00	125.00	12.00	25.00	25.66	25.66	14.56	04
12.021	GH305.0625.500.45.04.R.IK	15.87	15.87	127.00	15.87	24.87	26.06	26.06	18.44	04
12.001	GH305.1616.125.45.04.R.IK	16.00	16.00	125.00	16.00	25.00	25.66	25.66	18.56	04
12.022	GH305.0750.500.45.04.R.IK	19.05	19.05	127.00	19.05	24.05	26.06	26.06	21.61	04
12.002	GH305.2020.125.45.04.R.IK	20.00	20.00	125.00	20.00	25.00	25.66	25.66	22.56	04
12.003	GH305.2525.150.45.04.R.IK	25.00	25.00	150.00	25.00	30.00	30.66	30.66	27.56	04
12.023	GH305.1000.600.45.04.R.IK	25.40	25.40	152.40	25.40	30.40	31.14	31.14	27.96	04

Article no. **25365**  
version left-hand

Code no.	Description	h	b	L	h1	H	l1	l2	f	Size
		mm	mm	mm	mm	mm	mm	mm	mm	
12.005	GH305.1212.125.45.04.L.IK	12.00	12.00	125.00	12.00	25.00	25.66	25.66	14.56	04
12.021	GH305.0625.500.45.04.L.IK	15.87	15.87	127.00	15.87	24.87	26.06	26.06	18.44	04
12.001	GH305.1616.125.45.04.L.IK	16.00	16.00	125.00	16.00	25.00	25.66	25.66	18.56	04
12.022	GH305.0750.500.45.04.L.IK	19.05	19.05	127.00	19.05	24.05	26.06	26.06	21.61	04
12.002	GH305.2020.125.45.04.L.IK	20.00	20.00	125.00	20.00	25.00	25.66	25.66	22.56	04
12.003	GH305.2525.150.45.04.L.IK	25.00	25.00	150.00	25.00	30.00	30.66	30.66	27.56	04
12.023	GH305.1000.600.45.04.L.IK	25.40	25.40	152.40	25.40	30.40	31.14	31.14	27.96	04

**Spare parts**

Article no.	Clamping screw	Tightening torque
25902		Nm
Code 4.001	M4x0.5x7x15IP	4-4.5

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

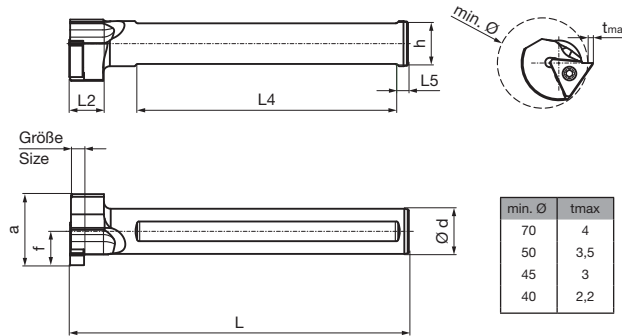


**Round shank holder, internal machining, without IC**

- grooving depth up to 4 mm
- without internal coolant supply

Type GB 305

for indexable inserts type 305 see from page 171



Right hand version shown  
Left hand version mirror image

Article no. **25368**

version right-hand

Code no.	Description	d	L	L2	L4	L5	h	f	a	Size
		mm	mm	mm	mm	mm	mm	mm	mm	
12.021	GB305.0750.600.90.04.R	19.05	152.40	14.60	116.84	5.08	17.04	14.48	30.48	04
12.001	GB305.0020.150.90.04.R	20.00	150.00	14.60	115.00	5.00	18.00	15.00	31.50	04
12.002	GB305.0025.170.90.04.R	25.00	170.00	14.60	130.00	5.00	23.00	17.50	34.50	04
12.022	GB305.1000.670.90.04.R	25.40	170.18	14.60	129.54	5.08	23.39	17.78	34.54	04
12.023	GB305.1250.800.90.04.R	31.75	205.20	14.60	162.56	5.08	29.74	21.08	39.37	04
12.003	GB305.0032.200.90.04.R	32.00	200.00	14.60	160.00	5.00	30.00	21.00	39.25	04
12.024	GB305.0750.600.90.06.R	19.05	152.40	14.60	116.84	5.08	17.04	14.48	30.48	06
12.004	GB305.0020.150.90.06.R	20.00	150.00	14.60	115.00	5.00	18.00	15.00	31.50	06
12.005	GB305.0025.170.90.06.R	25.00	170.00	14.60	130.00	5.00	23.00	17.50	34.50	06
12.025	GB305.1000.670.90.06.R	25.40	170.18	14.60	129.54	5.08	23.39	17.78	34.54	06
12.026	GB305.1250.800.90.06.R	31.75	203.20	14.60	162.56	5.08	29.74	21.08	39.37	06
12.006	GB305.0032.200.90.06.R	32.00	200.00	14.60	160.00	5.00	30.00	21.00	39.25	06
12.027	GB305.0750.600.90.08.R	19.05	152.40	14.60	116.84	5.08	17.04	14.48	30.48	08
12.007	GB305.0020.150.90.08.R	20.00	150.00	14.60	115.00	5.00	18.00	15.00	31.50	08
12.008	GB305.0025.170.90.08.R	25.00	170.00	14.60	130.00	5.00	23.00	17.50	34.50	08
12.028	GB305.1000.670.90.08.R	25.40	170.18	14.60	129.54	5.08	23.39	17.78	34.54	08
12.029	GB305.1250.800.90.08.R	31.75	203.20	14.60	162.56	5.08	29.74	21.08	39.37	08
12.009	GB305.0032.200.90.08.R	32.00	200.00	14.60	160.00	5.00	30.00	21.00	39.25	08
12.030	GB305.0750.600.90.12.R	19.05	152.40	19.60	116.84	5.08	17.04	14.48	30.48	12
12.010	GB305.0020.150.90.12.R	20.00	150.00	19.60	115.00	5.00	18.00	15.00	31.50	12
12.011	GB305.0025.170.90.12.R	25.00	170.00	19.60	130.00	5.00	23.00	17.50	34.50	12
12.031	GB305.1000.670.90.12.R	25.40	170.18	19.60	129.54	5.08	23.39	17.78	34.54	12
12.032	GB305.1250.800.90.12.R	31.75	203.20	19.60	162.56	5.08	29.74	21.08	39.37	12
12.012	GB305.0032.200.90.12.R	32.00	200.00	19.60	160.00	5.00	30.00	21.00	39.25	12

Article no. **25369**

version left-hand

Code no.	Description	d	L	L2	L4	L5	h	f	a	Size
		mm	mm	mm	mm	mm	mm	mm	mm	
12.021	GB305.0750.600.90.04.L	19.05	152.40	14.60	116.84	5.08	17.04	14.48	30.48	04
12.001	GB305.0020.150.90.04.L	20.00	150.00	14.60	115.00	5.00	18.00	15.00	31.50	04
12.002	GB305.0025.170.90.04.L	25.00	170.00	14.60	130.00	5.00	23.00	17.50	34.50	04
12.022	GB305.1000.670.90.04.L	25.40	170.18	14.60	129.54	5.08	23.39	17.78	34.54	04
12.023	GB305.1250.800.90.04.L	31.75	205.20	14.60	162.56	5.08	29.74	21.08	39.37	04
12.003	GB305.0032.200.90.04.L	32.00	200.00	14.60	160.00	5.00	30.00	21.00	39.25	04

System 305

Code no.	Description	d	L	L2	L4	L5	h	f	a	Size
		mm	mm	mm	mm	mm	mm	mm	mm	
12.024	GB305.0750.600.90.06.L	19.05	152.40	14.60	116.84	5.08	17.04	14.48	30.48	06
12.004	GB305.0020.150.90.06.L	20.00	150.00	14.60	115.00	5.00	18.00	15.00	31.50	06
12.005	GB305.0025.170.90.06.L	25.00	170.00	14.60	130.00	5.00	23.00	17.50	34.50	06
12.025	GB305.1000.670.90.06.L	25.40	170.18	14.60	129.54	5.08	23.39	17.78	34.54	06
12.026	GB305.1250.800.90.06.L	31.75	203.20	14.60	162.56	5.08	29.74	21.08	39.37	06
12.006	GB305.0032.200.90.06.L	32.00	200.00	14.60	160.00	5.00	30.00	21.00	39.25	06
12.027	GB305.0750.600.90.08.L	19.05	152.40	14.60	116.84	5.08	17.04	14.48	30.48	08
12.007	GB305.0020.150.90.08.L	20.00	150.00	14.60	115.00	5.00	18.00	15.00	31.50	08
12.008	GB305.0025.170.90.08.L	25.00	170.00	14.60	130.00	5.00	23.00	17.50	34.50	08
12.028	GB305.1000.670.90.08.L	25.40	170.18	14.60	129.54	5.08	23.39	17.78	34.54	08
12.029	GB305.1250.800.90.08.L	31.75	203.20	14.60	162.56	5.08	29.74	21.08	39.37	08
12.009	GB305.0032.200.90.08.L	32.00	200.00	14.60	160.00	5.00	30.00	21.00	39.25	08
12.030	GB305.0750.600.90.12.L	19.05	152.40	19.60	116.84	5.08	17.04	14.48	30.48	12
12.010	GB305.0020.150.90.12.L	20.00	150.00	19.60	115.00	5.00	18.00	15.00	31.50	12
12.011	GB305.0025.170.90.12.L	25.00	170.00	19.60	130.00	5.00	23.00	17.50	34.50	12
12.031	GB305.1000.670.90.12.L	25.40	170.18	19.60	129.54	5.08	23.39	17.78	34.54	12
12.032	GB305.1250.800.90.12.L	31.75	203.20	19.60	162.56	5.08	29.74	21.08	39.37	12
12.012	GB305.0032.200.90.12.L	32.00	200.00	19.60	160.00	5.00	30.00	21.00	39.25	12

**Spare parts**

Article no.	Clamping screw	Tightening torque	Size
25901		Nm	
Code 4.000	M4x15x15IP	4-4.5	04-08
Code 4.003	M4x17x15IP	4-4.5	12

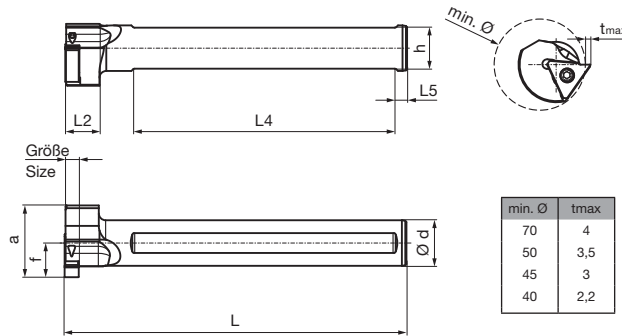
Article no.	Torx-Plus Wrench
25904	
Code 15.000	T15IP T-handle


**Round shank holder, internal machining, with IC**

- grooving depth up to 4 mm
- with internal coolant supply from above

Type GB 305

for indexable inserts type 305 see from page 171


 Right hand version shown  
 Left hand version mirror image

 Article no. **25370**

version right-hand

Code no.	Description	d	L	L2	L4	L5	h	f	a	Size
		mm	mm	mm	mm	mm	mm	mm	mm	
12.021	GB305.0750.600.90.04.R.IK	19.05	152.40	14.60	116.84	5.08	17.04	14.48	30.48	04
12.001	GB305.0020.150.90.04.R.IK	20.00	150.00	14.60	115.00	5.00	18.00	15.00	31.50	04
12.002	GB305.0025.170.90.04.R.IK	25.00	170.00	14.60	130.00	5.00	23.00	17.50	34.50	04
12.022	GB305.1000.670.90.04.R.IK	25.40	170.18	14.60	129.54	5.08	23.39	17.78	34.54	04
12.023	GB305.1250.800.90.04.R.IK	31.75	205.20	14.60	162.56	5.08	29.74	21.08	39.37	04
12.003	GB305.0032.200.90.04.R.IK	32.00	200.00	14.60	160.00	5.00	30.00	21.00	39.25	04
12.024	GB305.0750.600.90.06.R.IK	19.05	152.40	14.60	116.84	5.08	17.04	14.48	30.48	06
12.004	GB305.0020.150.90.06.R.IK	20.00	150.00	14.60	115.00	5.00	18.00	15.00	31.50	06
12.005	GB305.0025.170.90.06.R.IK	25.00	170.00	14.60	130.00	5.00	23.00	17.50	34.50	06
12.025	GB305.1000.670.90.06.R.IK	25.40	170.18	14.60	129.54	5.08	23.39	17.78	34.54	06
12.026	GB305.1250.800.90.06.R.IK	31.75	203.20	14.60	162.56	5.08	29.74	21.08	39.37	06
12.006	GB305.0032.200.90.06.R.IK	32.00	200.00	14.60	160.00	5.00	30.00	21.00	39.25	06
12.027	GB305.0750.600.90.12.R.IK	19.05	152.40	14.60	116.84	5.08	17.04	14.48	30.48	08
12.007	GB305.0020.150.90.08.R.IK	20.00	150.00	14.60	115.00	5.00	18.00	15.00	31.50	08
12.008	GB305.0025.170.90.08.R.IK	25.00	170.00	14.60	130.00	5.00	23.00	17.50	34.50	08
12.028	GB305.1000.670.90.08.R.IK	25.40	170.18	14.60	129.54	5.08	23.39	17.78	34.54	08
12.029	GB305.1250.800.90.08.R.IK	31.75	203.20	14.60	162.56	5.08	29.74	21.08	39.37	08
12.009	GB305.0032.200.90.08.R.IK	32.00	200.00	14.60	160.00	5.00	30.00	21.00	39.25	08
12.030	GB305.0750.600.90.06.R.IK	19.05	152.40	19.60	116.84	5.08	17.04	14.48	30.48	12
12.010	GB305.0020.150.90.12.R.IK	20.00	150.00	19.60	115.00	5.00	18.00	15.00	31.50	12
12.011	GB305.0025.170.90.12.R.IK	25.00	170.00	19.60	130.00	5.00	23.00	17.50	34.50	12
12.031	GB305.1000.670.90.12.R.IK	25.40	170.18	19.60	129.54	5.08	23.39	17.78	34.54	12
12.032	GB305.1250.800.90.12.R.IK	31.75	203.20	19.60	162.56	5.08	29.74	21.08	39.37	12
12.012	GB305.0032.200.90.12.R.IK	32.00	200.00	19.60	160.00	5.00	30.00	21.00	39.25	12

 Article no. **25371**

version left-hand

Code no.	Description	d	L	L2	L4	L5	h	f	a	Size
		mm	mm	mm	mm	mm	mm	mm	mm	
12.021	GB305.0750.600.90.04.L.IK	19.05	152.40	14.60	116.84	5.08	17.04	14.48	30.48	04
12.001	GB305.0020.150.90.04.L.IK	20.00	150.00	14.60	115.00	5.00	18.00	15.00	31.50	04
12.002	GB305.0025.170.90.04.L.IK	25.00	170.00	14.60	130.00	5.00	23.00	17.50	34.50	04
12.022	GB305.1000.670.90.04.L.IK	25.40	170.18	14.60	129.54	5.08	23.39	17.78	34.54	04
12.023	GB305.1250.800.90.04.L.IK	31.75	205.20	14.60	162.56	5.08	29.74	21.08	39.37	04
12.003	GB305.0032.200.90.04.L.IK	32.00	200.00	14.60	160.00	5.00	30.00	21.00	39.25	04

Code no.	Description	d	L	L2	L4	L5	h	f	a	Size
		mm	mm	mm	mm	mm	mm	mm	mm	
12.024	GB305.0750.600.90.06.L.IK	19.05	152.40	14.60	116.84	5.08	17.04	14.48	30.48	06
12.004	GB305.0020.150.90.06.L.IK	20.00	150.00	14.60	115.00	5.00	18.00	15.00	31.50	06
12.005	GB305.0025.170.90.06.L.IK	25.00	170.00	14.60	130.00	5.00	23.00	17.50	34.50	06
12.025	GB305.1000.670.90.06.L.IK	25.40	170.18	14.60	129.54	5.08	23.39	17.78	34.54	06
12.026	GB305.1250.800.90.06.L.IK	31.75	203.20	14.60	162.56	5.08	29.74	21.08	39.37	06
12.006	GB305.0032.200.90.06.L.IK	32.00	200.00	14.60	160.00	5.00	30.00	21.00	39.25	06
12.027	GB305.0750.600.90.12.L.IK	19.05	152.40	14.60	116.84	5.08	17.04	14.48	30.48	08
12.007	GB305.0020.150.90.08.L.IK	20.00	150.00	14.60	115.00	5.00	18.00	15.00	31.50	08
12.008	GB305.0025.170.90.08.L.IK	25.00	170.00	14.60	130.00	5.00	23.00	17.50	34.50	08
12.028	GB305.1000.670.90.08.L.IK	25.40	170.18	14.60	129.54	5.08	23.39	17.78	34.54	08
12.029	GB305.1250.800.90.08.L.IK	31.75	203.20	14.60	162.56	5.08	29.74	21.08	39.37	08
12.009	GB305.0032.200.90.08.L.IK	32.00	200.00	14.60	160.00	5.00	30.00	21.00	39.25	08
12.030	GB305.0750.600.90.06.L.IK	19.05	152.40	19.60	116.84	5.08	17.04	14.48	30.48	12
12.010	GB305.0020.150.90.12.L.IK	20.00	150.00	19.60	115.00	5.00	18.00	15.00	31.50	12
12.011	GB305.0025.170.90.12.L.IK	25.00	170.00	19.60	130.00	5.00	23.00	17.50	34.50	12
12.031	GB305.1000.670.90.12.L.IK	25.40	170.18	19.60	129.54	5.08	23.39	17.78	34.54	12
12.032	GB305.1250.800.90.12.L.IK	31.75	203.20	19.60	162.56	5.08	29.74	21.08	39.37	12
12.012	GB305.0032.200.90.12.L.IK	32.00	200.00	19.60	160.00	5.00	30.00	21.00	39.25	12

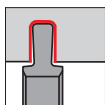
**Spare parts**

Article no.	Clamping screw	Tightening torque	Size
25901		Nm	
Code 4.000	M4x15x15IP	4-4.5	04-08
Code 4.003	M4x17x15IP	4-4.5	12

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



## Indexable insert for radial grooving external and internal

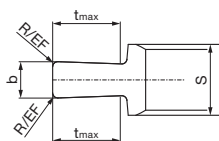
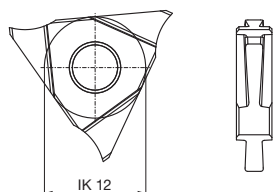


- snap ring grooves to DIN471/472, NW = 0.5-5.15
- indexable insert applicable in right and left holders
- geometry .BA ground
- pay attention to insert seat size 04 / 06

for tool holders type GH305/GB305 see from page 156

## GUHRING NAVIGATOR

Cutting data page 185

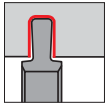


Article no. **25601** **25602** **25603**

Code no.	Description	NW	b ±0,02	R	EF	t max	s	Size
		mm	mm	mm	mm	mm	mm	
12.001	GE305.0050.000.BA.04.N	0.50	0.55			1.50	4.20	04
12.002	GE305.0060.000.BA.04.N	0.60	0.65			1.50	4.20	04
12.003	GE305.0070.000.BA.04.N	0.70	0.75			1.50	4.20	04
12.004	GE305.0080.000.BA.04.N	0.80	0.85			1.50	4.20	04
12.005	GE305.0090.000.BA.04.N	0.90	0.95			1.50	4.20	04
12.006	GE305.0100.000.BA.04.N	1.00	1.05		0.05	3.00	4.20	04
12.007	GE305.0110.000.BA.04.N	1.10	1.22		0.05	3.00	4.20	04
12.008	GE305.0130.000.BA.04.N	1.30	1.42		0.05	3.00	4.20	04
12.009	GE305.0160.000.BA.04.N	1.60	1.72		0.05	4.00	4.20	04
12.010	GE305.0185.015.BA.04.N	1.85	1.97	0.15		4.00	4.20	04
12.011	GE305.0215.015.BA.04.N	2.15	2.27	0.15		5.00	4.20	04
12.012	GE305.0265.015.BA.04.N	2.65	2.77	0.15		5.00	4.20	04
12.013	GE305.0315.015.BA.04.N	3.15	3.27	0.15		5.00	4.20	04
12.014	GE305.0415.015.BA.06.N	4.15	4.27	0.15		5.00	6.20	06
12.015	GE305.0515.015.BA.06.N	5.15	5.27	0.15		5.00	6.20	06

System 305

**Indexable insert for radial grooving and copying external and internal**



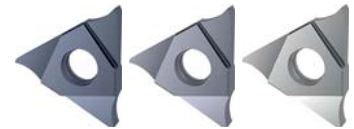
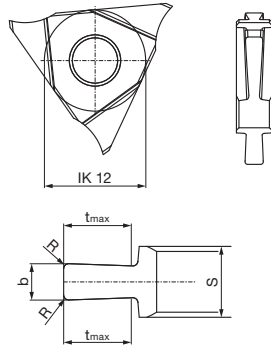
- grooving depth up to 5 mm
- indexable insert applicable in right and left holders
- geometry .BA ground

for tool holders type GH305/GB305 size 04 see from page 156

**GUHRING NAVIGATOR**

Cutting data page 185

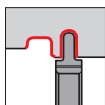
Tool material	Solid carbide		
Type	GE 305	GE 305	GE 305
Surface			
	FIRE	TiCN	bright



Article no. **25605** **25606** **25607**

System 305

Code no.	Description	b ±0,02	R	t max	s	Size
		mm	mm	mm	mm	
12.001	GE305.0100.010.BA.04.N	1.00	0.10	3.00	4.20	04
12.002	GE305.0150.020.BA.04.N	1.50	0.20	3.00	4.20	04
12.003	GE305.0200.020.BA.04.N	2.00	0.20	4.00	4.20	04
12.004	GE305.0250.030.BA.04.N	2.50	0.30	5.00	4.20	04
12.005	GE305.0300.030.BA.04.N	3.00	0.30	5.00	4.20	04
12.006	GE305.0350.030.BA.04.N	3.50	0.30	5.00	4.20	04
12.007	GE305.0400.020.BA.04.N	4.00	0.20	5.00	4.20	04
12.008	GE305.0400.040.BA.04.N	4.00	0.40	5.00	4.20	04

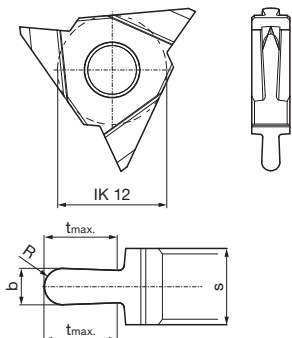

**Indexable insert for radial grooving and copying external and internal**


- grooving depth up to 5 mm
- indexable insert applicable in right and left holders
- geometry .AA ground

for tool holders type GH305/GB305 size 04 see from page 156

**GUHRING NAVIGATOR**

Cutting data page 185



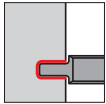
Article no. **25613** **25614** **25615**

Code no.	Description	b ±0,02	R	t max	s	Size
		mm	mm	mm	mm	
12.001	GE305.0050.025.AA.04.N	0.50	0.25	1.50	4.20	04
12.002	GE305.0100.050.AA.04.N	1.00	0.50	3.00	4.20	04
12.003	GE305.0110.055.AA.04.N	1.10	0.55	3.00	4.20	04
12.004	GE305.0120.060.AA.04.N	1.20	0.60	3.00	4.20	04
12.005	GE305.0140.070.AA.04.N	1.40	0.70	3.00	4.20	04
12.006	GE305.0150.075.AA.04.N	1.50	0.75	3.00	4.20	04
12.007	GE305.0160.080.AA.04.N	1.60	0.80	4.00	4.20	04
12.008	GE305.0180.090.AA.04.N	1.80	0.90	4.00	4.20	04
12.009	GE305.0200.100.AA.04.N	2.00	1.00	4.00	4.20	04
12.010	GE305.0220.110.AA.04.N	2.20	1.10	5.00	4.20	04
12.011	GE305.0250.125.AA.04.N	2.50	1.25	5.00	4.20	04
12.012	GE305.0280.140.AA.04.N	2.80	1.40	5.00	4.20	04
12.013	GE305.0300.150.AA.04.N	3.00	1.50	5.00	4.20	04
12.014	GE305.0360.180.AA.04.N	3.60	1.80	5.00	4.20	04
12.015	GE305.0400.200.AA.04.N	4.00	2.00	5.00	4.20	04

System 305



**Indexable insert for axial grooving, straight slots**

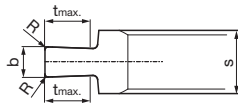
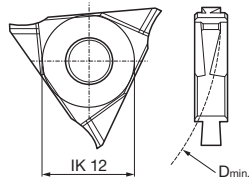


- grooving depth up to 3 mm
- right index. inserts in rh, left index. inserts in lh tool holders
- geometry .BA ground

for tool holders type GH305 size 04 see from page 156

**GUHRING NAVIGATOR**

Cutting data page 185



Right hand version shown  
Left hand version mirror image



Article no.	<b>25626</b>	<b>25628</b>	<b>25630</b>
Cutting direction			

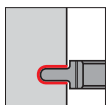
Code no.	Description	D min	b ±0,02	R	t max	s	Size
		mm	mm	mm	mm	mm	
12.001	GA305.0150.020.BA.04.R	15.00	1.50	0.20	2.00	4.20	04
12.002	GA305.0200.020.BA.04.R	30.00	2.00	0.20	3.00	4.20	04
12.003	GA305.0250.020.BA.04.R	30.00	2.50	0.20	3.00	4.20	04
12.004	GA305.0300.020.BA.04.R	30.00	3.00	0.20	3.00	4.20	04

Article no.	<b>25627</b>	<b>25629</b>	<b>25631</b>
Cutting direction			

Code no.	Description	D min	b ±0,02	R	t max	s	Size
		mm	mm	mm	mm	mm	
12.001	GA305.0150.020.BA.04.L	15.00	1.50	0.20	2.00	4.20	04
12.002	GA305.0200.020.BA.04.L	30.00	2.00	0.20	3.00	4.20	04
12.003	GA305.0250.020.BA.04.L	30.00	2.50	0.20	3.00	4.20	04
12.004	GA305.0300.020.BA.04.L	30.00	3.00	0.20	3.00	4.20	04



**Indexable insert for axial grooving, full radius slots**

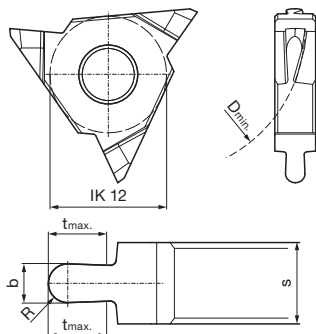


- grooving depth up to 3 mm
- right index. inserts in rh, left index. inserts in lh tool holders
- geometry .AA ground

for tool holders type GH305 size 04 see from page 156

**GUHRING NAVIGATOR**

Cutting data page 185



Right hand version shown  
Left hand version mirror image

Article no. **25634**    **25636**    **25638**

Cutting direction

Code no.	Description	D min	b ±0,02	R	t max	s	Size
		mm	mm	mm	mm	mm	
12.001	GA305.0150.075.AA.04.R	15.00	1.50	0.75	2.00	4.20	04
12.002	GA305.0200.100.AA.04.R	30.00	2.00	1.00	3.00	4.20	04
12.003	GA305.0300.150.AA.04.R	30.00	3.00	1.50	3.00	4.20	04
12.004	GA305.0400.200.AA.04.R	30.00	4.00	2.00	3.00	4.20	04

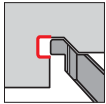
Article no. **25635**    **25637**    **25639**

Cutting direction

Code no.	Description	D min	b ±0,02	R	t max	s	Size
		mm	mm	mm	mm	mm	
12.001	GA305.0150.075.AA.04.L	15.00	1.50	0.75	2.00	4.20	04
12.002	GA305.0200.100.AA.04.L	30.00	2.00	1.00	3.00	4.20	04
12.003	GA305.0300.150.AA.04.L	30.00	3.00	1.50	3.00	4.20	04
12.004	GA305.0400.200.AA.04.L	30.00	4.00	2.00	3.00	4.20	04

System 305

**Indexable insert for grooving axial external recesses**

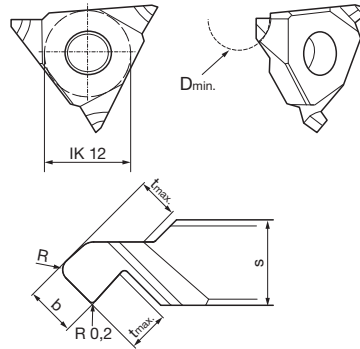


- grooving depth up to 2 mm
- right index. inserts in rh, left index. inserts in lh tool holders
- geometry .AA ground
- for axial external recesses to ISO 9974-2

for tool holders type GH305, 45° depressed centre, see page 165

**GUHRING NAVIGATOR**

Cutting data page 185



Right hand version shown  
Left hand version mirror image

Article no. **25618** **25620** **25622**

Cutting direction

Code no.	Description	D min	b ±0,02	R	t max	s	Size
		mm	mm	mm	mm	mm	
12.001	GA305.0150.040.AA.04.R	8.00	1.50	0.40	1.60	4.20	04
12.002	GA305.0200.050.AA.04.R	12.00	2.00	0.50	1.90	4.20	04
12.003	GA305.0240.060.AA.04.R	20.00	2.40	0.60	2.00	4.20	04

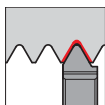
Article no. **25619** **25621** **25623**

Cutting direction

Code no.	Description	D min	b ±0,02	R	t max	s	Size
		mm	mm	mm	mm	mm	
12.001	GA305.0150.040.AA.04.L	8.00	1.50	0.40	1.60	4.20	04
12.002	GA305.0200.050.AA.04.L	12.00	2.00	0.50	1.90	4.20	04
12.003	GA305.0240.060.AA.04.L	20.00	2.40	0.60	2.00	4.20	04



## Indexable insert for thread turning, part profile

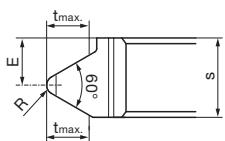
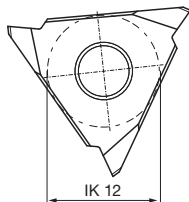


- grooving depth up to 3.5 mm
- ground top rake
- geometry .AA ground
- pay attention to insert seat size 04 / 06

for tool holders type GH305/GB305 see from page 156

## GUHRING NAVIGATOR

Cutting data page 185



Right hand version shown  
Left hand version mirror image



Article no.	25654	25656	25658
Cutting direction			

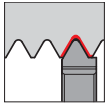
Code no.	Description	P	E	R	t max	s	Size
			mm	mm	mm	mm	
12.010	GG305.TM00.100.AA.04.R	1,00	3.60	0.14	0.70	4.20	04
12.020	GG305.TM00.125.AA.04.R	1,25	3.50	0.17	0.85	4.20	04
12.030	GG305.TM00.150.AA.04.R	1,50	3.40	0.21	1.00	4.20	04
12.040	GG305.TM00.175.AA.04.R	1,75	3.20	0.25	1.20	4.20	04
12.050	GG305.TM00.200.AA.04.R	2,00	3.10	0.28	1.35	4.20	04
12.060	GG305.TM00.250.AA.04.R	2,50	2.90	0.36	1.65	4.20	04
12.070	GG305.TM00.300.AA.04.R	3,00	2.60	0.43	2.60	4.20	04
12.080	GG305.TM00.600.AA.06.R	3,0-6,0	3.50	0.43	3.50	6.20	06
12.090	GG305.TM00.350.AA.04.R	3,50	2.50	0.50	2.50	4.20	04

Article no.	25655	25657	25659
Cutting direction			

Code no.	Description	P	E	R	t max	s	Size
			mm	mm	mm	mm	
12.010	GG305.TM00.100.AA.04.L	1,00	3.60	0.14	0.70	4.20	04
12.020	GG305.TM00.125.AA.04.L	1,25	3.50	0.17	0.85	4.20	04
12.030	GG305.TM00.150.AA.04.L	1,50	3.40	0.21	1.00	4.20	04
12.040	GG305.TM00.175.AA.04.L	1,75	3.20	0.25	1.20	4.20	04
12.050	GG305.TM00.200.AA.04.L	2,00	3.10	0.28	1.35	4.20	04
12.060	GG305.TM00.250.AA.04.L	2,50	2.90	0.36	1.65	4.20	04
12.070	GG305.TM00.300.AA.04.L	3,00	2.60	0.43	2.60	4.20	04
12.080	GG305.TM00.600.AA.06.L	3,0-6,0	3.50	0.43	3.50	6.20	06
12.090	GG305.TM00.350.AA.04.L	3,50	2.50	0.50	2.50	4.20	04

System 305

**Indexable insert for thread turning, full profile**

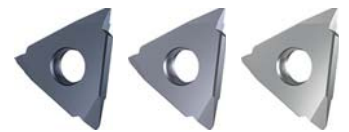
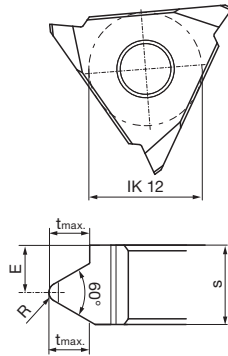


- grooving depth up to 3.9 mm
- ground top rake
- geometry .AA ground
- pay attention to insert seat size 04 / 06 / 08

for tool holders type GH305/GB305 see from page 156

**GUHRING NAVIGATOR**

Cutting data page 185



Right hand version shown  
Left hand version mirror image

Tool material	Solid carbide		
Type	GG 305	GG 305	GG 305
Surface			
	FIRE	TiCN	bright

Article no. **25662** **25664** **25666**

Cutting direction

Code no.	Description	P	E	R	t max	s	Size
		mm	mm	mm	mm	mm	
12.010	GG305.VM00.100.AA.04.R	1.00	3.60	0.14	0.70	4.20	04
12.020	GG305.VM00.125.AA.04.R	1.25	3.40	0.17	1.00	4.20	04
12.030	GG305.VM00.150.AA.04.R	1.50	3.30	0.21	1.15	4.20	04
12.040	GG305.VM00.175.AA.04.R	1.75	3.20	0.25	1.30	4.20	04
12.050	GG305.VM00.200.AA.04.R	2.00	3.10	0.28	1.45	4.20	04
12.060	GG305.VM00.250.AA.04.R	2.50	2.90	0.36	1.75	4.20	04
12.070	GG305.VM00.300.AA.04.R	3.00	2.70	0.43	2.10	4.20	04
12.080	GG305.VM00.350.AA.04.R	3.50	2.40	0.50	2.40	4.20	04
12.090	GG305.VM00.400.AA.06.R	4.00	4.20	0.57	2.70	6.20	06
12.100	GG305.VM00.500.AA.06.R	5.00	3.80	0.72	3.30	6.20	06
12.110	GG305.VM00.600.AA.08.R	6.00	5.20	0.86	3.90	8.20	08

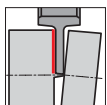
Article no. **25663** **25665** **25667**

Cutting direction

Code no.	Description	P	E	R	t max	s	Size
		mm	mm	mm	mm	mm	
12.010	GG305.VM00.100.AA.04.L	1.00	3.60	0.14	0.70	4.20	04
12.020	GG305.VM00.125.AA.04.L	1.25	3.40	0.17	1.00	4.20	04
12.030	GG305.VM00.150.AA.04.L	1.50	3.30	0.21	1.15	4.20	04
12.040	GG305.VM00.175.AA.04.L	1.75	3.20	0.25	1.30	4.20	04
12.050	GG305.VM00.200.AA.04.L	2.00	3.10	0.28	1.45	4.20	04
12.060	GG305.VM00.250.AA.04.L	2.50	2.90	0.36	1.75	4.20	04
12.070	GG305.VM00.300.AA.04.L	3.00	2.70	0.43	2.10	4.20	04
12.080	GG305.VM00.350.AA.04.L	3.50	2.40	0.50	2.40	4.20	04
12.090	GG305.VM00.400.AA.06.L	4.00	4.20	0.57	2.70	6.20	06
12.100	GG305.VM00.500.AA.06.L	5.00	3.80	0.72	3.30	6.20	06
12.110	GG305.VM00.600.AA.08.L	6.00	5.20	0.86	3.90	8.20	08



## Indexable insert for parting off

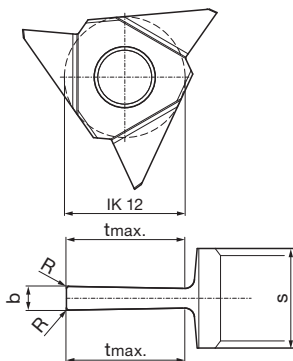


- grooving depth up to 5 mm
- indexable insert applicable in right and left holders
- geometry .AA ground
- without front cutting angle

for tool holders type GH305 size 04 see from page 156

## GUHRING NAVIGATOR

Cutting data page 185

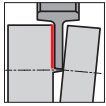


Article no. **25641** **25642** **25643**

Code no.	Description	b ±0,02	R	t max	s	Size
		mm	mm	mm	mm	
12.001	GZ305.0100.000.AA.04.N	1.00	0.10	5.00	4.20	04
12.002	GZ305.0150.000.AA.04.N	1.50	0.10	5.00	4.20	04

System 305

**Indexable insert for parting off**

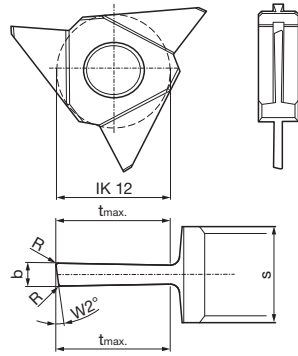


- grooving depth up to 5 mm
- indexable insert applicable in right and left holders
- geometry .AA ground
- with front cutting angle

for tool holders type GH305 size 04 see from page 156

**GUHRING NAVIGATOR**

Cutting data page 185



Right hand version shown  
Left hand version mirror image



Tool material	Solid carbide		
Type	GZ 305	GZ 305	GZ 305
Surface			
	FIRE	TiCN	bright

Article no. **25646** **25648** **25650**  
version right-hand right-hand right-hand

Code no.	Description	b ±0,02	R	W2	t max	s	Size
		mm	mm	°	mm	mm	
12.001	GZ305.0100.080.AA.04.R	1.00	0.10	8.00	5.00	4.20	04
12.002	GZ305.0150.080.AA.04.R	1.50	0.10	8.00	5.00	4.20	04

Article no. **25647** **25649** **25651**  
version left-hand left-hand left-hand

Code no.	Description	b ±0,02	R	W2	t max	s	Size
		mm	mm	°	mm	mm	
12.001	GZ305.0100.080.AA.04.L	1.00	0.10	8.00	5.00	4.20	04
12.002	GZ305.0150.080.AA.04.L	1.50	0.10	8.00	5.00	4.20	04



### External radial grooving

Application: External radial grooving	Tool selection	Customer benefit
Component: Shaft	System: 305	Instantly, Guhring's insert with three cutting edges convinced with good chip evacuation and longer tool life.
Material: C60	Holder: GH305.2020.125.00.04.R	
1.0601	Insert: GE305.0130.000.BA.04.N	
Machine: Gildemeister CTX410		
Cooling: External cooling, 10 bar		
Oper. step: Grooving to 1.4 mm		
vc: 100 m/min		
f: 0.15 mm		
ap:		
Groov. depth: 0.7 mm		



### External radial grooving

Application: External radial grooving	Tool selection	Customer benefit
Component: Shaft	System: 305	The change from external cooling to a Guhring holder with internal cooling resulted in a considerably longer tool life. There is one tool change less per shift and 25 more components can be manufactured per shift.
Material: Ck50	Holder: GH305.2020.125.00.04.R.IK	
1.1206	Insert: Special grooving insert b 2.72 mm	
Machine: Gildemeister CTX420		
Cooling: 10 bar		
Oper. step: Grooving to b 2.72 mm		
vc: 10 m/min		
f: 0.08 mm		
ap:		
Groov. depth: 1.3 mm		



### Axial grooving

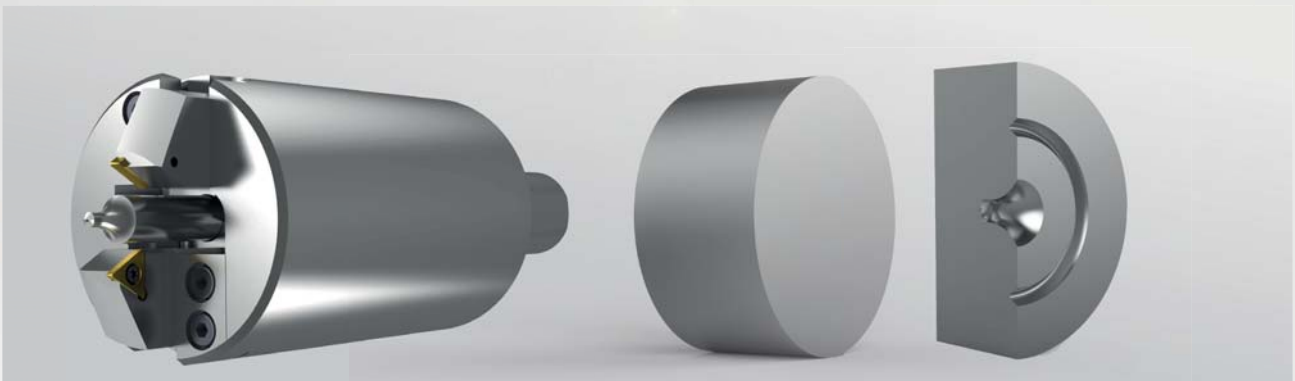
Application: Axial grooving	Tool selection	Customer benefit
Component: Adapter sleeve	System: 106	Under the same application conditions, the Guhring tool instantly achieves 50% more components. Therefore, there is much improvement potential in this application in order to increase cutting speed and feed rate to save time.
Material: 16 MnCr 5	Holder: GB106.0020.040.00.22.N.IK.CIT	
1.7139	Insert: GA106.0200.015.17.60.R	
Machine: Citizen A20		
Cooling: Neat oil, 80 bar		
Oper. step: Semi-finishing		
vc: 100 m/min		
f: 0.02 mm		
ap: D1 7.5 mm/D2 12.6 mm		
Groov. depth: 2.9 mm		



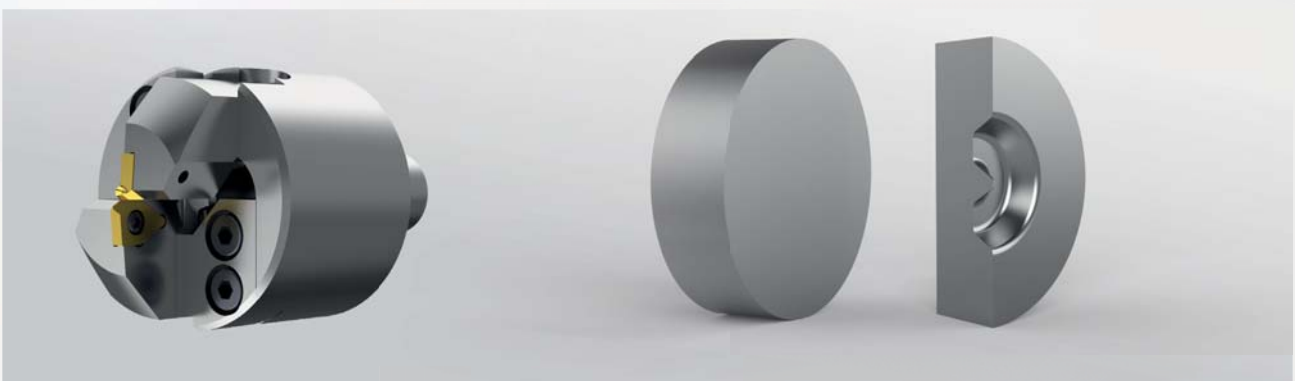
# GE 100

## MULTIFUNCTIONAL tool systems for END MACHINING

- \ Modular system for machining various component dimensions: facing, chamfering, turning, and centre boring with only one tool
- \ Precision polished DIN indexable insert range and special contours available



- | Tool: Drive shaft – input post
- | Material: 20MnCrS5
- | Machining: Grooving and centre drilling
- | Customer benefit: shorter machining times, quicker and easier change of cutting tool



- | Tool: Electronic component - Pin
- | Material: CuZn39Pb3
- | Machining: Grooving with profile plate
- | Customer benefit: Processing safety, precise reproducibility












# TECHNICAL SECTION & ACCESSORIES

Technical section  
& Accessories



**GUHRING**NAVIGATOR  
 SYSTEM 104/106/108/110

Machining	Feed range f (mm/rev.)	Point radius R	Cutting depth a <sub>p</sub> (mm)	General formulas
  	0.02 - 0.08	R 0.05 R 0.10 R 0.15 R 0.20 R 0.25 R 0.30	0.02 - 0.07 0.05 - 0.15 0.08 - 0.20 0.12 - 0.25 0.13 - 0.28 0.17 - 0.35	Cutting speed (v <sub>c</sub> ) $v_c = \frac{d_1 \cdot \pi \cdot n}{1000}$ [m/min]
  	0.01 - 0.03			Revolutions per minute (n) $n = \frac{v_c \cdot 1000}{d_1 \cdot \pi}$ [U/min]
  	0.01 - 0.05		Rule of thumb: a <sub>p</sub> ~ r	Feed rate (v <sub>f</sub> ) v <sub>f</sub> = f · n [mm/min]

Guide values for feed and cutting depths

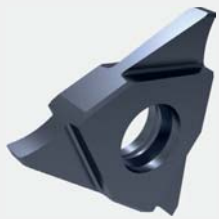
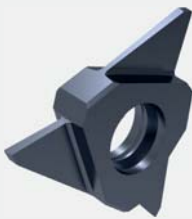
ISO	Material	Material examples/ material number	Tensile strength (N/mm <sup>2</sup> )	Brinell hardness (HB)	Cutting speed v <sub>c</sub> (m/min)			
					TiN Ⓢ	TiAlN nanoA Ⓢ	Bright ○	
P	Carbon steel	C <= 0.15%	11SMn30+C / 1.0715 C15 / 1.0401	500 600	150 180	20-160	50-200	15-90
		C ≥ 0.15-0.45%	S235JR (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			
	Low-alloyed steel (alloy content ≤5%)	annealed	16MnCr5 / 1.7131 18CrNi8 / 1.5920	650 650	200 200	20-160	50-180	15-70
		heat-treatable	25CrMoV4 / 1.7218 42CrMo4V / 1.7225	900 1100	270 320			
	High-alloyed steel (alloy content >5%)	annealed	X37CrMoV5-1 / 1.2343 X153CrMoV12 / 1.2379	750 850	220 250	25-90	40-140	-
		heat-treatable	55NiCrMoV7 / 1.2714	1200	350			
	Cast steel	un-alloyed, low-alloyed	GS52 / 1.0552	600	180	20-120	30-180	-
		high-alloyed	GX40CrNiSi22-10 / 1.4826	750	220	-	30-90	-
	M	Stainless steel	martensitic, ferritic, tempered	X14CrMoS17 / 1.4104 X4CrNiMo16-5-1 / 1.4418	800 1000	240 300	20-70	30-90
austenitic, Ni > 8%				X5CrNi18-10 / 1.4301 X2CrNiMo17-12-2 / 1.4404	650	200		
			austenitic, ferritic (Duplex)	X2CrNiMoCuN25-6-3 / 1.4507 X2CrNiMoN25-7-4 / 1.4410	850	250	-	30-100
K				Grey cast iron	low tensile strength	EN-GJL-200 (GG20) / 0.6020		180
	high tensile strength	EN-GJL-400 (GG40) / 0.6040			260	30-120	30-150	30-70
	Spheroidal graphite iron	low tensile strength	EN-GJS-400-15 (GGG40) / 0.7040		160	30-130	30-160	-
		high tensile strength	EN-GJS-700-2 (GGG70) / 0.7070		260	30-110	30-140	-
	Malleable cast iron	low tensile strength	EN-GJMW-350-4 (GTW35) / 0.8035		125	30-130	30-160	-
		high tensile strength	EN-GJMB-550-4 (GTS55) / 0.8155		250	30-110	30-140	-
N	Al-alloys	non-heat-treatable <12% Si	EN-AW-2017 (AlCuMg1) / 3.1325		60	30-550	30-550	30-250
		heat-treatable <12% Si	EN-AW-6082 (AlMgSi1) / 3.2315		100	30-400	30-400	30-180
	Al-cast-alloys	non-heat-treatable <12% Si	AlSi9Cu3 / 3.2163		80	30-550	30-550	30-250
		heat-treatable <12% Si	AlSi10Mg / 3.2383		100	30-400	30-400	30-180
	Copper alloys	brass, lead alloy	CuZn39Pb2 (MS58) / 2.0380	400	120	30-400	30-400	30-180
		bronze	CuSn6 / 2.1020	500	150	30-240	30-240	30-180
S	Heat resistant alloys, super alloys	NiFe-base, annealed	NiCr15Fe (Alloy600) / 2.4816	700		-	15-70	
		NiFe-Basis, hardened		950		-	15-50	
		NiCo-Basis, annealed	NiMo16Cr15W (Alloy C-276) / 2.4819	800		-	15-50	
		NiCo-Basis, cast		1100		-	10-40	-
	Titanium-alloys	annealed	Ti6Al4V / 3.7164	900		-	15-50	
		hardened		1200		-	10-35	
H	Hardened steels	Heat-treatable steel			> 52 HRC	-	20 - 40	-
		Heat-treatable steel, case hardened steel			> 59 HRC	-	10 - 30	-
		Heat-treatable steel, case hardened steel			> 62 HRC	-	(CBN)	-

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



**GUHRING**NAVIGATOR

SYSTEM 305

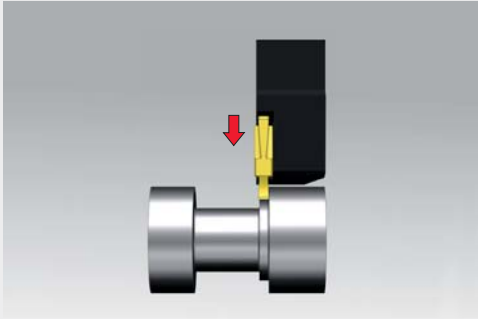
 <p><b>Geometry .BA</b> ground round chip breaker</p>	<p><b>Feed rate</b> f (mm/rev.)</p> <p>↓ 0.03 - 0.15</p> <p>↔ 0.02 - 0.12 ap = 0.1 - 0.5 mm</p>	 <p><b>Geometry .AA</b> ground flat chip breaker</p>	<p><b>Feed rate</b> f (mm/rev.)</p> <p>↓ 0.03 - 0.15</p> <p>↔ 0.02 - 0.12 ap = 0.1 - 0.5 mm</p>	<p><b>General formulas</b></p> <p>Cutting speed (<math>v_c</math>)  <math display="block">v_c = \frac{d_1 \cdot \pi \cdot n}{1000} \text{ [m/min]}</math> </p> <p>Revolutions per minute (n)  <math display="block">n = \frac{v_c \cdot 1000}{d_1 \cdot \pi} \text{ [U/min]}</math> </p> <p>Feed rate (<math>v_f</math>)  <math display="block">v_f = f \cdot n \text{ [mm/min]}</math> </p>
	<p>↓ = radial feed direction      ↔ = axial feed direction</p>			

ISO	Material	Material examples/ material number	Tensile strength (N/mm <sup>2</sup> )	Brinell hardness (HB)	Cutting speed vc (m/min)		
					FIRE/nanoFIRE	TiCN	
P	Carbon steel	C <= 0.15%	11SMn30+C / 1.0715 C15 / 1.0401	500 600	150 180	150-220	130-200
		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		
	Low-alloyed steel (alloy content ≤5%)	annealed	16MnCr5 / 1.7131 18CrNi8 / 1.5920	650 650	200 200	120-170	90-150
		heat-treatable	25CrMoV4 / 1.7218 42CrMo4V / 1.7225	900 1100	270 320	90-150	70-130
	High-alloyed steel (alloy content >5%)	annealed	X37CrMoV5-1 / 1.2343 X153CrMoV12 / 1.2379	750 850	220 250	130-180	-
		heat-treatable	55NiCrMoV7 / 1.2714	1200	350	70-120	-
	Cast steel	un-alloyed, low-alloyed	GS52 / 1.0552	600	180	130-180	-
		high-alloyed	GX40CrNiSi22-10 / 1.4826	750	220	100-140	-
	M	Stainless steel	martensitic, ferritic, tempered	X14CrMoS17 / 1.4104 X4CrNiMo16-5-1 / 1.4418	800 1000	240 300	90-160
austenitic, Ni > 8%			X5CrNi18-10 / 1.4301 X2CrNiMo17-12-2 / 1.4404	650	200	90-160	70-140
austenitic, ferritic (Duplex)			X2CrNiMoCuN25-6-3 / 1.4507 X2CrNiMoN25-7-4 / 1.4410	850	250	70-100	50-120
K	Grey cast iron	low tensile strength	EN-GJL-200 (GG20) / 0.6020		180	90-150	-
		high tensile strength	EN-GJL-400 (GG40) / 0.6040		260	70-110	-
	Spheroidal graphite iron	low tensile strength	EN-GJS-400-15 (GGG40) / 0.7040		160	90-150	70-100
		high tensile strength	EN-GJS-700-2 (GGG70) / 0.7070		260	70-110	50-90
	Malleable cast iron	low tensile strength	EN-GJMW-350-4 (GTW35) / 0.8035		125	70-140	60-100
		high tensile strength	EN-GJMB-550-4 (GTS55) / 0.8155		250	50-90	50-70
N	Al-alloys	non-heat-treatable <12% Si	EN-AW-2017 (AlCuMg1) / 3.1325		60	-	500-800
		heat-treatable <12% Si	EN-AW-6082 (AlMgSi1) / 3.2315		100	-	200-400
	Al-cast-alloys	non-heat-treatable <12% Si	AlSi9Cu3 / 3.2163		80	-	500-800
		heat-treatable <12% Si	AlSi10Mg / 3.2383		100	-	200-400
	Copper alloys	brass, lead alloy	CuZn39Pb2 (MS58) / 2.0380	400	120	-	130-250
		bronze	CuSn6 / 2.1020	500	150	-	100-180
S	Heat resistant alloys, super alloys	NiFe-base, annealed	NiCr15Fe (Alloy600) / 2.4816	700	-	-	30-70
		NiFe-Basis, hardened		950	-	-	30-50
		NiCo-Basis, annealed	NiMo16Cr15W (Alloy C-276) / 2.4819	800	-	-	30-60
		NiCo-Basis, cast		1100	-	-	30-40
		NiCo-Basis, hardened	NiCr19NbMo (Alloy718) / 2.4668	1200	-	-	20-30
	Titanium-alloys	annealed	Ti6Al4V / 3.7164	900	-	-	30-50
		hardened		1200	-	-	20-30
	H	Hardened steels	Heat-treatable steel			> 52 HRC	20 - 40
Heat-treatable steel, case hardened steel					> 59 HRC	10 - 30	-
Heat-treatable steel, case hardened steel					> 62 HRC	(CBN)	-

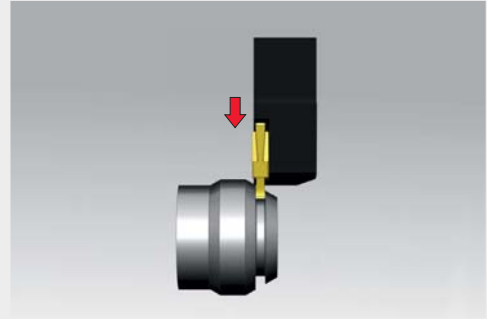
The specified values must be adapted to the machine and machining conditions.



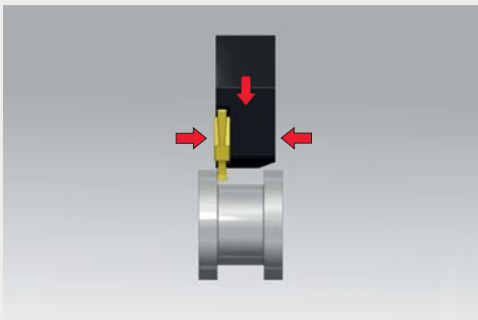
# General machining hints



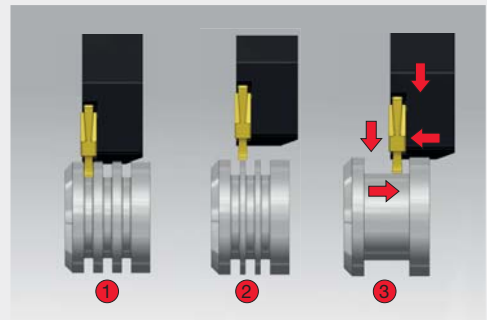
Width of machining should be min. 70% of the width of the cutting edge



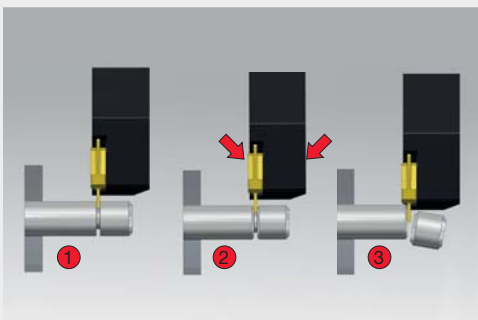
Reduce feed by 20 – 50% when grooving on inclined faces



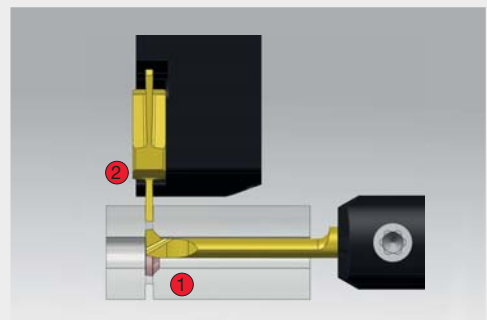
Recessing  
- radial stroke  
- turning in axial direction  
- leave axial and radial stock for finishing



Our hint for clever recessing:  
1 – (pre)-grooving „comb“  
2 – removing remaining webs  
width of the webs max: width of insert  $b - 2 \times r$   
3 - finishing



Our hint for clever parting:  
1 – (pre)-grooving  
2 – chamfering  
3 - parting



Our hint for clever parting with bore in centre:  
1 – (pre)-grooving with tool type GV104  
2 – parting with tool type GZ305

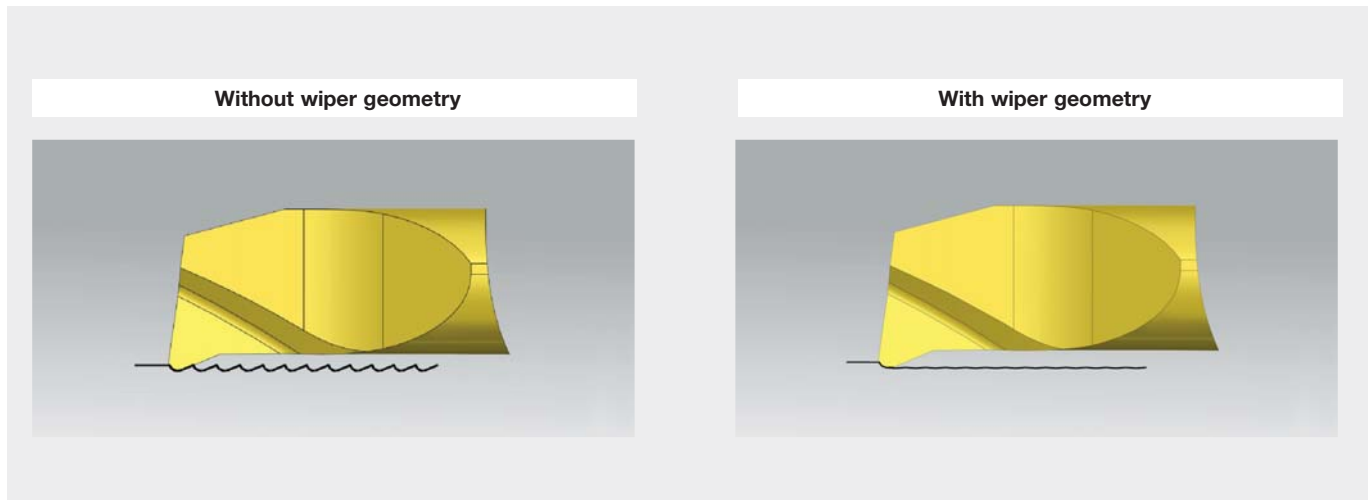


# General application hints

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

# Application hints for the cutting insert GJ104/106/108 with wiper geometry



### The wiper geometry offers multiple options

- You retain the feed rate of the cutting insert without wiper geometry and achieve a considerably better surface finish.
- You increase the feed rate taking the entire process (material, chip formation, stability) into consideration and achieve the following improvements:
  - reduced machining time
  - therefore reduced engagement of the tool, improving tool life
  - improved chip formation/chip breakage
  - thicker chip enables better heat dissipation

### Please note the following carefully!

The cutting insert/holder must be positioned axially parallel to optimize the wiper. This is the only way the wiper geometry can achieve its desired effect to improve the surface finish.

### General formulas to determine the surface finish quality

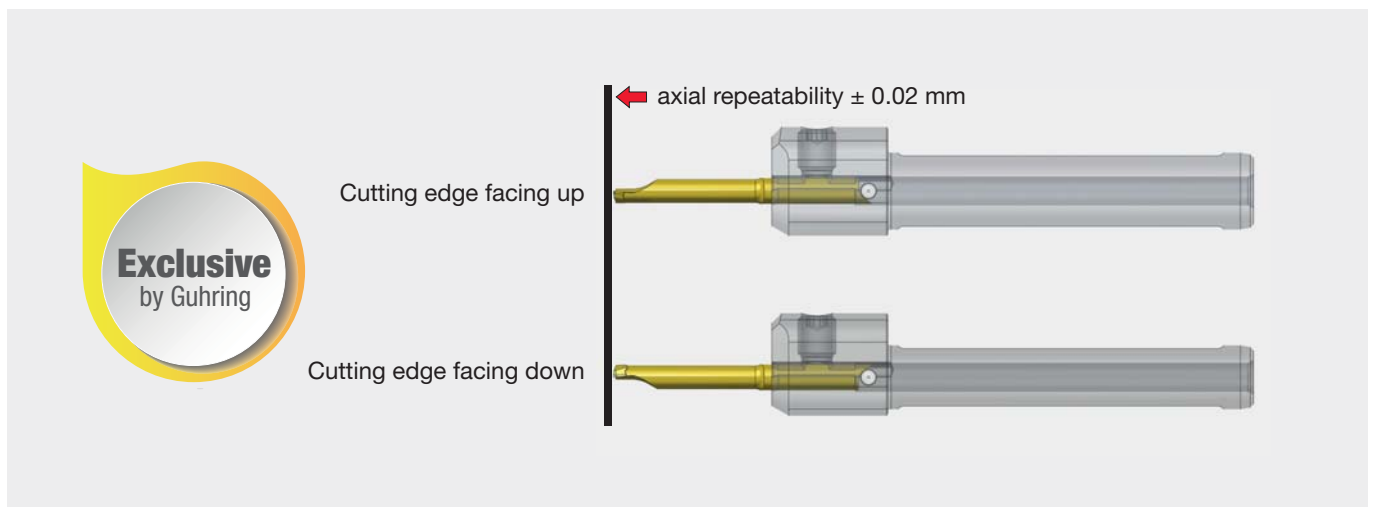
$R_{th} = f^2 / 8 \cdot r$	$r = f^2 / 8 \cdot R_{th}$	$f = \sqrt{8 \cdot r \cdot R_{th}}$
----------------------------	----------------------------	-------------------------------------

### Application example

Application: Boring out Ø 4 mm	Tool selection	Customer benefit
Component: Sleeve	System: 104	Rz 5-8 µm was achieved with a cutting insert without wiper. With a wiper cutting insert Rz values could be improved to 2-4 µm. In the 2nd step vc was increased to 130 m/min. This resulted in a further surface finish improvement.
Material: 42CrMo4	Holder: GB104.0016.075.00.15.N.IK	
1.7225	Insert: GJ104.2337.020.17.40.R	
Machine: Spinner	TiAlN nanoA	
Cooling: 20 bar		
Operat. step: Finishing		
vc: 90 m/min		
f: 0.08 mm		
ap: 0.15		
Groov. depth: -		

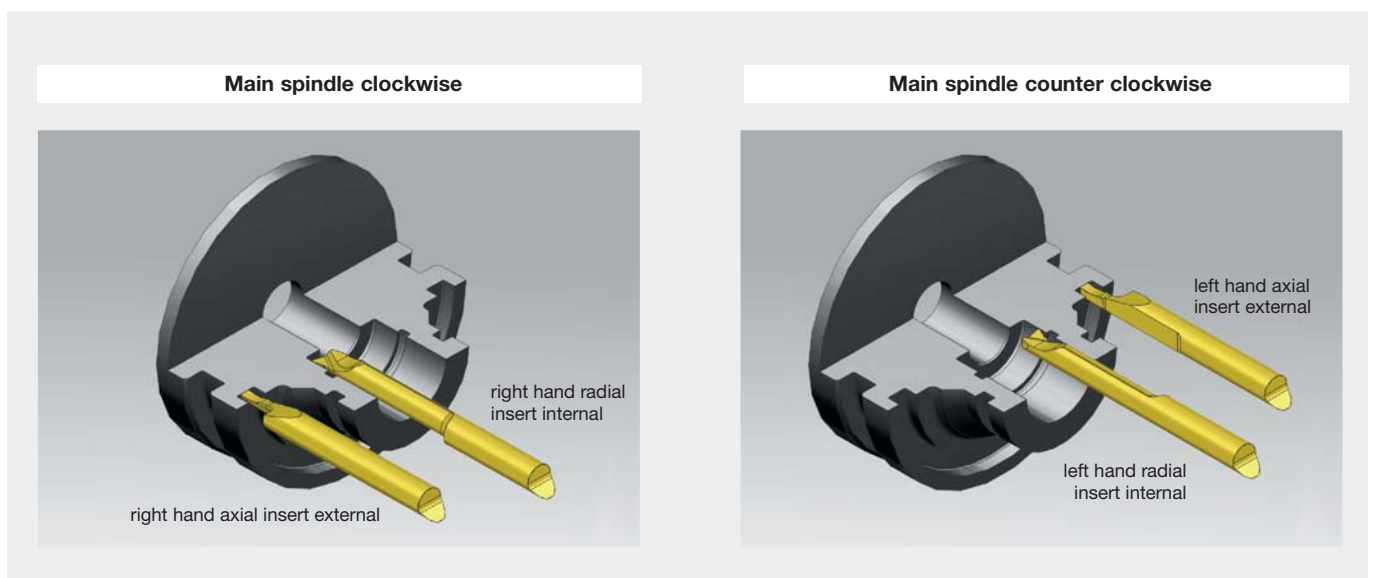


## System 104/106/108/110 Positioning and clamping



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

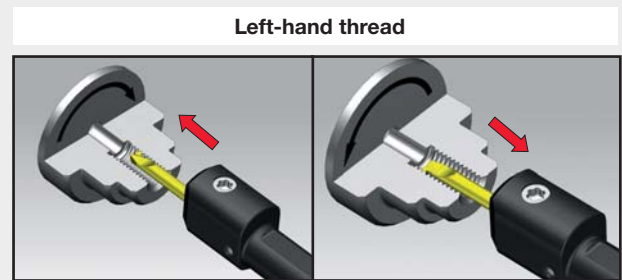
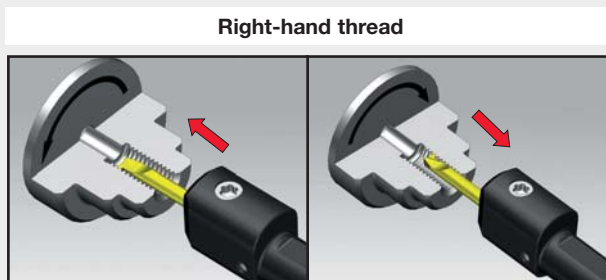




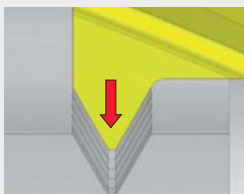
# Internal threading System GG104/GG106/GG108

Pitch/P		Recommended number of cuts with internal threading						
		Steel materials (tensile strength in N/mm <sup>2</sup> )			Stainless steel	Cast iron	Heat-resistant alloys	Aluminium
mm	Gg/°	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	19	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	11	16	17	20	20	16	20	16
3	8	22	24	30	30	22	30	22

## Feed direction internal threading

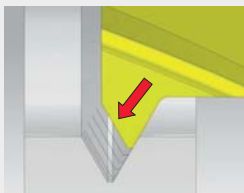


## Feed process



### 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
- Achieving 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
- Achieving a higher surface finish quality at the flanks



## Internal threading System GG104/GG106/GG108

Pre-drill-diameters for metrical threads						
Regular 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	Tapp. size hole 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

### Application example

Application: Internal thread	Tool selection	Customer benefit
Component: Threaded sleeve	System: 106	Guhring's cutting insert leads to considerably less manual re-working. The customer saves time and money.
Material: TiAl 6 V 4	Holder: GB106.0016.090.00.22.N.IK	
3.7165	Insert: GG106.TM08.125.22.68.R	
Machine: Mazak Nexus 200		
Cooling: 12 bar		
Operat.step: Threading		
vc: 25 m/min		
f: Pitch		
ap:		
Groov. depth:		

# Broaching System GN104 and GN106

## General hints

Please align the tool accurately.

The alignment surface on the tool holder GB104/106 is a great help.

## Application instructions

- With blind holes a run-out groove / undercut or cross hole must be at the groove end to allow chip evacuation
- As a general rule the delivery of coolant (soluble or neat oil) helps the broaching process. It allows chips to be flushed out of the hole as well as increasing the surface finish quality of the slot and tool life.
- On the return stroke the tool must travel completely out of the slot.
- Pay attention to the feed  $\varnothing$  when programming the first stroke (load on the cutting corners).

### Calculating the feed diameter $\varnothing d1$ for the first stroke

Example: Hole- $\varnothing$ : 8 mm  
Groove width: 5 mm  
Safety distance between cutting corners and workpiece- $\varnothing$ : 0,15 mm

$$r = \text{radius workpiece (hole-}\varnothing / 2) = 4$$

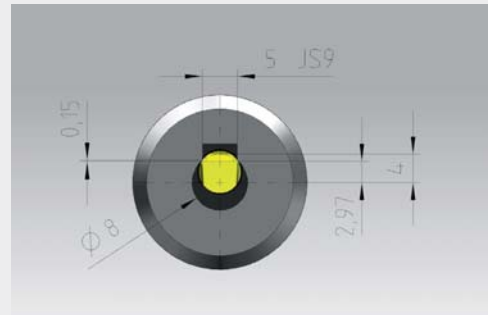
$$b = \text{Cutting edge} / 2 (5/2) = 2,5$$

$$\text{Feed radius} = \sqrt{r^2 - b^2} - \text{safety distance}$$

$$\text{Feed radius} = \sqrt{4^2 - 2,5^2} - 0,15 = 2,97$$

$$\text{Feed diameter } \varnothing d1 = 2.97 \times 2 = \varnothing 5.94$$

The feed diameter for the first stroke in the machining example above is  $\varnothing 5.94$



## Feed and feed rate

- The feed per stroke is dependent on the tensile strength of the material to be machined.
- The feed rate when broaching corresponds to the cutting speed and is controlled by the Z-axis of the machine.
- Achievable speeds are partly limited by the machine conditions.

	Tensile strength (N/mm <sup>2</sup> )					
	300	400	600	800	1000	1200
Feed rate (mm/min)	10000	8000	7000	6000	5000	4000
Feed per stroke (mm)	0.1	0.08	0.07	0.06	0.05	0.04

\* Values are for guidance only. The machine condition, rigidity of component clamping as well as the workpiece material influence the cutting parameters.



# Broaching

## System GN104 and GN106

### Sequence of machining

#### Broaching square profile:

- The broaching inserts generate a 90° corner
- The component must be repositioned 4 times each 90° to complete the square profile

#### Broaching hexagon profile:

- The broaching inserts generate a 60° corner
- The component must be repositioned 6 times each 60° to complete the hexagon profile

#### Broaching Torx profile:

- The broaching inserts generate one section of the torx profile
- The component must be repositioned 6 times each 60° to complete the torx profile



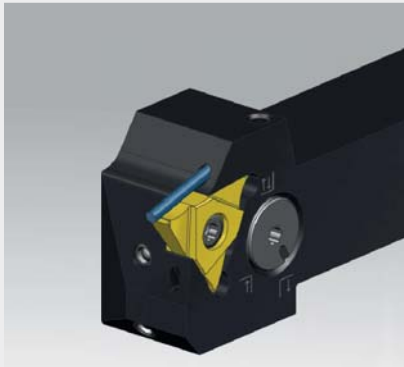
### Application example

Application: Hexagon broaching	Tool selection	Customer benefit
Component: Sleeve	System: 106 Special tool	The current process required a high amount of manual rework. Also the tool life was low. With the Gühring tool the customer achieves a very good surface with high tool life. Also there is no more manual rework required.
Material: X 10 CrNiS 18 9	Holder: GB106.0025.075.00.22.S.IK	
1.4305	Insert: Special insert	
Machine: Spinner TC 65	TiAlN nanoA	
Cooling: 20 bar		
Operat. step: Semifinishing & finishing		
vc: -		
f: 3200 mm		
ap: 0,06		
Groov. depth: SW 9.3 (special)		

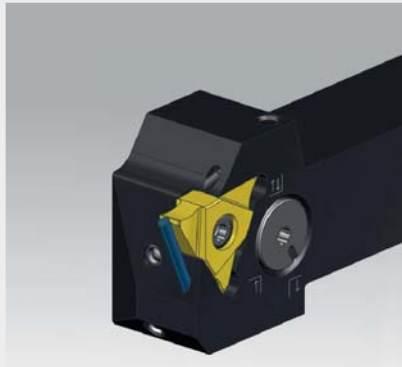
# Application hints for holder GH305...EST with adjustable coolant supply



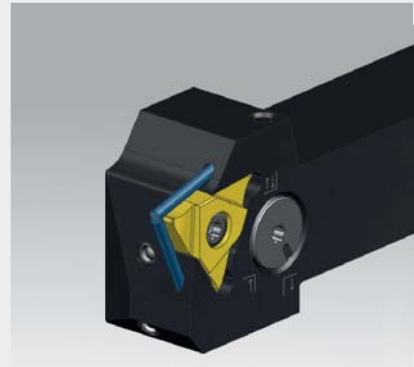
The adjustable valve directs the coolant to the cutting edge as follows:



Coolant supply directed to the rake face



Coolant supply directed to the clearance face



Coolant supply directed to both spots

The GH305 . . . EST is Guhring's patent pending grooving holder with internal coolant.

### What makes it worth the effort?

- You can optimally provide your process with coolant even at low coolant pressure:
  - first choice is the coolant supply to the rake face
  - if chips interfere or prevent coolant delivery, the temperature can be effectively controlled by cooling the clearance face.
- With high coolant pressure we recommend cooling from both coolant holes:
  - cooling the rake face can positively influence chip fracture
  - clearance face coolant additionally maintains the temperature of the cutting edge

### Application example

Application: External grooving radial	Tool selection	Customer benefit
Component: Piston	System: 305	Guhring's precision ground insert offers more tool life than the just sintered product of the competitor. Additionally the customer reported better chip formation as well as improved surface quality.
Material: 17 CrNiM0 6	Holder: GH305.2020.125.00.04.R.IK.EST	
1.6587	Insert: GE305.0200.020.BA.04.N	
Machine: Mazak Quick Turn Smart 200		
Cooling: 20 bar		
Operat. step: groov. 58 HRC, 0.8mm case d.		
vc: 40 m/min		
f: 0.06 mm		
ap:		
Groov. depth: 3 mm		



# Conversion Table Inch-Millimeter from 1/64 to 11 63/64

Size (Inch)	mm	Part of Inch (decimal)	Size (Inch)	mm	Part of Inch (decimal)	Size (Inch)	mm	Part of Inch (decimal)	Size (Inch)	mm	Part of Inch (decimal)
-	0.10	0.0039	51	1.70	0.0670	4	5.31	0.2090	-	14.00	0.5512
97	0.15	0.0059		1.75	0.0689	3	5.41	0.213	9/16	14.29	0.5625
96	0.16	0.0063	50	1.78	0.0700		5.50	0.2165		14.50	0.5709
95	0.17	0.0067		1.80	0.0709	7/32	5.56	0.2188	37/64	14.68	0.5781
94	0.18	0.0071	49	1.85	0.0730	2	5.61	0.221	-	15.00	0.5906
93	0.19	0.0075		1.90	0.0748	1	5.79	0.228	19/32	15.08	0.5938
92	0.20	0.0079	48	1.93	0.0760	A	5.94	0.234	39/64	15.48	0.6094
91	0.21	0.0083		1.95	0.0768	15/64	5.95	0.2344		15.50	0.6102
90	0.22	0.0087	5/64	1.98	0.0781	-	6.00	0.2362	5/8	15.88	0.625
89	0.23	0.0091	47	1.99	0.0785	B	6.05	0.238	-	16.00	0.6299
88	0.24	0.0095	-	2.00	0.0787	C	6.15	0.242	41/64	16.27	0.6406
-	0.25	0.0098		2.05	0.0807	D	6.25	0.246		16.50	0.6496
87	0.25	0.0100	46	2.06	0.0810	1/4	6.35	0.25	21/32	16.67	0.6562
	0.26	0.0102	45	2.08	0.0820	E	6.35	0.25	-	17.00	0.6693
86	0.27	0.0105		2.15	0.0846		6.50	0.2559	43/64	17.07	0.6719
	0.27	0.0106	44	2.18	0.0860	F	6.53	0.257	11/16	17.46	0.6875
85	0.28	0.0110	43	2.26	0.0890	G	6.63	0.261		17.50	0.689
	0.29	0.0114	42	2.37	0.0935	17/64	6.75	0.2656	45/64	17.86	0.7031
84	0.29	0.0115	3/32	2.38	0.0938		6.75	0.2657	-	18.00	0.7087
-	0.30	0.0118	41	2.44	0.0960	H	6.76	0.266	23/32	18.26	0.7188
83	0.30	0.0120	40	2.50	0.0980	I	6.91	0.272		18.50	0.7283
82	0.32	0.0125	39	2.53	0.0995	-	7.00	0.2756	47/64	18.65	0.7344
	0.32	0.0126	38	2.58	0.1015	J	7.04	0.2772	-	19.00	0.748
81	0.33	0.0130	37	2.64	0.1040	K	7.14	0.281	3/4	19.05	0.75
80	0.34	0.0135	36	2.71	0.1065	9/32	7.14	0.2812	49/64	19.45	0.7656
79	0.37	0.0145	7/64	2.78	0.1094	L	7.37	0.29		19.50	0.7677
1/64	0.40	0.0156	35	2.79	0.11	M	7.49	0.2949	25/32	19.84	0.7812
78	0.41	0.0160	34	2.82	0.111		7.50	0.2953	-	20.00	0.7874
77	0.46	0.0180	33	2.87	0.113	19/64	7.54	0.2969	51/64	20.24	0.7969
-	0.50	0.0197		2.90	0.1142	N	7.67	0.3020		20.50	0.8071
76	0.51	0.0200	32	2.95	0.116		7.75	0.3051	13/16	20.64	0.8125
75	0.53	0.0210	-	3.00	0.1181	5/16	7.94	0.3125	-	21.00	0.8268
74	0.57	0.0225	31	3.05	0.12	-	8.00	0.315	53/64	21.03	0.8281
-	0.60	0.0236	1/8	3.18	0.125	O	8.03	0.316	27/32	21.43	0.8438
73	0.61	0.0240	30	3.26	0.1285	P	8.20	0.323		21.50	0.8465
72	0.64	0.0250		3.30	0.1299	21/64	8.33	0.3281	55/64	21.84	0.8594
71	0.66	0.0260	29	3.45	0.136	Q	8.43	0.332	-	22.00	0.8661
-	0.70	0.0276		3.50	0.1378		8.50	0.3346	7/8	22.23	0.875
70	0.71	0.0280	28	3.57	0.1405	R	8.61	0.339		22.50	0.8858
69	0.74	0.0292	9/64	3.57	0.1406	11/32	8.73	0.3438	57/64	22.62	0.8906
-	0.75	0.0295	27	3.66	0.144		8.75	0.3445	-	23.00	0.9055
68	0.79	0.0310	26	3.73	0.147	S	8.84	0.348	29/32	23.02	0.9062
1/32	0.79	0.0313		3.75	0.1476	-	9.00	0.3543	59/64	23.42	0.9219
-	0.80	0.0315	25	3.80	0.1495	T	9.09	0.358		23.50	0.9252
67	0.81	0.0320	24	3.86	0.152	23/64	9.13	0.3594	15/16	23.81	0.9375
66	0.84	0.0330	23	3.91	0.154	U	9.35	0.368	-	24.00	0.9449
65	0.89	0.0350	5/32	3.97	0.1562		9.50	0.374	61/64	24.21	0.9531
-	0.90	0.0354	22	3.99	0.157	3/8	9.53	0.375		24.50	0.9646
64	0.91	0.0360	-	4.00	0.1575	V	9.56	0.377	31/32	24.61	0.9688
63	0.94	0.0370	21	4.04	0.159	W	9.80	0.386	-	25.00	0.9843
62	0.97	0.0380	20	4.09	0.161	25/64	9.92	0.3906	63/64	25.00	0.9844
61	0.99	0.0390		4.20	0.1654	-	10.00	0.3937	1	25.40	1.00
-	1.00	0.0394	19	4.22	0.166	X	10.08	0.397			
60	1.02	0.0400	18	4.31	0.1695	Y	10.26	0.4040			
59	1.04	0.0410	11/64	4.37	0.1719	13/32	10.32	0.4062			
58	1.07	0.0420	17	4.39	0.173	Z	10.49	0.413			
57	1.09	0.0430	16	4.50	0.177		10.50	0.4134			
56	1.18	0.0465	15	4.57	0.18	27/64	10.72	0.4219			
3/64	1.19	0.0469	14	4.62	0.182	-	11.00	0.4331			
	1.20	0.0472	13	4.70	0.185	7/16	11.11	0.4375			
	1.25	0.0492	3/16	4.76	0.1875		11.50	0.4528			
	1.30	0.0512	12	4.80	0.189	29/64	11.51	0.4531			
55	1.32	0.0520	11	4.85	0.191	15/32	11.91	0.4688			
54	1.40	0.0550	10	4.91	0.1935	-	12.00	0.4724			
	1.45	0.0571	9	4.98	0.196	31/64	12.30	0.4844			
	1.50	0.0591	-	5.00	0.1968		12.50	0.4921			
53	1.51	0.0595	8	5.05	0.199	1/2	12.70	0.50			
	1.55	0.0610	7	5.11	0.2010	-	13.00	0.5118			
1/16	1.59	0.0625	13/64	5.16	0.2031	33/64	13.10	0.5156			
	1.60	0.0630	6	5.18	0.2040	17/32	13.49	0.5312			
52	1.61	0.0635	5	5.22	0.2055		13.50	0.5315			
	1.65	0.0650		5.25	0.2067	35/64	13.89	0.5469			

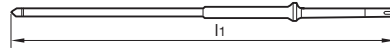
**Torque wrenches**



Article no. **4915**

Size	Nm	l1 mm	Code no.
1/4	2-8	200.000	8.000

**Torx-Plus interchangeable blade**



Article no. **4960**

Size	Nm	l1 mm	Code no.
6,6 NM		175.000	15.000

**Torx-Plus screwdriver**



- Key with T-handle code no. 15.000
- Allen key code no. 15.001



Article no. **25904**

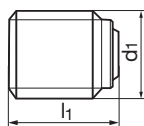
Size	l1 mm	Code no.
15IP	65.000	15.000
15IP	97.000	15.001



**Clamping screws**



• for system 104/106/108/110



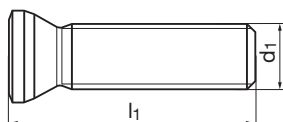
Article no. **25900**

Size	d1	l1	Code no.
		mm	
15IP	M6	7.500	6.000

**Clamping screws**



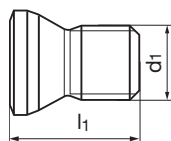
• for system 305



Article no. **25901**

Size	d1	l1	Code no.
		mm	
15IP	M4	15.000	4.000
15IP	M4	22.000	4.001
15IP	M4 x 0,35	11.000	4.002
15IP	M4 x 0,5	17.000	4.003

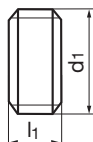
**Clamping screws**



Article no. **25902**

Size	d1	l1	Code no.
		mm	
15IP	M4	15.000	4.000
15IP	M4	7.000	4.001

**Activation screws**



Article no. **25905**

Size	d1	l1	Code no.
		mm	
SW 4	G1/8	5.000	5.000





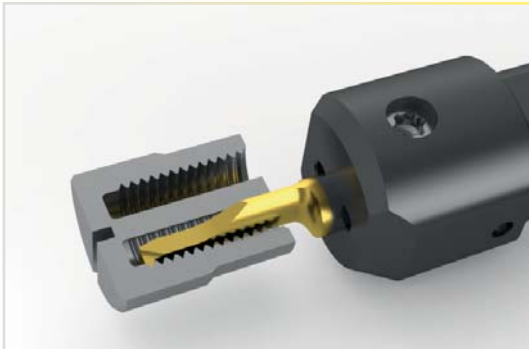
# SPECIAL SOLUTIONS made to measure

## SYSTEM 104



**Face grooving and copying dovetail grooving**

Insert: GA 104



**Internal threading**

Insert: GG 104

## SYSTEM 106



**Copying a radius at the bottom of a bore on a turning centre**

Insert: GT 106



**Broaching an internal spline, pre- and finish-cutter in one tool**

Insert: GN 106



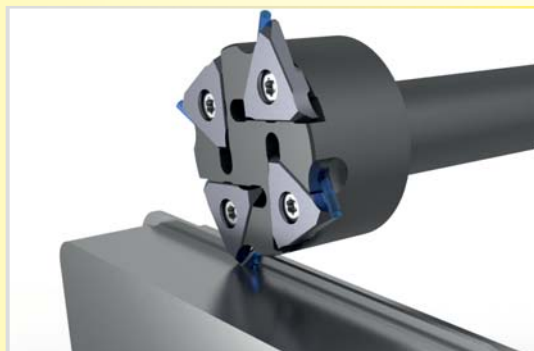
## SYSTEM 305



**Broaching an internal longitudinal grooves from hole  $\varnothing$  30 mm,**

**i.e. for profile forms or tooth profiles**

Clamping holder and indexable insert type 305



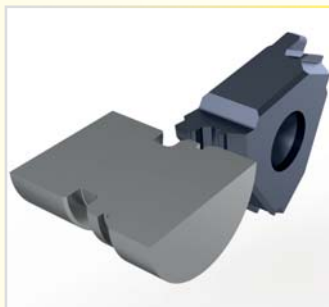
**External/internal circular milling of form recesses**

Milling body and indexable insert type 305



**Indexable insert type 305, basic width 4.2 mm**

Grooving with external edge chamfering,  
form width up to 4.2 mm, form depth up to 4 mm



**Indexable insert type 305, basic width 6.2 mm**

Two grooves in one operation,  
form width up to 6.2 mm, form depth up to 4 mm



**Indexable insert type 305, basic width 8.2 mm**

Profile form insert, external contour,  
form width up to 8.2 mm, form depth up to 4 mm



**Indexable insert type 305, basic width 12.2 mm**

Profile form insert, external contour,  
form width up to 12.2 mm, form depth up to 4 mm

Article no.	Page	Type	Description	Tool material	Standard
4915	196		Torque wrenches		Company std.
4960	196		Torx-Plus interchangeable blade		Company std.
25000	16	GB 104	Round shank holder, clamping screw top		Company std.
25001	17	GB 104	Round shank holder, clamping screw lateral		Company std.
25002	23	GH 104	Square shank holder, 90° offset		Company std.
25003	23	GH 104	Square shank holder, 90° offset		Company std.
25006	28	GB 104	Round shank holder, 4 clamping surfaces		Company std.
25010	25	GH 104	Polygon shank holder, to ISO 26623, straight 0°		Company std.
25012	26	GH 104	Polygon shank holder, to ISO 26623, off-set 90°		Company std.
25013	26	GH 104	Polygon shank holder, to ISO 26623, off-set 90°		Company std.
25016	27	GH 104	HSK-T holder, to ISO 12164-3, straight 0°		Company std.
25017	19	GB 104	Round shank holder, clamping screw above, without clamping surfaces		Company std.
25018	18	GB 104	Round shank holder, clamping screw above, four clamping surfaces		Company std.
25019	24	GH 104	Square shank holder, straight 0°		Company std.
25020	24	GH 104	Square shank holder, straight 0°		Company std.
25021	20	GB 104	Round shank holder, clamping screw above, for Citizen machine		Company std.
25022	21	GB 104	Round shank holder, clamping screw above, for Star machine		Company std.
25023	22	GB 104	Round shank holder, clamping screw above, for Tornos machine		Company std.
25050	29	GT 104	Cutting insert for boring out and profiling	Solid carbide	Company std.
25051	30	GT 104	Cutting insert for boring out and profiling	Solid carbide	Company std.
25052	29	GT 104	Cutting insert for boring out and profiling	Solid carbide	Company std.
25053	30	GT 104	Cutting insert for boring out and profiling	Solid carbide	Company std.
25056	29	GT 104	Cutting insert for boring out and profiling	Solid carbide	Company std.
25057	30	GT 104	Cutting insert for boring out and profiling	Solid carbide	Company std.
25058	31	GT 104	Cutting insert for boring out and profiling	Solid carbide	Company std.
25059	32	GT 104	Cutting insert for boring out and profiling	Solid carbide	Company std.
25060	31	GT 104	Cutting insert for boring out and profiling	Solid carbide	Company std.
25061	32	GT 104	Cutting insert for boring out and profiling	Solid carbide	Company std.
25064	31	GT 104	Cutting insert for boring out and profiling	Solid carbide	Company std.
25065	32	GT 104	Cutting insert for boring out and profiling	Solid carbide	Company std.
25066	33	GT 104	Cutting insert for boring out and profiling	Solid carbide	Company std.
25067	34	GT 104	Cutting insert for boring out and profiling	Solid carbide	Company std.
25068	33	GT 104	Cutting insert for boring out and profiling	Solid carbide	Company std.
25069	34	GT 104	Cutting insert for boring out and profiling	Solid carbide	Company std.
25072	33	GT 104	Cutting insert for boring out and profiling	Solid carbide	Company std.
25073	34	GT 104	Cutting insert for boring out and profiling	Solid carbide	Company std.
25074	35	GT 104	Cutting insert for boring out and profiling	Solid carbide	Company std.
25075	35	GT 104	Cutting insert for boring out and profiling	Solid carbide	Company std.
25076	35	GT 104	Cutting insert for boring out and profiling	Solid carbide	Company std.
25077	35	GT 104	Cutting insert for boring out and profiling	Solid carbide	Company std.
25080	35	GT 104	Cutting insert for boring out and profiling	Solid carbide	Company std.
25081	35	GT 104	Cutting insert for boring out and profiling	Solid carbide	Company std.
25082	37	GT 104	Cutting insert for boring out and profiling	Solid carbide	Company std.
25083	37	GT 104	Cutting insert for boring out and profiling	Solid carbide	Company std.
25084	37	GT 104	Cutting insert for boring out and profiling	Solid carbide	Company std.
25085	37	GT 104	Cutting insert for boring out and profiling	Solid carbide	Company std.
25088	37	GT 104	Cutting insert for boring out and profiling	Solid carbide	Company std.
25089	37	GT 104	Cutting insert for boring out and profiling	Solid carbide	Company std.
25090	39	GJ 104	Cutting insert for boring out and profiling	Solid carbide	Company std.
25091	39	GJ 104	Cutting insert for boring out and profiling	Solid carbide	Company std.
25092	39	GJ 104	Cutting insert for boring out and profiling	Solid carbide	Company std.
25093	39	GJ 104	Cutting insert for boring out and profiling	Solid carbide	Company std.
25096	39	GJ 104	Cutting insert for boring out and profiling	Solid carbide	Company std.
25097	39	GJ 104	Cutting insert for boring out and profiling	Solid carbide	Company std.
25106	40	GT 104	Cutting insert for back boring and profiling	Solid carbide	Company std.
25107	40	GT 104	Cutting insert for back boring and profiling	Solid carbide	Company std.
25108	40	GT 104	Cutting insert for back boring and profiling	Solid carbide	Company std.
25109	40	GT 104	Cutting insert for back boring and profiling	Solid carbide	Company std.
25112	40	GT 104	Cutting insert for back boring and profiling	Solid carbide	Company std.
25113	40	GT 104	Cutting insert for back boring and profiling	Solid carbide	Company std.
25114	42	GT 104	Cutting insert for boring out and chamfering	Solid carbide	Company std.
25115	42	GT 104	Cutting insert for boring out and chamfering	Solid carbide	Company std.
25116	42	GT 104	Cutting insert for boring out and chamfering	Solid carbide	Company std.
25117	42	GT 104	Cutting insert for boring out and chamfering	Solid carbide	Company std.
25120	42	GT 104	Cutting insert for boring out and chamfering	Solid carbide	Company std.
25121	42	GT 104	Cutting insert for boring out and chamfering	Solid carbide	Company std.
25124	43	GE 104	Cutting insert for internal grooving, straight slots	Solid carbide	Company std.
25125	43	GE 104	Cutting insert for internal grooving, straight slots	Solid carbide	Company std.
25126	43	GE 104	Cutting insert for internal grooving, straight slots	Solid carbide	Company std.
25127	43	GE 104	Cutting insert for internal grooving, straight slots	Solid carbide	Company std.
25130	43	GE 104	Cutting insert for internal grooving, straight slots	Solid carbide	Company std.
25131	43	GE 104	Cutting insert for internal grooving, straight slots	Solid carbide	Company std.



Article no.	Page	Type	Description	Tool material	Standard
25228	57	GN 104	Cutting insert for internal hexagon	Solid carbide	Company std.
25229	57	GN 104	Cutting insert for internal hexagon	Solid carbide	Company std.
25231	57	GN 104	Cutting insert for internal hexagon	Solid carbide	Company std.
25232	58	GN 104	Cutting insert for internal square	Solid carbide	Company std.
25233	58	GN 104	Cutting insert for internal square	Solid carbide	Company std.
25235	58	GN 104	Cutting insert for internal square	Solid carbide	Company std.
25236	59	GN 104	Cutting insert for Torx	Solid carbide	Company std.
25237	59	GN 104	Cutting insert for Torx	Solid carbide	Company std.
25239	59	GN 104	Cutting insert for Torx	Solid carbide	Company std.
25300	62	GB 106	Round shank holder, clamping screw top		Company std.
25301	63	GB 106	Round shank holder, clamping screw lateral		Company std.
25302	74	GB 106	Round shank holder, 4 clamping surfaces		Company std.
25304	70	GH 106	Square shank holder, 90° offset		Company std.
25305	70	GH 106	Square shank holder, 90° offset		Company std.
25307	71	GH 106	Polygon shank holder, to ISO 26623, straight 0°		Company std.
25308	72	GH 106	Polygon shank holder, to ISO 26623, off-set 90°		Company std.
25309	72	GH 106	Polygon shank holder, to ISO 26623, off-set 90°		Company std.
25311	73	GH 106	HSK-T holder, to ISO 12164-3, straight 0°		Company std.
25314	69	GH 106	Square shank holder, straight 0°		Company std.
25315	69	GH 106	Square shank holder, straight 0°		Company std.
25316	66	GB 106	Round shank holder, clamping screw above, for Citizen machine		Company std.
25317	67	GB 106	Round shank holder, clamping screw above, for Star machine		Company std.
25318	68	GB 106	Round shank holder, clamping screw above, for Tornos machine		Company std.
25319	65	GB 106	Round shank holder, clamping screw above, without clamping surfaces		Company std.
25320	64	GB 106	Round shank holder, clamping screw above, four clamping surfaces		Company std.
25350	156	GH 305	Square shank holder straight, external machining, without IC		Company std.
25351	157	GH 305	Square shank holder straight, external machining, without IC		Company std.
25352	158	GH 305	Square shank holder straight, external machining, with IC		Company std.
25353	159	GH 305	Square shank holder straight, external machining, with IC		Company std.
25356	161	GH 305	Square shank holder 90° offset, external machining, without IC		Company std.
25357	162	GH 305	Square shank holder 90° offset, external machining, without IC		Company std.
25358	163	GH 305	Square shank holder 90° offset, external machining, with IC		Company std.
25359	164	GH 305	Square shank holder 90° offset, external machining, with IC		Company std.
25362	165	GH 305	Square shank holder 45° offset, external machining, without IC		Company std.
25363	165	GH 305	Square shank holder 45° offset, external machining, without IC		Company std.
25364	166	GH 305	Square shank holder 45° offset, external machining, with IC		Company std.
25365	166	GH 305	Square shank holder 45° offset, external machining, with IC		Company std.
25368	167	GB 305	Round shank holder, internal machining, without IC		Company std.
25369	167	GB 305	Round shank holder, internal machining, without IC		Company std.
25370	169	GB 305	Round shank holder, internal machining, with IC		Company std.
25371	169	GB 305	Round shank holder, internal machining, with IC		Company std.
25372	160	GH 305	Square shank holder straight, external machining, IC adjustable		Company std.
25373	160	GH 305	Square shank holder straight, external machining, IC adjustable		Company std.
25500	88	GT 106	Cutting insert for boring out and profiling	Solid carbide	Company std.
25501	89	GT 106	Cutting insert for boring out and profiling	Solid carbide	Company std.
25502	88	GT 106	Cutting insert for boring out and profiling	Solid carbide	Company std.
25503	89	GT 106	Cutting insert for boring out and profiling	Solid carbide	Company std.
25506	88	GT 106	Cutting insert for boring out and profiling	Solid carbide	Company std.
25507	89	GT 106	Cutting insert for boring out and profiling	Solid carbide	Company std.
25508	90	GT 106	Cutting insert for boring out and profiling	Solid carbide	Company std.
25509	91	GT 106	Cutting insert for boring out and profiling	Solid carbide	Company std.
25510	90	GT 106	Cutting insert for boring out and profiling	Solid carbide	Company std.
25511	91	GT 106	Cutting insert for boring out and profiling	Solid carbide	Company std.
25514	90	GT 106	Cutting insert for boring out and profiling	Solid carbide	Company std.
25515	91	GT 106	Cutting insert for boring out and profiling	Solid carbide	Company std.
25516	86	GT 106	Cutting insert for boring out and profiling	Solid carbide	Company std.
25517	87	GT 106	Cutting insert for boring out and profiling	Solid carbide	Company std.
25518	86	GT 106	Cutting insert for boring out and profiling	Solid carbide	Company std.
25519	87	GT 106	Cutting insert for boring out and profiling	Solid carbide	Company std.
25522	86	GT 106	Cutting insert for boring out and profiling	Solid carbide	Company std.
25523	87	GT 106	Cutting insert for boring out and profiling	Solid carbide	Company std.
25601	171	GE 305	Indexable insert for radial grooving external and internal	Solid carbide	Company std.
25602	171	GE 305	Indexable insert for radial grooving external and internal	Solid carbide	Company std.
25603	171	GE 305	Indexable insert for radial grooving external and internal	Solid carbide	Company std.
25605	172	GE 305	Indexable insert for radial grooving and copying external and internal	Solid carbide	Company std.
25606	172	GE 305	Indexable insert for radial grooving and copying external and internal	Solid carbide	Company std.
25607	172	GE 305	Indexable insert for radial grooving and copying external and internal	Solid carbide	Company std.
25613	173	GE 305	Indexable insert for radial grooving and copying external and internal	Solid carbide	Company std.
25614	173	GE 305	Indexable insert for radial grooving and copying external and internal	Solid carbide	Company std.
25615	173	GE 305	Indexable insert for radial grooving and copying external and internal	Solid carbide	Company std.
25618	176	GA 305	Indexable insert for grooving axial external recesses	Solid carbide	Company std.
25619	176	GA 305	Indexable insert for grooving axial external recesses	Solid carbide	Company std.









Article no.	Page	Type	Description	Tool material	Standard
25850	92	GJ 106	Cutting insert for boring out and profiling	Solid carbide	Company std.
25851	93	GJ 106	Cutting insert for boring out and profiling	Solid carbide	Company std.
25854	92	GJ 106	Cutting insert for boring out and profiling	Solid carbide	Company std.
25855	93	GJ 106	Cutting insert for boring out and profiling	Solid carbide	Company std.
25856	96	GT 106	Cutting insert for back boring and profiling	Solid carbide	Company std.
25857	96	GT 106	Cutting insert for back boring and profiling	Solid carbide	Company std.
25858	96	GT 106	Cutting insert for back boring and profiling	Solid carbide	Company std.
25859	96	GT 106	Cutting insert for back boring and profiling	Solid carbide	Company std.
25862	96	GT 106	Cutting insert for back boring and profiling	Solid carbide	Company std.
25863	96	GT 106	Cutting insert for back boring and profiling	Solid carbide	Company std.
25864	98	GT 106	Cutting insert for boring out and chamfering	Solid carbide	Company std.
25865	99	GT 106	Cutting insert for boring out and chamfering	Solid carbide	Company std.
25866	98	GT 106	Cutting insert for boring out and chamfering	Solid carbide	Company std.
25867	99	GT 106	Cutting insert for boring out and chamfering	Solid carbide	Company std.
25870	98	GT 106	Cutting insert for boring out and chamfering	Solid carbide	Company std.
25871	99	GT 106	Cutting insert for boring out and chamfering	Solid carbide	Company std.
25872	102	GE 106	Cutting insert for internal grooving, straight slots	Solid carbide	Company std.
25873	102	GE 106	Cutting insert for internal grooving, straight slots	Solid carbide	Company std.
25874	102	GE 106	Cutting insert for internal grooving, straight slots	Solid carbide	Company std.
25875	102	GE 106	Cutting insert for internal grooving, straight slots	Solid carbide	Company std.
25878	102	GE 106	Cutting insert for internal grooving, straight slots	Solid carbide	Company std.
25879	102	GE 106	Cutting insert for internal grooving, straight slots	Solid carbide	Company std.
25880	106	GE 106	Cutting insert for internal grooving, full radius slots	Solid carbide	Company std.
25881	106	GE 106	Cutting insert for internal grooving, full radius slots	Solid carbide	Company std.
25882	106	GE 106	Cutting insert for internal grooving, full radius slots	Solid carbide	Company std.
25883	106	GE 106	Cutting insert for internal grooving, full radius slots	Solid carbide	Company std.
25886	106	GE 106	Cutting insert for internal grooving, full radius slots	Solid carbide	Company std.
25887	106	GE 106	Cutting insert for internal grooving, full radius slots	Solid carbide	Company std.
25888	84	GT 106	Cutting insert for boring out and profiling	Solid carbide	Company std.
25889	85	GT 106	Cutting insert for boring out and profiling	Solid carbide	Company std.
25890	84	GT 106	Cutting insert for boring out and profiling	Solid carbide	Company std.
25891	85	GT 106	Cutting insert for boring out and profiling	Solid carbide	Company std.
25894	84	GT 106	Cutting insert for boring out and profiling	Solid carbide	Company std.
25895	85	GT 106	Cutting insert for boring out and profiling	Solid carbide	Company std.
25896	120	GN 106	Cutting insert for internal hexagon	Solid carbide	Company std.
25897	120	GN 106	Cutting insert for internal hexagon	Solid carbide	Company std.
25898	120	GN 106	Cutting insert for internal hexagon	Solid carbide	Company std.
25900	197		Clamping screws		Company std.
25901	197		Clamping screws		Company std.
25902	197		Clamping screws		Company std.
25904	196		Torx-Plus screwdriver		Company std.
25905	197		Activation screws		Company std.
27000	124	GB 108	Round shank holder, clamping screw top		Company std.
27001	125	GB 108	Round shank holder, clamping screw lateral		Company std.
27002	126	GB 108	Round shank holder, clamping screw above, four clamping surfaces		Company std.
27003	127	GB 108	Round shank holder, clamping screw above, without clamping surfaces		Company std.
27007	128	GH 108	Square shank holder, straight 0°		Company std.
27008	128	GH 108	Square shank holder, straight 0°		Company std.
27009	129	GH 108	Square shank holder, 90° offset		Company std.
27010	129	GH 108	Square shank holder, 90° offset		Company std.
27050	151	GB 110	Round shank holder, clamping screw top		Company std.
27051	152	GB 110	Round shank holder, clamping screw lateral		Company std.
27100	130	GT 108	Cutting insert for boring out and profiling	Solid carbide	Company std.
27101	130	GT 108	Cutting insert for boring out and profiling	Solid carbide	Company std.
27102	130	GT 108	Cutting insert for boring out and profiling	Solid carbide	Company std.
27103	130	GT 108	Cutting insert for boring out and profiling	Solid carbide	Company std.
27104	132	GT 108	Cutting insert for boring out and profiling	Solid carbide	Company std.
27105	132	GT 108	Cutting insert for boring out and profiling	Solid carbide	Company std.
27106	132	GT 108	Cutting insert for boring out and profiling	Solid carbide	Company std.
27107	132	GT 108	Cutting insert for boring out and profiling	Solid carbide	Company std.
27108	134	GT 108	Cutting insert for boring out and profiling	Solid carbide	Company std.
27109	134	GT 108	Cutting insert for boring out and profiling	Solid carbide	Company std.
27110	134	GT 108	Cutting insert for boring out and profiling	Solid carbide	Company std.
27111	134	GT 108	Cutting insert for boring out and profiling	Solid carbide	Company std.
27116	136	GJ 108	Cutting insert for boring out and profiling	Solid carbide	Company std.
27117	136	GJ 108	Cutting insert for boring out and profiling	Solid carbide	Company std.
27118	136	GJ 108	Cutting insert for boring out and profiling	Solid carbide	Company std.
27119	136	GJ 108	Cutting insert for boring out and profiling	Solid carbide	Company std.
27120	138	GT 108	Cutting insert for back boring and profiling	Solid carbide	Company std.
27121	138	GT 108	Cutting insert for back boring and profiling	Solid carbide	Company std.
27122	138	GT 108	Cutting insert for back boring and profiling	Solid carbide	Company std.
27123	138	GT 108	Cutting insert for back boring and profiling	Solid carbide	Company std.

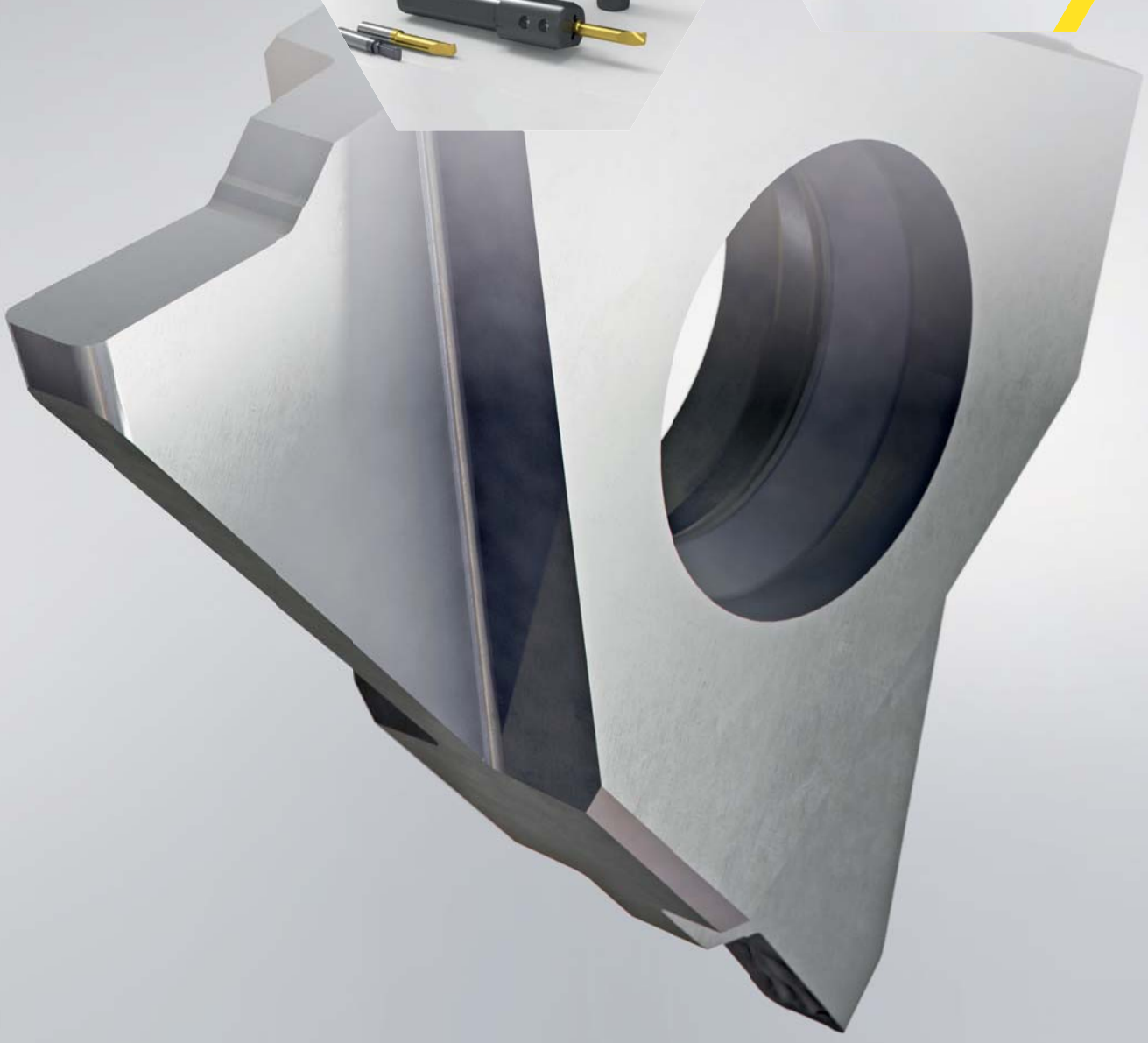




Article no.	Page	Type	Description	Tool material	Standard
27124	140	GE 108	Cutting insert for internal grooving, straight slots	Solid carbide	Company std.
27125	140	GE 108	Cutting insert for internal grooving, straight slots	Solid carbide	Company std.
27126	140	GE 108	Cutting insert for internal grooving, straight slots	Solid carbide	Company std.
27127	140	GE 108	Cutting insert for internal grooving, straight slots	Solid carbide	Company std.
27128	144	GE 108	Cutting insert for internal grooving, full radius slots	Solid carbide	Company std.
27129	144	GE 108	Cutting insert for internal grooving, full radius slots	Solid carbide	Company std.
27130	144	GE 108	Cutting insert for internal grooving, full radius slots	Solid carbide	Company std.
27131	144	GE 108	Cutting insert for internal grooving, full radius slots	Solid carbide	Company std.
27200	131	GT 108	Cutting insert for boring out and profiling	Solid carbide	Company std.
27201	131	GT 108	Cutting insert for boring out and profiling	Solid carbide	Company std.
27202	131	GT 108	Cutting insert for boring out and profiling	Solid carbide	Company std.
27203	131	GT 108	Cutting insert for boring out and profiling	Solid carbide	Company std.
27204	133	GT 108	Cutting insert for boring out and profiling	Solid carbide	Company std.
27205	133	GT 108	Cutting insert for boring out and profiling	Solid carbide	Company std.
27206	133	GT 108	Cutting insert for boring out and profiling	Solid carbide	Company std.
27207	133	GT 108	Cutting insert for boring out and profiling	Solid carbide	Company std.
27208	135	GT 108	Cutting insert for boring out and profiling	Solid carbide	Company std.
27209	135	GT 108	Cutting insert for boring out and profiling	Solid carbide	Company std.
27210	135	GT 108	Cutting insert for boring out and profiling	Solid carbide	Company std.
27211	135	GT 108	Cutting insert for boring out and profiling	Solid carbide	Company std.
27216	137	GJ 108	Cutting insert for boring out and profiling	Solid carbide	Company std.
27217	137	GJ 108	Cutting insert for boring out and profiling	Solid carbide	Company std.
27218	137	GJ 108	Cutting insert for boring out and profiling	Solid carbide	Company std.
27219	137	GJ 108	Cutting insert for boring out and profiling	Solid carbide	Company std.
27220	139	GT 108	Cutting insert for back boring and profiling	Solid carbide	Company std.
27221	139	GT 108	Cutting insert for back boring and profiling	Solid carbide	Company std.
27222	139	GT 108	Cutting insert for back boring and profiling	Solid carbide	Company std.
27223	139	GT 108	Cutting insert for back boring and profiling	Solid carbide	Company std.
27224	142	GE 108	Cutting insert for internal grooving, straight slots	Solid carbide	Company std.
27225	142	GE 108	Cutting insert for internal grooving, straight slots	Solid carbide	Company std.
27226	142	GE 108	Cutting insert for internal grooving, straight slots	Solid carbide	Company std.
27227	142	GE 108	Cutting insert for internal grooving, straight slots	Solid carbide	Company std.
27228	146	GE 108	Cutting insert for internal grooving, full radius slots	Solid carbide	Company std.
27229	146	GE 108	Cutting insert for internal grooving, full radius slots	Solid carbide	Company std.
27230	146	GE 108	Cutting insert for internal grooving, full radius slots	Solid carbide	Company std.
27231	146	GE 108	Cutting insert for internal grooving, full radius slots	Solid carbide	Company std.



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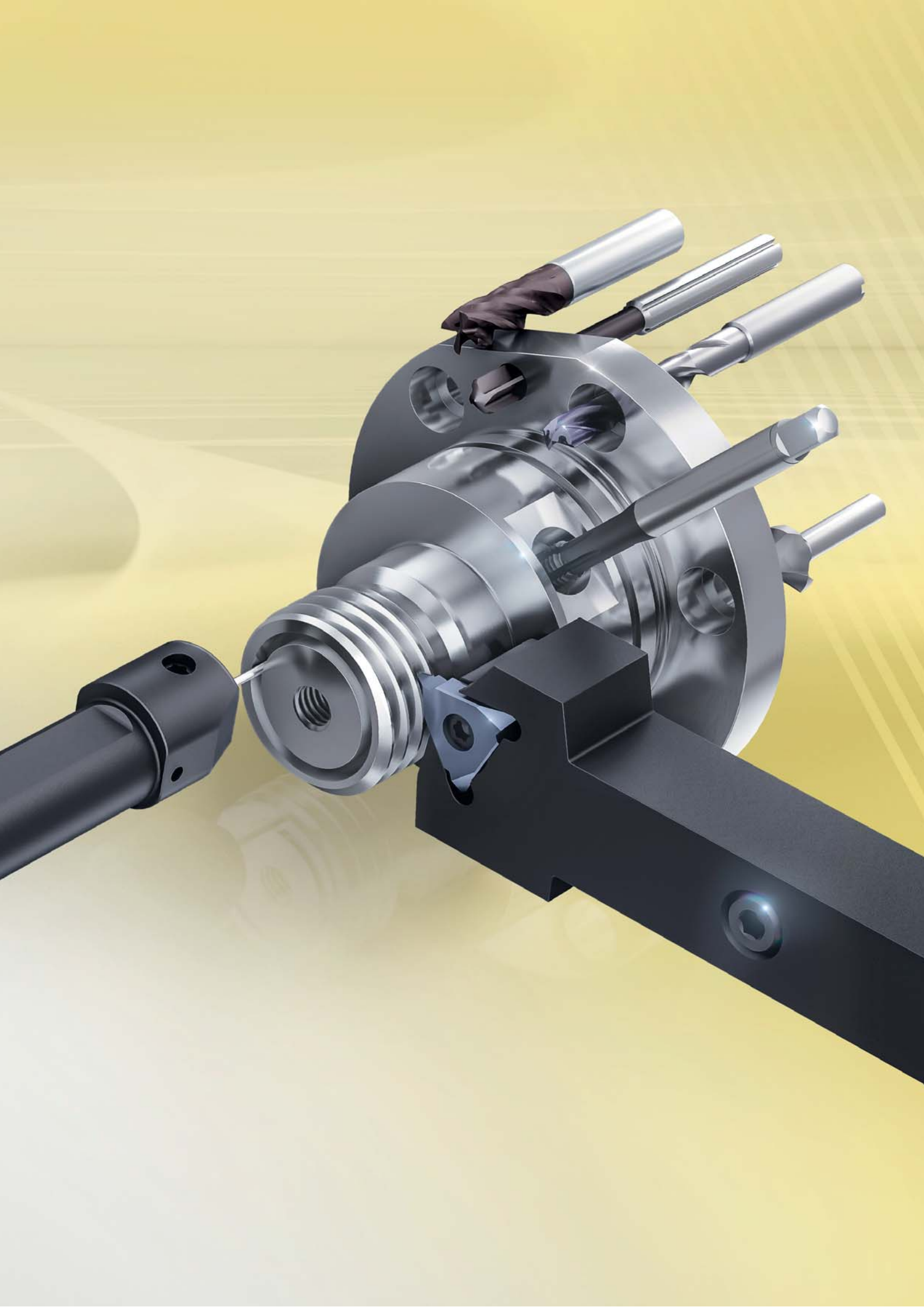
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