

GUHRING



RT 100 T AL *deep hole drill for **ALUMINUM***

GUHRING – YOUR WORLDWIDE PARTNER

GUHRING'S DEEP HOLE AL SOLUTION

The RT 100 T AL solid carbide deep hole twist drill was designed specifically for machining aluminum alloys.

It features specialized web thinning with highly polished surface finish on point and flutes, resulting in optimal drilling performance. Low machining temperature reduces the potential of built-up edges when drilling non-ferrous metals.

Pilot drilling is required for the RT 100 T AL deep hole drills, and the Guhring series 5768 drill (page 3) is the perfect pilot drill choice.

Sharp, micro-treated cutting edges

for ideal cutting performance;
excels in aluminum with <7% silicon.

Highly polished flute (Rz 0.5µ) reduces the risk
of chip adhesion, maximizing chip evacuation

Double margin design improves stability
in the cut

ADVANTAGES:

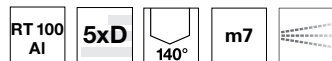
- Reduction of machining time
- Ideal chip control and evacuation
- Optimum drilling results with excellent hole quality
- Ultimate performance when machining non-ferrous metals

Available from stock in 15xD, 20xD and 25xD lengths, diameters from 3 to 14mm

**Customized solutions
available on request.**



RT 100 AL drill - recommended pilot drill for RT 100 T AL



Tool material Solid carbide

Coating Uncoated

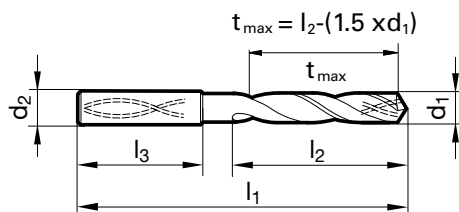
Shank form HA

Material	Suitability
P Steel	
M Stainless steel	
K Cast iron	
N Aluminum	●
S Ni / Ti alloys	
H Hardened steel	

relieved cone • main cutting edge is slightly concave • optimized cutting geometry • sharp cutting edges

aluminum and Al-alloys • Al materials with high Si-content

●=Optimal ○=Limited



Series										5768
d1	d1	d1	d1	d2	l1	l2	t _{max}	l3	Code	EDP No.
inch	fract.	wire/ltr	mm	mm	mm	mm	mm	mm	no.	
0.1181			3.00	6.00	66.00	28.00	23.50	36.00	3.000	9057680030000
0.1220			3.10	6.00	66.00	28.00	23.35	36.00	3.100	9057680031000
0.1248	1/8		3.17	6.00	66.00	28.00	23.25	36.00	3.170	9057680031700
0.1260			3.20	6.00	66.00	28.00	23.20	36.00	3.200	9057680032000
0.1280			3.25	6.00	66.00	28.00	23.13	36.00	3.250	9057680032500
0.1299			3.30	6.00	66.00	28.00	23.05	36.00	3.300	9057680033000
0.1339			3.40	6.00	66.00	28.00	22.90	36.00	3.400	9057680034000
0.1378			3.50	6.00	66.00	28.00	22.75	36.00	3.500	9057680035000
0.1406	9/64	#28	3.57	6.00	66.00	28.00	22.65	36.00	3.570	9057680035700
0.1417			3.60	6.00	66.00	28.00	22.60	36.00	3.600	9057680036000
0.1457			3.70	6.00	66.00	28.00	22.45	36.00	3.700	9057680037000
0.1496			3.80	6.00	74.00	36.00	30.30	36.00	3.800	9057680038000
0.1535			3.90	6.00	74.00	36.00	30.15	36.00	3.900	9057680039000
0.1563	5/32		3.97	6.00	74.00	36.00	30.05	36.00	3.970	9057680039700
0.1575			4.00	6.00	74.00	36.00	30.00	36.00	4.000	9057680040000
0.1614			4.10	6.00	74.00	36.00	29.85	36.00	4.100	9057680041000
0.1654			4.20	6.00	74.00	36.00	29.70	36.00	4.200	9057680042000
0.1693			4.30	6.00	74.00	36.00	29.55	36.00	4.300	9057680043000
0.1720	11/64		4.37	6.00	74.00	36.00	29.45	36.00	4.370	9057680043700
0.1732			4.40	6.00	74.00	36.00	29.40	36.00	4.400	9057680044000
0.1772			4.50	6.00	74.00	36.00	29.25	36.00	4.500	9057680045000
0.1811			4.60	6.00	74.00	36.00	29.10	36.00	4.600	9057680046000
0.1831			4.65	6.00	74.00	36.00	29.03	36.00	4.650	9057680046500
0.1850			4.70	6.00	74.00	36.00	28.95	36.00	4.700	9057680047000
0.1874	3/16		4.76	6.00	82.00	44.00	36.86	36.00	4.760	9057680047600
0.1890			4.80	6.00	82.00	44.00	36.80	36.00	4.800	9057680048000
0.1929			4.90	6.00	82.00	44.00	36.65	36.00	4.900	9057680049000
0.1969			5.00	6.00	82.00	44.00	36.50	36.00	5.000	9057680050000
0.2008			5.10	6.00	82.00	44.00	36.35	36.00	5.100	9057680051000
0.2031	13/64		5.16	6.00	82.00	44.00	36.26	36.00	5.160	9057680051600
0.2047			5.20	6.00	82.00	44.00	36.20	36.00	5.200	9057680052000
0.2087			5.30	6.00	82.00	44.00	36.05	36.00	5.300	9057680053000
0.2126			5.40	6.00	82.00	44.00	35.90	36.00	5.400	9057680054000
0.2165			5.50	6.00	82.00	44.00	35.75	36.00	5.500	9057680055000
0.2185			5.55	6.00	82.00	44.00	35.68	36.00	5.550	9057680055500
0.2189	7/32		5.56	6.00	82.00	44.00	35.66	36.00	5.560	9057680055600



Series										5768
d1	d1	d1	d1	d2	l1	l2	t _{max}	l3	Code	EDP No.
inch	fract.	wire/ltr	mm	mm	mm	mm	mm	mm	no.	
0.2205			5.60	6.00	82.00	44.00	35.60	36.00	5.600	9057680056000
0.2244			5.70	6.00	82.00	44.00	35.45	36.00	5.700	9057680057000
0.2283			5.80	6.00	82.00	44.00	35.30	36.00	5.800	9057680058000
0.2323	15/64		5.90	6.00	82.00	44.00	35.15	36.00	5.900	9057680059000
0.2343			5.95	6.00	82.00	44.00	35.08	36.00	5.950	9057680059500
0.2362			6.00	6.00	82.00	44.00	35.00	36.00	6.000	9057680060000
0.2402			6.10	8.00	91.00	53.00	43.85	36.00	6.100	9057680061000
0.2441			6.20	8.00	91.00	53.00	43.70	36.00	6.200	9057680062000
0.2480			6.30	8.00	91.00	53.00	43.55	36.00	6.300	9057680063000
0.2500	1/4	E	6.35	8.00	91.00	53.00	43.48	36.00	6.350	9057680063500
0.2520			6.40	8.00	91.00	53.00	43.40	36.00	6.400	9057680064000
0.2559			6.50	8.00	91.00	53.00	43.25	36.00	6.500	9057680065000
0.2598			6.60	8.00	91.00	53.00	43.10	36.00	6.600	9057680066000
0.2638	17/64		6.70	8.00	91.00	53.00	42.95	36.00	6.700	9057680067000
0.2657			6.75	8.00	91.00	53.00	42.88	36.00	6.750	9057680067500
0.2677			6.80	8.00	91.00	53.00	42.80	36.00	6.800	9057680068000
0.2717			6.90	8.00	91.00	53.00	42.65	36.00	6.900	9057680069000
0.2756			7.00	8.00	91.00	53.00	42.50	36.00	7.000	9057680070000
0.2795			7.10	8.00	91.00	53.00	42.35	36.00	7.100	9057680071000
0.2811	9/32		7.14	8.00	91.00	53.00	42.29	36.00	7.140	9057680071400
0.2835	7.20		8.00	91.00	53.00	42.20	36.00	7.200	9057680072000	
0.2874	7.30		8.00	91.00	53.00	42.05	36.00	7.300	9057680073000	
0.2913			7.40	8.00	91.00	53.00	41.90	36.00	7.400	9057680074000
0.2953			7.50	8.00	91.00	53.00	41.75	36.00	7.500	9057680075000
0.2969			7.54	8.00	91.00	53.00	41.69	36.00	7.540	9057680075400
0.2992	19/64		7.60	8.00	91.00	53.00	41.60	36.00	7.600	9057680076000
0.3031	7.70		8.00	91.00	53.00	41.45	36.00	7.700	9057680077000	
0.3071	7.80		8.00	91.00	53.00	41.30	36.00	7.800	9057680078000	
0.3110	5/16		7.90	8.00	91.00	53.00	41.15	36.00	7.900	9057680079000
0.3126			7.94	8.00	91.00	53.00	41.09	36.00	7.940	9057680079400
0.3150			8.00	8.00	91.00	53.00	41.00	36.00	8.000	9057680080000
0.3189			8.10	10.00	103.00	61.00	48.85	40.00	8.100	9057680081000
0.3228			8.20	10.00	103.00	61.00	48.70	40.00	8.200	9057680082000
0.3268			8.30	10.00	103.00	61.00	48.55	40.00	8.300	9057680083000
0.3280	21/64		8.33	10.00	103.00	61.00	48.51	40.00	8.330	9057680083300
0.3307	8.40		10.00	103.00	61.00	48.40	40.00	8.400	9057680084000	
0.3346	8.50		10.00	103.00	61.00	48.25	40.00	8.500	9057680085000	
0.3386			8.60	10.00	103.00	61.00	48.10	40.00	8.600	9057680086000
0.3425			8.70	10.00	103.00	61.00	47.95	40.00	8.700	9057680087000
0.3437			8.73	10.00	103.00	61.00	47.91	40.00	8.730	9057680087300
0.3465	11/32		8.80	10.00	103.00	61.00	47.80	40.00	8.800	9057680088000
0.3504	8.90		10.00	103.00	61.00	47.65	40.00	8.900	9057680089000	
0.3543	9.00		10.00	103.00	61.00	47.50	40.00	9.000	9057680090000	
0.3583	23/64		9.10	10.00	103.00	61.00	47.35	40.00	9.100	9057680091000
0.3594			9.13	10.00	103.00	61.00	47.31	40.00	9.130	9057680091300
0.3622			9.20	10.00	103.00	61.00	47.20	40.00	9.200	9057680092000
0.3642			9.25	10.00	103.00	61.00	47.13	40.00	9.250	9057680092500
0.3661			9.30	10.00	103.00	61.00	47.05	40.00	9.300	9057680093000
0.3677			9.34	10.00	103.00	61.00	46.99	40.00	9.340	9057680093400
0.3701			9.40	10.00	103.00	61.00	46.90	40.00	9.400	9057680094000
0.3740			9.50	10.00	103.00	61.00	46.75	40.00	9.500	9057680095000
0.3748			9.52	10.00	103.00	61.00	46.72	40.00	9.520	9057680095200
0.3780	3/8		9.60	10.00	103.00	61.00	46.60	40.00	9.600	9057680096000
0.3819	9.70		10.00	103.00	61.00	46.45	40.00	9.700	9057680097000	
0.3858	9.80		10.00	103.00	61.00	46.30	40.00	9.800	9057680098000	
0.3898	25/64		9.90	10.00	103.00	61.00	46.15	40.00	9.900	9057680099000
0.3906			9.92	10.00	103.00	61.00	46.12	40.00	9.920	9057680099200
0.3937			10.00	10.00	103.00	61.00	46.00	40.00	10.000	9057680100000
0.3976			10.10	12.00	118.00	71.00	55.85	45.00	10.100	9057680101000
0.4016			10.20	12.00	118.00	71.00	55.70	45.00	10.200	9057680102000



Series										5768
d1	d1	d1	d1	d2	l1	l2	t _{max}	l3	Code	EDP No.
inch	fract.	wire/ltr	mm	mm	mm	mm	mm	mm	no.	
0.4055	13/32		10.30	12.00	118.00	71.00	55.55	45.00	10.300	9057680103000
0.4063			10.32	12.00	118.00	71.00	55.52	45.00	10.320	9057680103200
0.4094			10.40	12.00	118.00	71.00	55.40	45.00	10.400	9057680104000
0.4134			10.50	12.00	118.00	71.00	55.25	45.00	10.500	9057680105000
0.4173			10.60	12.00	118.00	71.00	55.10	45.00	10.600	9057680106000
0.4213			10.70	12.00	118.00	71.00	54.95	45.00	10.700	9057680107000
0.4252			10.80	12.00	118.00	71.00	54.80	45.00	10.800	9057680108000
0.4291			10.90	12.00	118.00	71.00	54.65	45.00	10.900	9057680109000
0.4331			11.00	12.00	118.00	71.00	54.50	45.00	11.000	9057680110000
0.4370	7/16		11.10	12.00	118.00	71.00	54.35	45.00	11.100	9057680111000
0.4374			11.11	12.00	118.00	71.00	54.34	45.00	11.110	9057680111100
0.4409			11.20	12.00	118.00	71.00	54.20	45.00	11.200	9057680112000
0.4449			11.30	12.00	118.00	71.00	54.05	45.00	11.300	9057680113000
0.4488			11.40	12.00	118.00	71.00	53.90	45.00	11.400	9057680114000
0.4528			11.50	12.00	118.00	71.00	53.75	45.00	11.500	9057680115000
0.4567			11.60	12.00	118.00	71.00	53.60	45.00	11.600	9057680116000
0.4606			11.70	12.00	118.00	71.00	53.45	45.00	11.700	9057680117000
0.4646			11.80	12.00	118.00	71.00	53.30	45.00	11.800	9057680118000
0.4685	15/32		11.90	12.00	118.00	71.00	53.15	45.00	11.900	9057680119000
0.4689			11.91	12.00	118.00	71.00	53.14	45.00	11.910	9057680119100
0.4724			12.00	12.00	118.00	71.00	53.00	45.00	12.000	9057680120000
0.4764			12.10	14.00	124.00	77.00	58.85	45.00	12.100	9057680121000
0.4803			12.20	14.00	124.00	77.00	58.70	45.00	12.200	9057680122000
0.4921			12.50	14.00	124.00	77.00	58.25	45.00	12.500	9057680125000
0.4961	1/2		12.60	14.00	124.00	77.00	58.10	45.00	12.600	9057680126000
0.5000			12.70	14.00	124.00	77.00	57.95	45.00	12.700	9057680127000
0.5039			12.80	14.00	124.00	77.00	57.80	45.00	12.800	9057680128000
0.5079	33/64		12.90	14.00	124.00	77.00	57.65	45.00	12.900	9057680129000
0.5118			13.00	14.00	124.00	77.00	57.50	45.00	13.000	9057680130000
0.5157			13.10	14.00	124.00	77.00	57.35	45.00	13.100	9057680131000
0.5236			13.30	14.00	124.00	77.00	57.05	45.00	13.300	9057680133000
0.5276			13.40	14.00	124.00	77.00	56.90	45.00	13.400	9057680134000
0.5315			13.50	14.00	124.00	77.00	56.75	45.00	13.500	9057680135000
0.5394			13.70	14.00	124.00	77.00	56.45	45.00	13.700	9057680137000
0.5433			13.80	14.00	124.00	77.00	56.30	45.00	13.800	9057680138000
0.5512			14.00	14.00	124.00	77.00	56.00	45.00	14.000	9057680140000



RT 100 T AL - Deep hole drill for aluminum



Cutting depth



Type



Point angle



Tolerance on Ø



Internal coolant



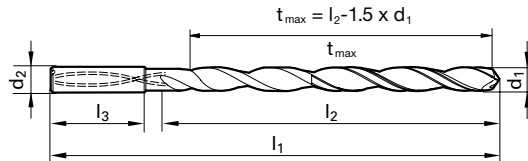
Tool material	Solid carbide
Coating	Uncoated
Shank form	HA

Material	Suitability
P Steel	
M Stainless steel	
K Cast iron	
N Aluminum	●
S Ni / Ti alloys	
H Hardened steel	

●=Optimal ○=Limited

facet point grind • main cutting edge form concave • optimized flute design • maximum diameter of coolant ducts • observe coolant pressure • for piloting we recommend RT 100 AL, Series 5768

aluminum and Al-alloys



Series										6515
d1	d1	d1	d1	d2	l1	l2	t _{max}	l3	Code	EDP No.
inch	fract. in	wire/ltr	mm	mm	mm	mm	mm	mm	no.	
0.1181	1/8		3.00	6.00	95.00	55.00	50.50	36.00	3.000	9065150030000
0.1220			3.10	6.00	106.00	66.00	61.35	36.00	3.100	9065150031000
0.1248			3.17	6.00	106.00	66.00	61.25	36.00	3.170	9065150031700
0.1260	9/64		3.20	6.00	106.00	66.00	61.20	36.00	3.200	9065150032000
0.1280			3.25	6.00	106.00	66.00	61.13	36.00	3.250	9065150032500
0.1299			3.30	6.00	106.00	66.00	61.05	36.00	3.300	9065150033000
0.1339			3.40	6.00	106.00	66.00	60.90	36.00	3.400	9065150034000
0.1378			3.50	6.00	116.00	76.00	70.75	36.00	3.500	9065150035000
0.1406	5/32		3.57	6.00	116.00	76.00	70.65	36.00	3.570	9065150035700
0.1417			3.60	6.00	116.00	76.00	70.60	36.00	3.600	9065150036000
0.1457			3.70	6.00	116.00	76.00	70.45	36.00	3.700	9065150037000
0.1496			3.80	6.00	116.00	76.00	70.30	36.00	3.800	9065150038000
0.1535	11/64		3.90	6.00	116.00	76.00	70.15	36.00	3.900	9065150039000
0.1563			3.97	6.00	116.00	76.00	70.05	36.00	3.970	9065150039700
0.1575			4.00	6.00	116.00	76.00	70.00	36.00	4.000	9065150040000
0.1614	3/16		4.10	6.00	133.00	93.00	86.85	36.00	4.100	9065150041000
0.1654			4.20	6.00	133.00	93.00	86.70	36.00	4.200	9065150042000
0.1693			4.30	6.00	133.00	93.00	86.55	36.00	4.300	9065150043000
0.1720			4.37	6.00	133.00	93.00	86.45	36.00	4.370	9065150043700
0.1732	#13		4.40	6.00	133.00	93.00	86.40	36.00	4.400	9065150044000
0.1772			4.50	6.00	133.00	93.00	86.25	36.00	4.500	9065150045000
0.1811			4.60	6.00	133.00	93.00	86.10	36.00	4.600	9065150046000
0.1831	#12		4.65	6.00	133.00	93.00	86.03	36.00	4.650	9065150046500
0.1850			4.70	6.00	133.00	93.00	85.95	36.00	4.700	9065150047000
0.1874			4.76	6.00	133.00	93.00	85.86	36.00	4.760	9065150047600
0.1890	7/32		4.80	6.00	133.00	93.00	85.80	36.00	4.800	9065150048000
0.1929			4.90	6.00	133.00	93.00	85.65	36.00	4.900	9065150049000
0.1969			5.00	6.00	133.00	93.00	85.50	36.00	5.000	9065150050000
0.2008	13/64		5.10	6.00	150.00	110.00	102.35	36.00	5.100	9065150051000
0.2031			5.16	6.00	150.00	110.00	102.26	36.00	5.160	9065150051600
0.2047			5.20	6.00	150.00	110.00	102.20	36.00	5.200	9065150052000
0.2087	7/16		5.30	6.00	150.00	110.00	102.05	36.00	5.300	9065150053000
0.2126			5.40	6.00	150.00	110.00	101.90	36.00	5.400	9065150054000
0.2165			5.50	6.00	150.00	110.00	101.75	36.00	5.500	9065150055000
0.2185	7/8		5.55	6.00	150.00	110.00	101.68	36.00	5.550	9065150055500
0.2189			5.56	6.00	150.00	110.00	101.66	36.00	5.560	9065150055600



Series										6515
d1	d1	d1	d1	d2	l1	l2	t _{max}	l3	Code	EDP No.
inch	fract. in	wire/ltr	mm	mm	mm	mm	mm	mm	no.	
0.2205			5.60	6.00	150.00	110.00	101.60	36.00	5.600	9065150056000
0.2244			5.70	6.00	150.00	110.00	101.45	36.00	5.700	9065150057000
0.2283			5.80	6.00	150.00	110.00	101.30	36.00	5.800	9065150058000
0.2323	15/64		5.90	6.00	150.00	110.00	101.15	36.00	5.900	9065150059000
0.2343			5.95	6.00	150.00	110.00	101.08	36.00	5.950	9065150059500
0.2362			6.00	6.00	150.00	110.00	101.00	36.00	6.000	9065150060000
0.2402			6.10	8.00	167.00	127.00	117.85	36.00	6.100	9065150061000
0.2441			6.20	8.00	167.00	127.00	117.70	36.00	6.200	9065150062000
0.2480			6.30	8.00	167.00	127.00	117.55	36.00	6.300	9065150063000
0.2500	1/4	E	6.35	8.00	167.00	127.00	117.48	36.00	6.350	9065150063500
0.2520			6.40	8.00	167.00	127.00	117.40	36.00	6.400	9065150064000
0.2559			6.50	8.00	167.00	127.00	117.25	36.00	6.500	9065150065000
0.2598			6.60	8.00	167.00	127.00	117.10	36.00	6.600	9065150066000
0.2638			6.70	8.00	167.00	127.00	116.95	36.00	6.700	9065150067000
0.2657			6.75	8.00	167.00	127.00	116.88	36.00	6.750	9065150067500
0.2677			6.80	8.00	167.00	127.00	116.80	36.00	6.800	9065150068000
0.2717			6.90	8.00	167.00	127.00	116.65	36.00	6.900	9065150069000
0.2756			7.00	8.00	167.00	127.00	116.50	36.00	7.000	9065150070000
0.2795	9/32		7.10	8.00	183.00	143.00	132.35	36.00	7.100	9065150071000
0.2811			7.14	8.00	183.00	143.00	132.29	36.00	7.140	9065150071400
0.2835			7.20	8.00	183.00	143.00	132.20	36.00	7.200	9065150072000
0.2874			7.30	8.00	183.00	143.00	132.05	36.00	7.300	9065150073000
0.2913			7.40	8.00	183.00	143.00	131.90	36.00	7.400	9065150074000
0.2953			7.50	8.00	183.00	143.00	131.75	36.00	7.500	9065150075000
0.2969	19/64		7.54	8.00	183.00	143.00	131.69	36.00	7.540	9065150075400
0.2992			7.60	8.00	183.00	143.00	131.60	36.00	7.600	9065150076000
0.3031			7.70	8.00	183.00	143.00	131.45	36.00	7.700	9065150077000
0.3071			7.80	8.00	183.00	143.00	131.30	36.00	7.800	9065150078000
0.3110			7.90	8.00	183.00	143.00	131.15	36.00	7.900	9065150079000
0.3126			7.94	8.00	183.00	143.00	131.09	36.00	7.940	9065150079400
0.3150	5/16		8.00	8.00	183.00	143.00	131.00	36.00	8.000	9065150080000
0.3189			8.10	10.00	204.00	160.00	147.85	40.00	8.100	9065150081000
0.3228			8.20	10.00	204.00	160.00	147.70	40.00	8.200	9065150082000
0.3268			8.30	10.00	204.00	160.00	147.55	40.00	8.300	9065150083000
0.3280			8.33	10.00	204.00	160.00	147.51	40.00	8.330	9065150083300
0.3307			8.40	10.00	204.00	160.00	147.40	40.00	8.400	9065150084000
0.3346	21/64		8.50	10.00	204.00	160.00	147.25	40.00	8.500	9065150085000
0.3386			8.60	10.00	204.00	160.00	147.10	40.00	8.600	9065150086000
0.3425			8.70	10.00	204.00	160.00	146.95	40.00	8.700	9065150087000
0.3437	11/32		8.73	10.00	204.00	160.00	146.91	40.00	8.730	9065150087300
0.3465			8.80	10.00	204.00	160.00	146.80	40.00	8.800	9065150088000
0.3504			8.90	10.00	204.00	160.00	146.65	40.00	8.900	9065150089000
0.3543			9.00	10.00	204.00	160.00	146.50	40.00	9.000	9065150090000
0.3583			9.10	10.00	221.00	177.00	163.35	40.00	9.100	9065150091000
0.3594			9.13	10.00	221.00	177.00	163.31	40.00	9.130	9065150091300
0.3622	23/64		9.20	10.00	221.00	177.00	163.20	40.00	9.200	9065150092000
0.3642			9.25	10.00	221.00	177.00	163.13	40.00	9.250	9065150092500
0.3661			9.30	10.00	221.00	177.00	163.05	40.00	9.300	9065150093000
0.3677			9.34	10.00	221.00	177.00	162.99	40.00	9.340	9065150093400
0.3701			9.40	10.00	221.00	177.00	162.90	40.00	9.400	9065150094000
0.3740			9.50	10.00	221.00	177.00	162.75	40.00	9.500	9065150095000
0.3748	3/8		9.52	10.00	221.00	177.00	162.72	40.00	9.520	9065150095200
0.3780			9.60	10.00	221.00	177.00	162.60	40.00	9.600	9065150096000
0.3819			9.70	10.00	221.00	177.00	162.45	40.00	9.700	9065150097000
0.3858			9.80	10.00	221.00	177.00	162.30	40.00	9.800	9065150098000
0.3898			9.90	10.00	221.00	177.00	162.15	40.00	9.900	9065150099000
0.3906			9.92	10.00	221.00	177.00	162.12	40.00	9.920	9065150099200
0.3937	25/64		10.00	10.00	221.00	177.00	162.00	40.00	10.000	9065150100000
0.3976			10.10	12.00	247.00	198.00	182.85	45.00	10.100	9065150101000



Series										6515
d1	d1	d1	d1	d2	l1	l2	t _{max}	l3	Code	EDP No.
inch	fract. in	wire/ltr	mm	mm	mm	mm	mm	mm	no.	
0.4016			10.20	12.00	247.00	198.00	182.70	45.00	10.200	9065150102000
0.4055	13/32		10.30	12.00	247.00	198.00	182.55	45.00	10.300	9065150103000
0.4063			10.32	12.00	247.00	198.00	182.52	45.00	10.320	9065150103200
0.4094			10.40	12.00	247.00	198.00	182.40	45.00	10.400	9065150104000
0.4134			10.50	12.00	247.00	198.00	182.25	45.00	10.500	9065150105000
0.4173			10.60	12.00	247.00	198.00	182.10	45.00	10.600	9065150106000
0.4213			10.70	12.00	247.00	198.00	181.95	45.00	10.700	9065150107000
0.4252			10.80	12.00	247.00	198.00	181.80	45.00	10.800	9065150108000
0.4291			10.90	12.00	247.00	198.00	181.65	45.00	10.900	9065150109000
0.4331			11.00	12.00	247.00	198.00	181.50	45.00	11.000	9065150110000
0.4370	7/16		11.10	12.00	263.00	214.00	197.35	45.00	11.100	9065150111000
0.4374			11.11	12.00	263.00	214.00	197.34	45.00	11.110	9065150111100
0.4409			11.20	12.00	263.00	214.00	197.20	45.00	11.200	9065150112000
0.4449			11.30	12.00	263.00	214.00	197.05	45.00	11.300	9065150113000
0.4488			11.40	12.00	263.00	214.00	196.90	45.00	11.400	9065150114000
0.4528			11.50	12.00	263.00	214.00	196.75	45.00	11.500	9065150115000
0.4567			11.60	12.00	263.00	214.00	196.60	45.00	11.600	9065150116000
0.4606			11.70	12.00	263.00	214.00	196.45	45.00	11.700	9065150117000
0.4646			11.80	12.00	263.00	214.00	196.30	45.00	11.800	9065150118000
0.4685	15/32		11.90	12.00	263.00	214.00	196.15	45.00	11.900	9065150119000
0.4689			11.91	12.00	263.00	214.00	196.14	45.00	11.910	9065150119100
0.4724			12.00	12.00	263.00	214.00	196.00	45.00	12.000	9065150120000
0.4764			12.10	14.00	297.00	248.00	229.85	45.00	12.100	9065150121000
0.4803			12.20	14.00	297.00	248.00	229.70	45.00	12.200	9065150122000
0.4921			12.50	14.00	297.00	248.00	229.25	45.00	12.500	9065150125000
0.4961	1/2		12.60	14.00	297.00	248.00	229.10	45.00	12.600	9065150126000
0.5000			12.70	14.00	297.00	248.00	228.95	45.00	12.700	9065150127000
0.5039			12.80	14.00	297.00	248.00	228.80	45.00	12.800	9065150128000
0.5079			12.90	14.00	297.00	248.00	228.65	45.00	12.900	9065150129000
0.5118	33/64		13.00	14.00	297.00	248.00	228.50	45.00	13.000	9065150130000
0.5157			13.10	14.00	297.00	248.00	228.35	45.00	13.100	9065150131000
0.5236			13.30	14.00	297.00	248.00	228.05	45.00	13.300	9065150133000
0.5276			13.40	14.00	297.00	248.00	227.90	45.00	13.400	9065150134000
0.5315			13.50	14.00	297.00	248.00	227.75	45.00	13.500	9065150135000
0.5394			13.70	14.00	297.00	248.00	227.45	45.00	13.700	9065150137000
0.5433			13.80	14.00	297.00	248.00	227.30	45.00	13.800	9065150138000
0.5512			14.00	14.00	297.00	248.00	227.00	45.00	14.000	9065150140000



RT 100 T AL - Deep hole drill for aluminum



Tool material

Solid carbide

Coating

Uncoated

Shank form

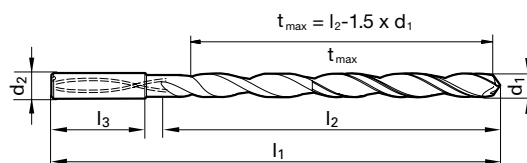
HA

Material		Suitability
P	Steel	
M	Stainless steel	
K	Cast iron	
N	Aluminum	●
S	Ni / Ti alloys	
H	Hardened steel	

●=Optimal ○=Limited

facet point grind • main cutting edge form concave • optimized flute design • maximum diameter of coolant ducts • observe coolant pressure • for piloting we recommend RT 100 Al, Series 5768

aluminum and Al-alloys



Series										6516
d1	d1	d1	d1	d2	l1	l2	t _{max}	l3	Code	EDP No.
inch	fract. in	wire/ltr	mm	mm	mm	mm	mm	mm	no.	
0.1181	1/8		3.00	6.00	110.00	70.00	65.50	36.00	3.000	9065160030000
0.1220			3.10	6.00	123.00	83.00	78.35	36.00	3.100	9065160031000
0.1248			3.17	6.00	123.00	83.00	78.25	36.00	3.170	9065160031700
0.1260			3.20	6.00	123.00	83.00	78.20	36.00	3.200	9065160032000
0.1280			3.25	6.00	123.00	83.00	78.13	36.00	3.250	9065160032500
0.1299			3.30	6.00	123.00	83.00	78.05	36.00	3.300	9065160033000
0.1339	9/64		3.40	6.00	123.00	83.00	77.90	36.00	3.400	9065160034000
0.1378			3.50	6.00	136.00	96.00	90.75	36.00	3.500	9065160035000
0.1406			3.57	6.00	136.00	96.00	90.65	36.00	3.570	9065160035700
0.1417			3.60	6.00	136.00	96.00	90.60	36.00	3.600	9065160036000
0.1457			3.70	6.00	136.00	96.00	90.45	36.00	3.700	9065160037000
0.1496			3.80	6.00	136.00	96.00	90.30	36.00	3.800	9065160038000
0.1535	5/32		3.90	6.00	136.00	96.00	90.15	36.00	3.900	9065160039000
0.1563			3.97	6.00	136.00	96.00	90.05	36.00	3.970	9065160039700
0.1575			4.00	6.00	136.00	96.00	90.00	36.00	4.000	9065160040000
0.1614	11/64		4.10	6.00	158.00	118.00	111.85	36.00	4.100	9065160041000
0.1654			4.20	6.00	158.00	118.00	111.70	36.00	4.200	9065160042000
0.1693			4.30	6.00	158.00	118.00	111.55	36.00	4.300	9065160043000
0.1720			4.37	6.00	158.00	118.00	111.45	36.00	4.370	9065160043700
0.1732			4.40	6.00	158.00	118.00	111.40	36.00	4.400	9065160044000
0.1772			4.50	6.00	158.00	118.00	111.25	36.00	4.500	9065160045000
0.1811	3/16		4.60	6.00	158.00	118.00	111.10	36.00	4.600	9065160046000
0.1831			4.65	6.00	158.00	118.00	111.03	36.00	4.650	9065160046500
0.1850		#13	4.70	6.00	158.00	118.00	110.95	36.00	4.700	9065160047000
0.1874			4.76	6.00	158.00	118.00	110.86	36.00	4.760	9065160047600
0.1890			4.80	6.00	158.00	118.00	110.80	36.00	4.800	9065160048000
0.1929		#12	4.90	6.00	158.00	118.00	110.65	36.00	4.900	9065160049000
0.1969	13/64		5.00	6.00	158.00	118.00	110.50	36.00	5.000	9065160050000
0.2008			5.10	6.00	180.00	140.00	132.35	36.00	5.100	9065160051000
0.2031			5.16	6.00	180.00	140.00	132.26	36.00	5.160	9065160051600
0.2047			5.20	6.00	180.00	140.00	132.20	36.00	5.200	9065160052000
0.2087			5.30	6.00	180.00	140.00	132.05	36.00	5.300	9065160053000
0.2126			5.40	6.00	180.00	140.00	131.90	36.00	5.400	9065160054000
0.2165	7/32		5.50	6.00	180.00	140.00	131.75	36.00	5.500	9065160055000
0.2185			5.55	6.00	180.00	140.00	131.68	36.00	5.550	9065160055500
0.2189			5.56	6.00	180.00	140.00	131.66	36.00	5.560	9065160055600



Series										6516
d1	d1	d1	d1	d2	l1	l2	t _{max}	l3	Code	EDP No.
inch	fract. in	wire/ltr	mm	mm	mm	mm	mm	mm	no.	
0.2205			5.60	6.00	180.00	140.00	131.60	36.00	5.600	9065160056000
0.2244			5.70	6.00	180.00	140.00	131.45	36.00	5.700	9065160057000
0.2283			5.80	6.00	180.00	140.00	131.30	36.00	5.800	9065160058000
0.2323			5.90	6.00	180.00	140.00	131.15	36.00	5.900	9065160059000
0.2343	15/64		5.95	6.00	180.00	140.00	131.08	36.00	5.950	9065160059500
0.2362			6.00	6.00	180.00	140.00	131.00	36.00	6.000	9065160060000
0.2402			6.10	8.00	202.00	162.00	152.85	36.00	6.100	9065160061000
0.2441			6.20	8.00	202.00	162.00	152.70	36.00	6.200	9065160062000
0.2480			6.30	8.00	202.00	162.00	152.55	36.00	6.300	9065160063000
0.2500	1/4	E	6.35	8.00	202.00	162.00	152.48	36.00	6.350	9065160063500
0.2520			6.40	8.00	202.00	162.00	152.40	36.00	6.400	9065160064000
0.2559			6.50	8.00	202.00	162.00	152.25	36.00	6.500	9065160065000
0.2598			6.60	8.00	202.00	162.00	152.10	36.00	6.600	9065160066000
0.2638			6.70	8.00	202.00	162.00	151.95	36.00	6.700	9065160067000
0.2657	17/64		6.75	8.00	202.00	162.00	151.88	36.00	6.750	9065160067500
0.2677			6.80	8.00	202.00	162.00	151.80	36.00	6.800	9065160068000
0.2717			6.90	8.00	202.00	162.00	151.65	36.00	6.900	9065160069000
0.2756			7.00	8.00	202.00	162.00	151.50	36.00	7.000	9065160070000
0.2795			7.10	8.00	223.00	183.00	172.35	36.00	7.100	9065160071000
0.2811	9/32		7.14	8.00	223.00	183.00	172.29	36.00	7.140	9065160071400
0.2835			7.20	8.00	223.00	183.00	172.20	36.00	7.200	9065160072000
0.2874			7.30	8.00	223.00	183.00	172.05	36.00	7.300	9065160073000
0.2913			7.40	8.00	223.00	183.00	171.90	36.00	7.400	9065160074000
0.2953			7.50	8.00	223.00	183.00	171.75	36.00	7.500	9065160075000
0.2969	19/64		7.54	8.00	223.00	183.00	171.69	36.00	7.540	9065160075400
0.2992			7.60	8.00	223.00	183.00	171.60	36.00	7.600	9065160076000
0.3031			7.70	8.00	223.00	183.00	171.45	36.00	7.700	9065160077000
0.3071			7.80	8.00	223.00	183.00	171.30	36.00	7.800	9065160078000
0.3110			7.90	8.00	223.00	183.00	171.15	36.00	7.900	9065160079000
0.3126	5/16		7.94	8.00	223.00	183.00	171.09	36.00	7.940	9065160079400
0.3150			8.00	8.00	223.00	183.00	171.00	36.00	8.000	9065160080000
0.3189			8.10	10.00	249.00	205.00	192.85	40.00	8.100	9065160081000
0.3228			8.20	10.00	249.00	205.00	192.70	40.00	8.200	9065160082000
0.3268			8.30	10.00	249.00	205.00	192.55	40.00	8.300	9065160083000
0.3280	21/64		8.33	10.00	249.00	205.00	192.51	40.00	8.330	9065160083300
0.3307			8.40	10.00	249.00	205.00	192.40	40.00	8.400	9065160084000
0.3346			8.50	10.00	249.00	205.00	192.25	40.00	8.500	9065160085000
0.3386			8.60	10.00	249.00	205.00	192.10	40.00	8.600	9065160086000
0.3425			8.70	10.00	249.00	205.00	191.95	40.00	8.700	9065160087000
0.3437	11/32		8.73	10.00	249.00	205.00	191.91	40.00	8.730	9065160087300
0.3465			8.80	10.00	249.00	205.00	191.80	40.00	8.800	9065160088000
0.3504			8.90	10.00	249.00	205.00	191.65	40.00	8.900	9065160089000
0.3543			9.00	10.00	249.00	205.00	191.50	40.00	9.000	9065160090000
0.3583			9.10	10.00	271.00	227.00	213.35	40.00	9.100	9065160091000
0.3594	23/64		9.13	10.00	271.00	227.00	213.31	40.00	9.130	9065160091300
0.3622			9.20	10.00	271.00	227.00	213.20	40.00	9.200	9065160092000
0.3642			9.25	10.00	271.00	227.00	213.13	40.00	9.250	9065160092500
0.3661			9.30	10.00	271.00	227.00	213.05	40.00	9.300	9065160093000
0.3677			9.34	10.00	271.00	227.00	212.99	40.00	9.340	9065160093400
0.3701			9.40	10.00	271.00	227.00	212.90	40.00	9.400	9065160094000
0.3740			9.50	10.00	271.00	227.00	212.75	40.00	9.500	9065160095000
0.3748	3/8		9.52	10.00	271.00	227.00	212.72	40.00	9.520	9065160095200
0.3780			9.60	10.00	271.00	227.00	212.60	40.00	9.600	9065160096000
0.3819			9.70	10.00	271.00	227.00	212.45	40.00	9.700	9065160097000
0.3858			9.80	10.00	271.00	227.00	212.30	40.00	9.800	9065160098000
0.3898			9.90	10.00	271.00	227.00	212.15	40.00	9.900	9065160099000
0.3906	25/64		9.92	10.00	271.00	227.00	212.12	40.00	9.920	9065160099200
0.3937			10.00	10.00	271.00	227.00	212.00	40.00	10.000	9065160100000
0.3976			10.10	12.00	302.00	253.00	237.85	45.00	10.100	9065160101000



Series										6516
d1	d1	d1	d1	d2	l1	l2	t _{max}	l3	Code	EDP No.
inch	fract. in	wire/ltr	mm	mm	mm	mm	mm	mm	no.	
0.4016			10.20	12.00	302.00	253.00	237.70	45.00	10.200	9065160102000
0.4055			10.30	12.00	302.00	253.00	237.55	45.00	10.300	9065160103000
0.4063	13/32		10.32	12.00	302.00	253.00	237.52	45.00	10.320	9065160103200
0.4094			10.40	12.00	302.00	253.00	237.40	45.00	10.400	9065160104000
0.4134			10.50	12.00	302.00	253.00	237.25	45.00	10.500	9065160105000
0.4173			10.60	12.00	302.00	253.00	237.10	45.00	10.600	9065160106000
0.4213			10.70	12.00	302.00	253.00	236.95	45.00	10.700	9065160107000
0.4252			10.80	12.00	302.00	253.00	236.80	45.00	10.800	9065160108000
0.4291			10.90	12.00	302.00	253.00	236.65	45.00	10.900	9065160109000
0.4331			11.00	12.00	302.00	253.00	236.50	45.00	11.000	9065160110000
0.4370			11.10	12.00	323.00	274.00	257.35	45.00	11.100	9065160111000
0.4374	7/16		11.11	12.00	323.00	274.00	257.34	45.00	11.110	9065160111100
0.4409			11.20	12.00	323.00	274.00	257.20	45.00	11.200	9065160112000
0.4449			11.30	12.00	323.00	274.00	257.05	45.00	11.300	9065160113000
0.4488			11.40	12.00	323.00	274.00	256.90	45.00	11.400	9065160114000
0.4528			11.50	12.00	323.00	274.00	256.75	45.00	11.500	9065160115000
0.4567			11.60	12.00	323.00	274.00	256.60	45.00	11.600	9065160116000
0.4606			11.70	12.00	323.00	274.00	256.45	45.00	11.700	9065160117000
0.4646			11.80	12.00	323.00	274.00	256.30	45.00	11.800	9065160118000
0.4685			11.90	12.00	323.00	274.00	256.15	45.00	11.900	9065160119000
0.4689	15/32		11.91	12.00	323.00	274.00	256.14	45.00	11.910	9065160119100
0.4724			12.00	12.00	323.00	274.00	256.00	45.00	12.000	9065160120000
0.4764			12.10	14.00	367.00	318.00	299.85	45.00	12.100	9065160121000
0.4803			12.20	14.00	367.00	318.00	299.70	45.00	12.200	9065160122000
0.4921			12.50	14.00	367.00	318.00	299.25	45.00	12.500	9065160125000
0.4961			12.60	14.00	367.00	318.00	299.10	45.00	12.600	9065160126000
0.5000	1/2		12.70	14.00	367.00	318.00	298.95	45.00	12.700	9065160127000
0.5039			12.80	14.00	367.00	318.00	298.80	45.00	12.800	9065160128000
0.5079			12.90	14.00	367.00	318.00	298.65	45.00	12.900	9065160129000
0.5118			13.00	14.00	367.00	318.00	298.50	45.00	13.000	9065160130000
0.5157	33/64		13.10	14.00	367.00	318.00	298.35	45.00	13.100	9065160131000
0.5236			13.30	14.00	367.00	318.00	298.05	45.00	13.300	9065160133000
0.5276			13.40	14.00	367.00	318.00	297.90	45.00	13.400	9065160134000
0.5315			13.50	14.00	367.00	318.00	297.75	45.00	13.500	9065160135000
0.5394			13.70	14.00	367.00	318.00	297.45	45.00	13.700	9065160137000
0.5433			13.80	14.00	367.00	318.00	297.30	45.00	13.800	9065160138000
0.5512			14.00	14.00	367.00	318.00	297.00	45.00	14.000	9065160140000



RT 100 T AL - Deep hole drill for aluminum



Tool material

Solid carbide

Coating

Uncoated

Shank form

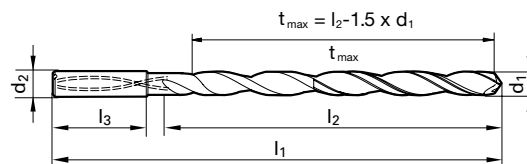
HA

Material	Suitability
P Steel	
M Stainless steel	
K Cast iron	
N Aluminum	●
S Ni / Ti alloys	
H Hardened steel	

●=Optimal ○=Limited

facet point grind • main cutting edge form concave • optimized flute design • maximum diameter of coolant ducts • observe coolant pressure • for piloting we recommend RT 100 Al, Series 5768

aluminum and Al-alloys



Series										6517
d1	d1	d1	d1	d2	l1	l2	t _{max}	l3	Code	EDP No.
inch	fract. in	wire/ltr	mm	mm	mm	mm	mm	mm	no.	
0.1181			3.00	6.00	125.00	85.00	80.50	36.00	3.00	9065170030000
0.1220			3.10	6.00	141.00	101.00	96.35	36.00	3.10	9065170031000
0.1248	1/8		3.17	6.00	141.00	101.00	96.25	36.00	3.17	9065170031700
0.1260			3.20	6.00	141.00	101.00	96.20	36.00	3.20	9065170032000
0.1280			3.25	6.00	141.00	101.00	96.13	36.00	3.25	9065170032500
0.1299			3.30	6.00	141.00	101.00	96.05	36.00	3.30	9065170033000
0.1339			3.40	6.00	141.00	101.00	95.90	36.00	3.40	9065170034000
0.1378			3.50	6.00	156.00	116.00	110.75	36.00	3.50	9065170035000
0.1406	9/64		3.57	6.00	156.00	116.00	110.65	36.00	3.57	9065170035700
0.1417			3.60	6.00	156.00	116.00	110.60	36.00	3.60	9065170036000
0.1457			3.70	6.00	156.00	116.00	110.45	36.00	3.70	9065170037000
0.1496			3.80	6.00	156.00	116.00	110.30	36.00	3.80	9065170038000
0.1535			3.90	6.00	156.00	116.00	110.15	36.00	3.90	9065170039000
0.1563	5/32		3.97	6.00	156.00	116.00	110.05	36.00	3.97	9065170039700
0.1575			4.00	6.00	156.00	116.00	110.00	36.00	4.00	9065170040000
0.1614			4.10	6.00	183.00	143.00	136.85	36.00	4.10	9065170041000
0.1654			4.20	6.00	183.00	143.00	136.70	36.00	4.20	9065170042000
0.1693			4.30	6.00	183.00	143.00	136.55	36.00	4.30	9065170043000
0.1720	11/64		4.37	6.00	183.00	143.00	136.45	36.00	4.37	9065170043700
0.1732			4.40	6.00	183.00	143.00	136.40	36.00	4.40	9065170044000
0.1772			4.50	6.00	183.00	143.00	136.25	36.00	4.50	9065170045000
0.1811			4.60	6.00	183.00	143.00	136.10	36.00	4.60	9065170046000
0.1831			4.65	6.00	183.00	143.00	136.03	36.00	4.65	9065170046500
0.1850		#13	4.70	6.00	183.00	143.00	135.95	36.00	4.70	9065170047000
0.1874	3/16		4.76	6.00	183.00	143.00	135.86	36.00	4.76	9065170047600
0.1890		#12	4.80	6.00	183.00	143.00	135.80	36.00	4.80	9065170048000
0.1929			4.90	6.00	183.00	143.00	135.65	36.00	4.90	9065170049000
0.1969			5.00	6.00	183.00	143.00	135.50	36.00	5.00	9065170050000
0.2008			5.10	6.00	210.00	170.00	162.35	36.00	5.10	9065170051000
0.2031	13/64		5.16	6.00	210.00	170.00	162.26	36.00	5.16	9065170051600
0.2047			5.20	6.00	210.00	170.00	162.20	36.00	5.20	9065170052000
0.2087			5.30	6.00	210.00	170.00	162.05	36.00	5.30	9065170053000
0.2126			5.40	6.00	210.00	170.00	161.90	36.00	5.40	9065170054000
0.2165			5.50	6.00	210.00	170.00	161.75	36.00	5.50	9065170055000
0.2185			5.55	6.00	210.00	170.00	161.68	36.00	5.55	9065170055500
0.2189	7/32		5.56	6.00	210.00	170.00	161.66	36.00	5.56	9065170055600



Series										6517
d1	d1	d1	d1	d2	l1	l2	t _{max}	l3	Code	EDP No.
inch	fract. in	wire/ltr	mm	mm	mm	mm	mm	mm	no.	
0.2205			5.60	6.00	210.00	170.00	161.60	36.00	5.60	9065170056000
0.2244			5.70	6.00	210.00	170.00	161.45	36.00	5.70	9065170057000
0.2283			5.80	6.00	210.00	170.00	161.30	36.00	5.80	9065170058000
0.2323			5.90	6.00	210.00	170.00	161.15	36.00	5.90	9065170059000
0.2343	15/64		5.95	6.00	210.00	170.00	161.08	36.00	5.95	9065170059500
0.2362			6.00	6.00	210.00	170.00	161.00	36.00	6.00	9065170060000
0.2402			6.10	8.00	237.00	197.00	187.85	36.00	6.10	9065170061000
0.2441			6.20	8.00	237.00	197.00	187.70	36.00	6.20	9065170062000
0.2480			6.30	8.00	237.00	197.00	187.55	36.00	6.30	9065170063000
0.2500	1/4	E	6.35	8.00	237.00	197.00	187.48	36.00	6.35	9065170063500
0.2520			6.40	8.00	237.00	197.00	187.40	36.00	6.40	9065170064000
0.2559			6.50	8.00	237.00	197.00	187.25	36.00	6.50	9065170065000
0.2598			6.60	8.00	237.00	197.00	187.10	36.00	6.60	9065170066000
0.2638			6.70	8.00	237.00	197.00	186.95	36.00	6.70	9065170067000
0.2657	17/64		6.75	8.00	237.00	197.00	186.88	36.00	6.75	9065170067500
0.2677			6.80	8.00	237.00	197.00	186.80	36.00	6.80	9065170068000
0.2717			6.90	8.00	237.00	197.00	186.65	36.00	6.90	9065170069000
0.2756			7.00	8.00	237.00	197.00	186.50	36.00	7.00	9065170070000
0.2795			7.10	8.00	263.00	223.00	212.35	36.00	7.10	9065170071000
0.2811	9/32		7.14	8.00	263.00	223.00	212.29	36.00	7.14	9065170071400
0.2835			7.20	8.00	263.00	223.00	212.20	36.00	7.20	9065170072000
0.2874			7.30	8.00	263.00	223.00	212.05	36.00	7.30	9065170073000
0.2913			7.40	8.00	263.00	223.00	211.90	36.00	7.40	9065170074000
0.2953			7.50	8.00	263.00	223.00	211.75	36.00	7.50	9065170075000
0.2969	19/64		7.54	8.00	263.00	223.00	211.69	36.00	7.54	9065170075400
0.2992			7.60	8.00	263.00	223.00	211.60	36.00	7.60	9065170076000
0.3031			7.70	8.00	263.00	223.00	211.45	36.00	7.70	9065170077000
0.3071			7.80	8.00	263.00	223.00	211.30	36.00	7.80	9065170078000
0.3110			7.90	8.00	263.00	223.00	211.15	36.00	7.90	9065170079000
0.3126	5/16		7.94	8.00	263.00	223.00	211.09	36.00	7.94	9065170079400
0.3150			8.00	8.00	263.00	223.00	211.00	36.00	8.00	9065170080000
0.3189			8.10	10.00	294.00	250.00	237.85	40.00	8.10	9065170081000
0.3228			8.20	10.00	294.00	250.00	237.70	40.00	8.20	9065170082000
0.3268			8.30	10.00	294.00	250.00	237.55	40.00	8.30	9065170083000
0.3280	21/64		8.33	10.00	294.00	250.00	237.51	40.00	8.33	9065170083300
0.3307			8.40	10.00	294.00	250.00	237.40	40.00	8.40	9065170084000
0.3346			8.50	10.00	294.00	250.00	237.25	40.00	8.50	9065170085000
0.3386			8.60	10.00	294.00	250.00	237.10	40.00	8.60	9065170086000
0.3425			8.70	10.00	294.00	250.00	236.95	40.00	8.70	9065170087000
0.3437	11/32		8.73	10.00	294.00	250.00	236.91	40.00	8.73	9065170087300
0.3465			8.80	10.00	294.00	250.00	236.80	40.00	8.80	9065170088000
0.3504			8.90	10.00	294.00	250.00	236.65	40.00	8.90	9065170089000
0.3543			9.00	10.00	294.00	250.00	236.50	40.00	9.00	9065170090000
0.3583			9.10	10.00	321.00	277.00	263.35	40.00	9.10	9065170091000
0.3594	23/64		9.13	10.00	321.00	277.00	263.31	40.00	9.13	9065170091300
0.3622			9.20	10.00	321.00	277.00	263.20	40.00	9.20	9065170092000
0.3642			9.25	10.00	321.00	277.00	263.13	40.00	9.25	9065170092500
0.3661			9.30	10.00	321.00	277.00	263.05	40.00	9.30	9065170093000
0.3677			9.34	10.00	321.00	277.00	262.99	40.00	9.34	9065170093400
0.3701			9.40	10.00	321.00	277.00	262.90	40.00	9.40	9065170094000
0.3740			9.50	10.00	321.00	277.00	262.75	40.00	9.50	9065170095000
0.3748	3/8		9.52	10.00	321.00	277.00	262.72	40.00	9.52	9065170095200
0.3780			9.60	10.00	321.00	277.00	262.60	40.00	9.60	9065170096000
0.3819			9.70	10.00	321.00	277.00	262.45	40.00	9.70	9065170097000
0.3858			9.80	10.00	321.00	277.00	262.30	40.00	9.80	9065170098000
0.3898			9.90	10.00	321.00	277.00	262.15	40.00	9.90	9065170099000
0.3906	25/64		9.92	10.00	321.00	277.00	262.12	40.00	9.92	9065170099200
0.3937			10.00	10.00	321.00	277.00	262.00	40.00	10.00	9065170100000
0.3976			10.10	12.00	359.00	310.00	294.85	45.00	10.10	9065170101000



Series										6517
d1	d1	d1	d1	d2	l1	l2	t _{max}	l3	Code	EDP No.
inch	fract. in	wire/ltr	mm	mm	mm	mm	mm	mm	no.	
0.4016			10.20	12.00	359.00	310.00	294.70	45.00	10.20	9065170102000
0.4055			10.30	12.00	359.00	310.00	294.55	45.00	10.30	9065170103000
0.4063	13/32		10.32	12.00	359.00	310.00	294.52	45.00	10.32	9065170103200
0.4094			10.40	12.00	359.00	310.00	294.40	45.00	10.40	9065170104000
0.4134			10.50	12.00	359.00	310.00	294.25	45.00	10.50	9065170105000
0.4173			10.60	12.00	359.00	310.00	294.10	45.00	10.60	9065170106000
0.4213			10.70	12.00	359.00	310.00	293.95	45.00	10.70	9065170107000
0.4252			10.80	12.00	359.00	310.00	293.80	45.00	10.80	9065170108000
0.4291			10.90	12.00	359.00	310.00	293.65	45.00	10.90	9065170109000
0.4331			11.00	12.00	359.00	310.00	293.50	45.00	11.00	9065170110000
0.4370			11.10	12.00	386.00	337.00	320.35	45.00	11.10	9065170111000
0.4374	7/16		11.11	12.00	386.00	337.00	320.34	45.00	11.11	9065170111100
0.4409			11.20	12.00	386.00	337.00	320.20	45.00	11.20	9065170112000
0.4449			11.30	12.00	386.00	337.00	320.05	45.00	11.30	9065170113000
0.4488			11.40	12.00	386.00	337.00	319.90	45.00	11.40	9065170114000
0.4528			11.50	12.00	386.00	337.00	319.75	45.00	11.50	9065170115000
0.4567			11.60	12.00	386.00	337.00	319.60	45.00	11.60	9065170116000
0.4606			11.70	12.00	386.00	337.00	319.45	45.00	11.70	9065170117000
0.4646			11.80	12.00	386.00	337.00	319.30	45.00	11.80	9065170118000
0.4685			11.90	12.00	386.00	337.00	319.15	45.00	11.90	9065170119000
0.4689	15/32		11.91	12.00	386.00	337.00	319.14	45.00	11.91	9065170119100
0.4724			12.00	12.00	386.00	337.00	319.00	45.00	12.00	9065170120000
0.4764			12.10	14.00	437.00	388.00	369.85	45.00	12.10	9065170121000
0.4803			12.20	14.00	437.00	388.00	369.70	45.00	12.20	9065170122000
0.4921			12.50	14.00	437.00	388.00	369.25	45.00	12.50	9065170125000
0.4961			12.60	14.00	437.00	388.00	369.10	45.00	12.60	9065170126000
0.5000	1/2		12.70	14.00	437.00	388.00	368.95	45.00	12.70	9065170127000
0.5039			12.80	14.00	437.00	388.00	368.80	45.00	12.80	9065170128000
0.5079			12.90	14.00	437.00	388.00	368.65	45.00	12.90	9065170129000
0.5118			13.00	14.00	437.00	388.00	368.50	45.00	13.00	9065170130000
0.5157	33/64		13.10	14.00	437.00	388.00	368.35	45.00	13.10	9065170131000
0.5236			13.30	14.00	437.00	388.00	368.05	45.00	13.30	9065170133000
0.5276			13.40	14.00	437.00	388.00	367.90	45.00	13.40	9065170134000
0.5315			13.50	14.00	437.00	388.00	367.75	45.00	13.50	9065170135000
0.5394			13.70	14.00	437.00	388.00	367.45	45.00	13.70	9065170137000
0.5433			13.80	14.00	437.00	388.00	367.30	45.00	13.80	9065170138000
0.5512			14.00	14.00	437.00	388.00	367.00	45.00	14.00	9065170140000

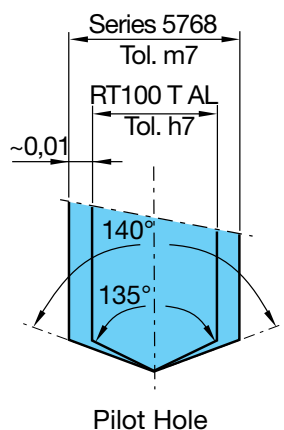


6515, 6516, 6517 (RT 100 T AL) Operating Parameters

Material group	Hardness		SFM	Feed Rate - IPR					
	HRc	Bhn		1/8 in. 3.170 mm	1/4 in. 6.350 mm	3/8 in. 9.520 mm	1/2 in. 12.700 mm	5/8 in. 15.870 mm	3/4 in. 19.050 mm
Aluminium and Al-alloys	-	≤ 120	395	0.0050	0.0080	0.0125	0.0125	0.0155	0.0195
Al wrought alloys	-	≤ 200	395	0.0050	0.0080	0.0125	0.0125	0.0155	0.0195
Al cast alloys ≤ 10 % Si	-	≤ 180	460	0.0065	0.0125	0.0155	0.0195	0.0250	0.0250
> 10 % Si	-	≤ 180	395	0.0065	0.0125	0.0155	0.0195	0.0250	0.0250
Magnesium alloys	-	≤ 120	510	0.0065	0.0100	0.0155	0.0155	0.0195	0.0250
Copper, low-alloyed	-	≤ 150	395	0.0025	0.0040	0.0065	0.0065	0.0080	0.0100
Brass, short-chipping	-	≤ 180	460	0.0050	0.0080	0.0125	0.0125	0.0155	0.0195
long-chipping	-	≤ 180	460	0.0050	0.0080	0.0125	0.0125	0.0155	0.0195
Bronze, short-chipping	-	≤ 180	395	0.0050	0.0080	0.0125	0.0125	0.0155	0.0195
	≤ 25	≤ 255	395	0.0040	0.0065	0.0100	0.0100	0.0125	0.0155
Bronze, long-chipping	≤ 25	≤ 255							
	≤ 32	≤ 301							
Duroplastics			330	0.0020	0.0030	0.0050	0.0050	0.0065	0.0080
Thermoplastics			330	0.0020	0.0030	0.0050	0.0050	0.0065	0.0080
Reinforced plastics - Kevlar									
Reinforced plastics - GFK / CFK									

5768 (Recommended pilot drill) Operating Parameters

Material group	Hardness		SFM	Feed Rate - IPR					
	HRc	Bhn		1/8 in. 3.170 mm	1/4 in. 6.350 mm	3/8 in. 9.520 mm	1/2 in. 12.700 mm	5/8 in. 15.870 mm	3/4 in. 19.050 mm
Aluminium and Al-alloys	-	≤ 120	1150	0.0065	0.0125	0.0155	0.0195	0.0250	0.0250
Al wrought alloys	-	≤ 200	1150	0.0065	0.0125	0.0155	0.0195	0.0250	0.0250
Al cast alloys ≤ 10 % Si	-	≤ 180	1050	0.0065	0.0100	0.0155	0.0155	0.0195	0.0250
> 10 % Si	-	≤ 180	920	0.0050	0.0080	0.0125	0.0125	0.0155	0.0195
Magnesium alloys	-	≤ 120	1050	0.0050	0.0080	0.0125	0.0125	0.0155	0.0195
Copper, low-alloyed	-	≤ 150	625	0.0050	0.0080	0.0125	0.0125	0.0155	0.0195
Brass, short-chipping	-	≤ 180	525	0.0040	0.0065	0.0100	0.0100	0.0125	0.0155
long-chipping	-	≤ 180	525	0.0040	0.0065	0.0100	0.0100	0.0125	0.0155
Bronze, short-chipping	-	≤ 180	525	0.0040	0.0065	0.0100	0.0100	0.0125	0.0155
	≤ 25	≤ 255	525	0.0040	0.0065	0.0100	0.0100	0.0125	0.0155
Bronze, long-chipping	≤ 25	≤ 255	490	0.0040	0.0065	0.0100	0.0100	0.0125	0.0155
	≤ 32	≤ 301	490	0.0040	0.0065	0.0100	0.0100	0.0125	0.0155
Duroplastics			330	0.0020	0.0030	0.0050	0.0050	0.0065	0.0080
Thermoplastics			330	0.0020	0.0030	0.0050	0.0050	0.0065	0.0080
Reinforced plastics - Kevlar									
Reinforced plastics - GFK / CFK			330	0.0015	0.0025	0.0040	0.0040	0.0050	0.0065



Recommended drilling procedure for RT100 T AL drills:

- Machine a pilot hole with an m7 toleranced Guhring series 5768 drill to a pilot depth of 2xD to 3xD.
- Enter the pilot hole at a speed of approx. 300 RPM, and with a feed rate of approx. 20 IPM stopping just shy of the bottom of the hole.
- Start high coolant pressure and increase RPM to recommended value.
- Feed drill at recommended feed rate to final hole depth. No peck cycle required.
- For through holes with oblique exit, reduce the feed rate to 40% approx. 1 mm prior to break-through.
- After reaching hole depth, turn off coolant, reduce machine spindle speed to 300RPM and withdraw the drill at a maximum feed rate of 200IPM.



Item no 400001846

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