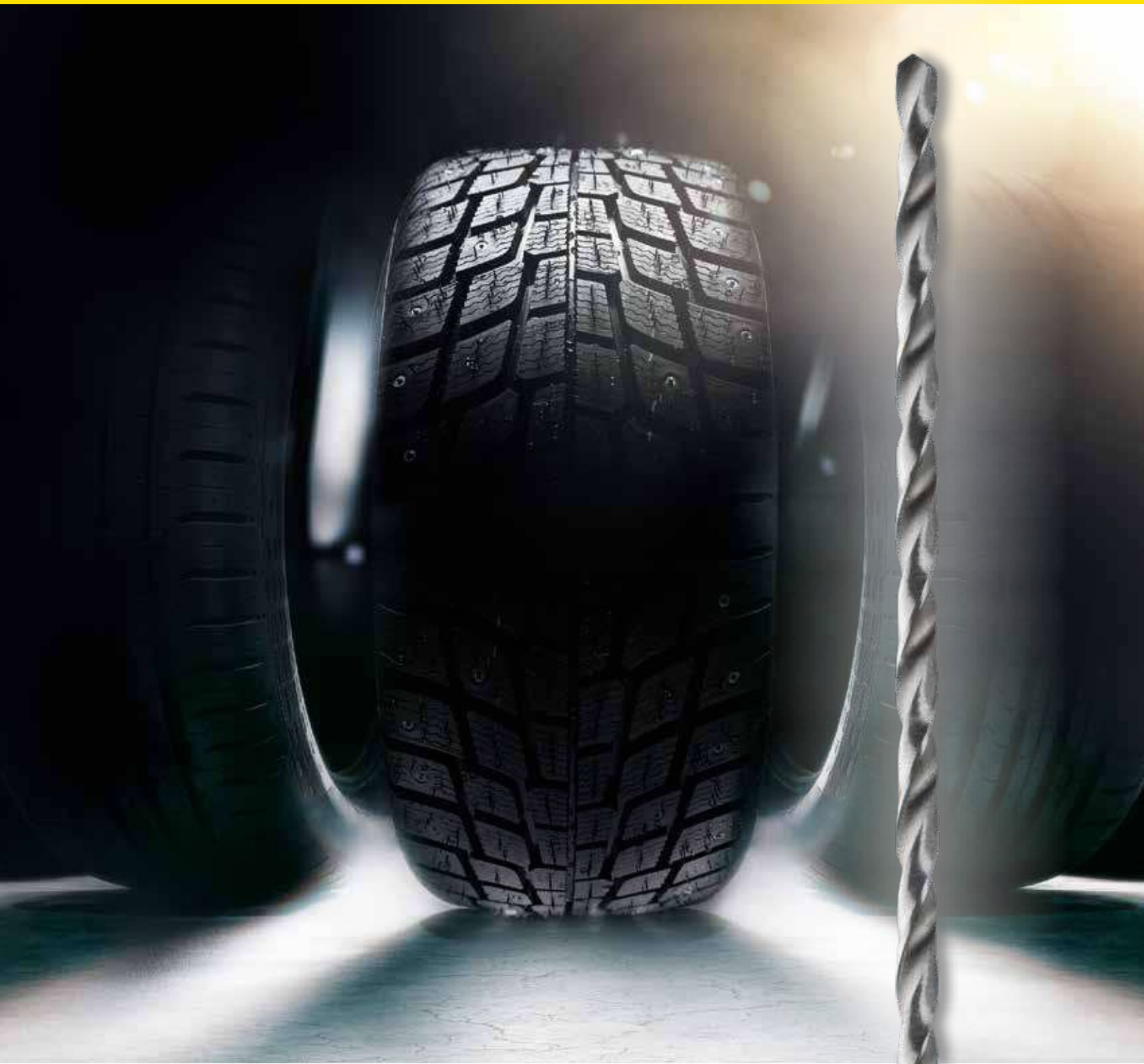


GUHRING



HSS twist drills

for cleaning out and drilling holes in tire tread molds

GUHRING – YOUR WORLDWIDE PARTNER



The final step in tire production is vulcanization where blanks are pressed into molds or mold segments under heat and pressure and the tire receives its final tread. If air is trapped between the blank and the mold, this drastically reduces production quality. This is prevented by small openings in the profile form through which the air can escape during the process. These openings must be kept free of residues for the entire life of the mold. We have developed an extra long drill for use on tire molding tools: The combination of tough HSS-M2 cutting material and specially shaped flutes enables reliable cleaning and drilling of vent holes in steel and aluminum molding tools. The drill can be used in handheld, manual machines as well as in stationary systems.

POINT ANGLE
relieved cone 118°

TOOL MATERIAL
HSS-M2 for high toughness:
Cleaning and drilling of vent holes
possible without breakage.

FLUTES
specially shaped flutes for
reliable chip formation
and chip evacuation





Extra length twist drills



N



h8



• relieved cone • common diameters
available in different lengths

• for cleaning out and drilling vent holes in industrial mold making,
especially in tire manufacturing

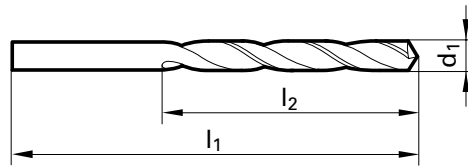
Tool material

HSS

Surface



Cutting direction



Series no.

6403

d1		l1	l2	Code no.	EDP #	d1		l1	l2	Code no.	EDP #
mm	inch	mm	mm			mm	inch	mm	mm		
0.500		50.00	25.00	0.500	9064030005000	1.320	#55	101.60	76.20	1.320	9064030013200
0.550		50.00	25.00	0.550	9064030005500	1.320	#55	152.40	101.60	1.321	9064030013210
0.570	#74	50.80	25.40	0.570	9064030005700	1.400		100.00	70.00	1.400	9064030014000
0.570	#74	76.20	25.40	0.571	9064030005710	1.400		150.00	100.00	1.401	9064030014010
0.600		60.00	30.00	0.600	9064030006000	1.500		100.00	70.00	1.500	9064030015000
0.700		60.00	30.00	0.700	9064030007000	1.500		150.00	100.00	1.501	9064030015010
0.700		80.00	50.00	0.701	9064030007010	1.590	1/16	76.20	50.80	1.590	9064030015900
0.740	#69	50.80	25.40	0.740	9064030007400	1.590	1/16	101.60	76.20	1.591	9064030015910
0.740	#69	76.20	50.80	0.741	9064030007410	1.590	1/16	152.40	101.60	1.592	9064030015920
0.800		60.00	30.00	0.800	9064030008000	1.590	1/16	203.20	101.60	1.593	9064030015930
0.800		80.00	50.00	0.801	9064030008010	1.600		150.00	100.00	1.600	9064030016000
0.800		120.00	60.00	0.802	9064030008020	1.700		150.00	100.00	1.700	9064030017000
1.000		60.00	40.00	1.000	9064030010000	1.780	#50	101.60	76.20	1.780	9064030017800
1.000		80.00	50.00	1.001	9064030010010	1.780	#50	152.40	101.60	1.781	9064030017810
1.000		100.00	70.00	1.002	9064030010020	1.800		100.00	70.00	1.800	9064030018000
1.000		150.00	75.00	1.003	9064030010030	1.800		150.00	100.00	1.801	9064030018010
1.020	#60	76.20	50.80	1.020	9064030010200	1.900		150.00	100.00	1.900	9064030019000
1.020	#60	152.40	63.50	1.021	9064030010210	2.000		100.00	70.00	2.000	9064030020000
1.090	#57	76.20	50.80	1.090	9064030010900	2.000		150.00	100.00	2.001	9064030020010
1.090	#57	101.60	76.20	1.091	9064030010910	2.100		100.00	70.00	2.100	9064030021000
1.090	#57	152.40	76.20	1.092	9064030010920	2.380	3/32	114.30	76.20	2.380	9064030023800
1.190	3/64	76.20	50.80	1.190	9064030011900	2.380	3/32	152.40	101.60	2.381	9064030023810
1.190	3/64	101.60	76.20	1.191	9064030011910	2.380	3/32	203.20	101.60	2.382	9064030023820
1.190	3/64	152.40	101.60	1.192	9064030011920	2.380	3/32	203.20	152.40	2.383	9064030023830
1.200		100.00	70.00	1.200	9064030012000	2.400		100.00	70.00	2.400	9064030024000
1.200		150.00	100.00	1.201	9064030012010	2.400		205.00	150.00	2.401	9064030024010
1.300		100.00	70.00	1.300	9064030013000	2.600		150.00	100.00	2.600	9064030026000
1.300		150.00	100.00	1.301	9064030013010						

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