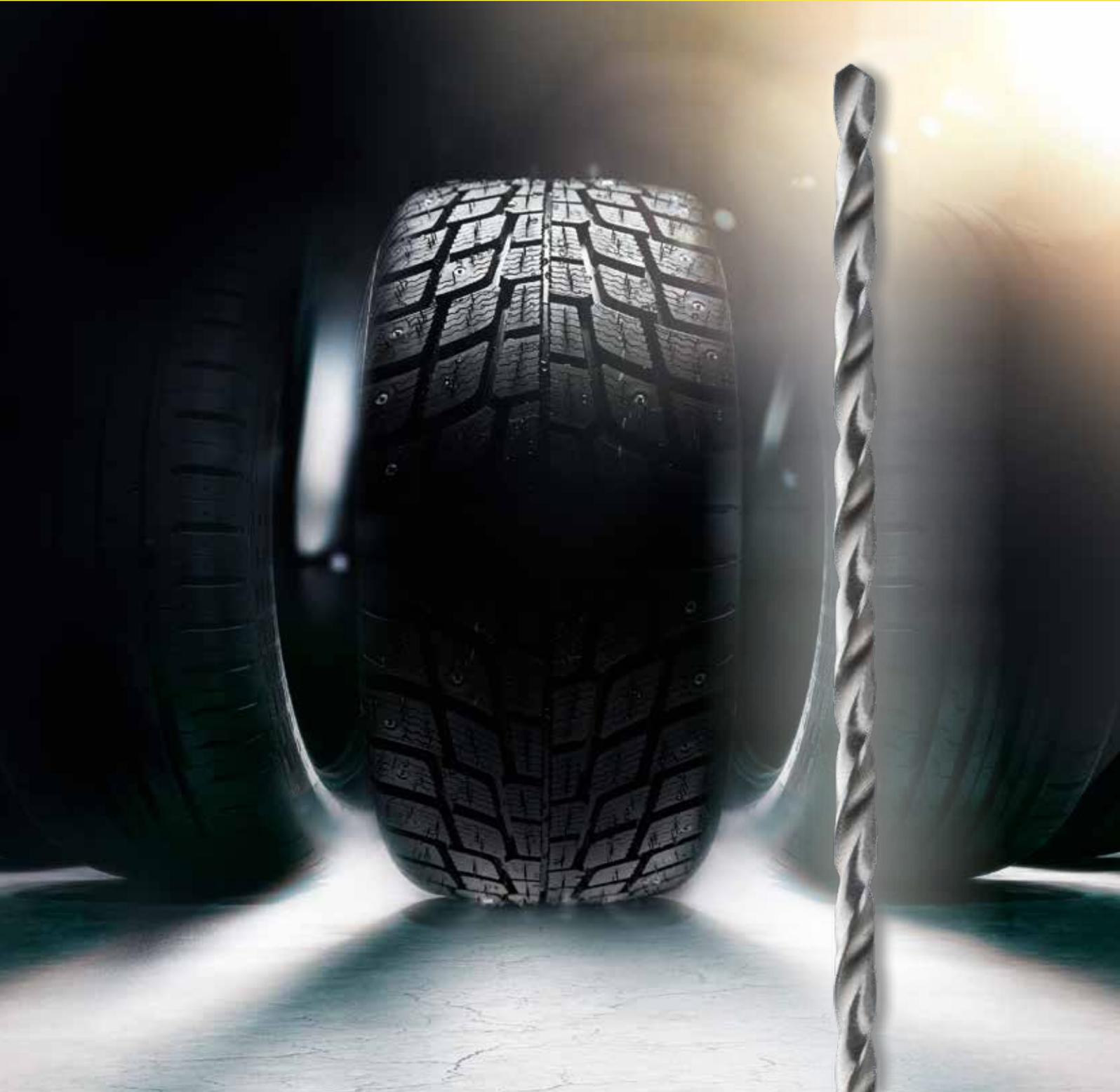


# GÜHRING



## **HSS twist drills**

for cleaning out and drilling holes in tyre tread moulds

GÜHRING – YOUR WORLDWIDE PARTNER



The final step in tyre production is vulcanisation where blanks are pressed into moulds or mould segments under heat and pressure and the tyre receives its final tread. If air is trapped between the blank and the mould, 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 mould. We have developed an extra long drill for use on tyre moulding tools: The combination of tough HSS-M2 cutting material and specially shaped flutes enables reliable cleaning and drilling of vent holes in steel and aluminium moulding 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



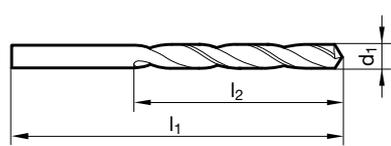


Extra length twist drills



- P** ○ • relieved cone • common diameters available in different lengths
- M** ○
- K** ○
- N** ● • for cleaning out and drilling vent holes in industrial mould making, especially in tyre manufacturing
- S** ○
- H** ○

Tool material	<b>HSS</b>
Surface	○
Cutting direction	Ⓜ



Article no. **6403**

d1		l1	l2	Code no.
mm	inch	mm	mm	
0.500		50.00	25.00	0.500
0.550		50.00	25.00	0.550
0.570	#74	50.80	25.40	0.570
0.570	#74	76.20	25.40	0.571
0.600		60.00	30.00	0.600
0.700		60.00	30.00	0.700
0.700		80.00	50.00	0.701
0.740	#69	50.80	25.40	0.740
0.740	#69	76.20	50.80	0.741
0.800		60.00	30.00	0.800
0.800		80.00	50.00	0.801
0.800		120.00	60.00	0.802
1.000		60.00	40.00	1.000
1.000		80.00	50.00	1.001
1.000		100.00	70.00	1.002
1.000		150.00	75.00	1.003
1.020	#60	76.20	50.80	1.020
1.020	#60	152.40	63.50	1.021
1.090	#57	76.20	50.80	1.090
1.090	#57	101.60	76.20	1.091
1.090	#57	152.40	76.20	1.092
1.190	3/64	76.20	50.80	1.190
1.190	3/64	101.60	76.20	1.191
1.190	3/64	152.40	101.60	1.192
1.200		100.00	70.00	1.200
1.200		150.00	100.00	1.201
1.300		100.00	70.00	1.300
1.300		150.00	100.00	1.301
1.320	#55	101.60	76.20	1.320
1.320	#55	152.40	101.60	1.321

d1		l1	l2	Code no.
mm	inch	mm	mm	
1.400		100.00	70.00	1.400
1.400		150.00	100.00	1.401
1.500		100.00	70.00	1.500
1.500		150.00	100.00	1.501
1.590	1/16	76.20	50.80	1.590
1.590	1/16	101.60	76.20	1.591
1.590	1/16	152.40	101.60	1.592
1.590	1/16	203.20	101.60	1.593
1.600		150.00	100.00	1.600
1.700		150.00	100.00	1.700
1.780	#50	101.60	76.20	1.780
1.780	#50	152.40	101.60	1.781
1.800		100.00	70.00	1.800
1.800		150.00	100.00	1.801
1.900		150.00	100.00	1.900
2.000		100.00	70.00	2.000
2.000		150.00	100.00	2.001
2.100		100.00	70.00	2.100
2.380	3/32	114.30	76.20	2.380
2.380	3/32	152.40	101.60	2.381
2.380	3/32	203.20	101.60	2.382
2.380	3/32	203.20	152.40	2.383
2.400		100.00	70.00	2.400
2.400		205.00	150.00	2.401
2.600		150.00	100.00	2.600

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