

GUHRING



GROOVING SYSTEMS

EXPANDED OFFERING:

NEW 2mm width

Part-off holders and inserts

SYSTEM
222

INNOVATION

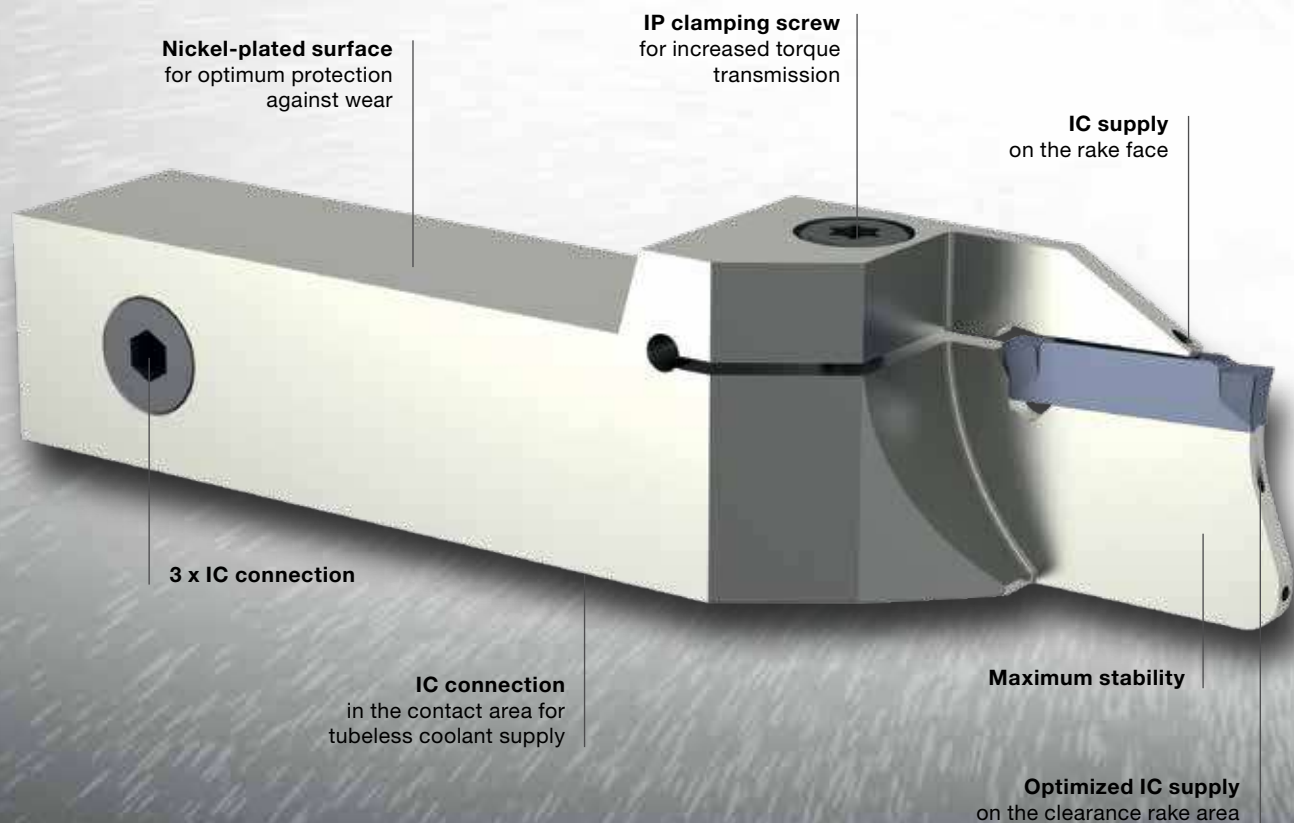
NEW SYSTEM

2 CUTTING EDGES | 22 MM LENGTH | FOR GROOVING AND PARTING-OFF

With System 222, Guhring continues to add to its range of turning and grooving tools. The inserts are pressed to size, and utilize chip breakers designed for steel, stainless steel and cast iron applications. We also offer an extensive range of tool holders with and without internal cooling.

TOOL HOLDER,

WITH AND WITHOUT INTERNAL COOLANT SUPPLY

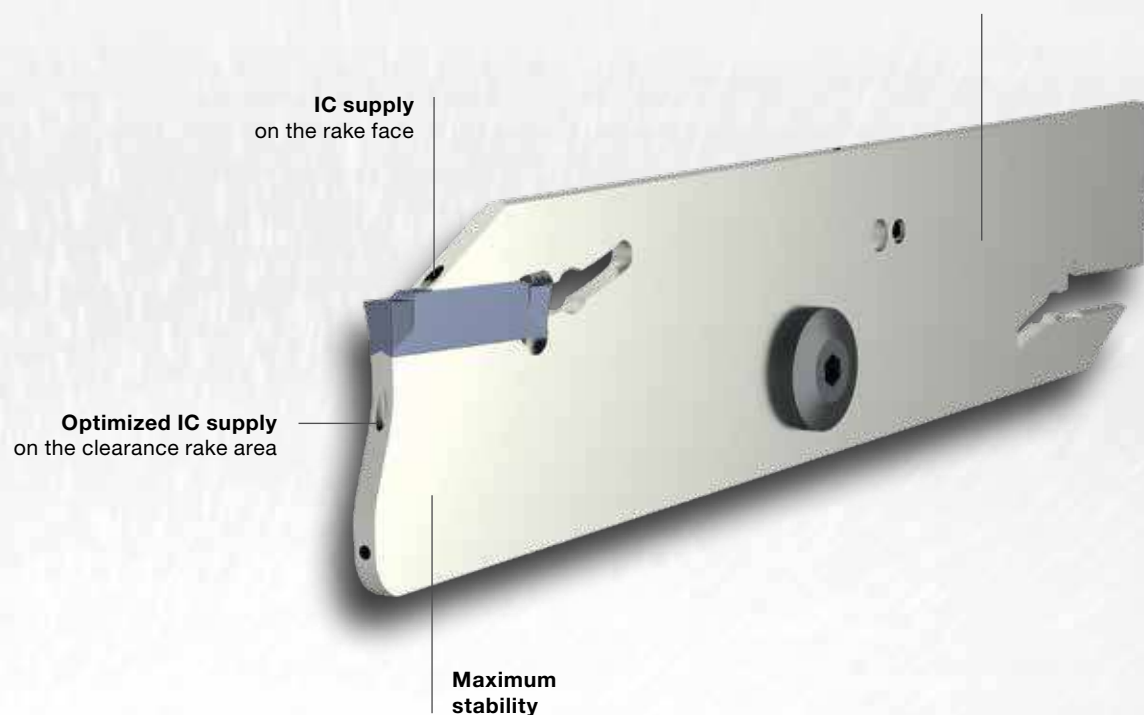


SYSTEM
222

GUHRING

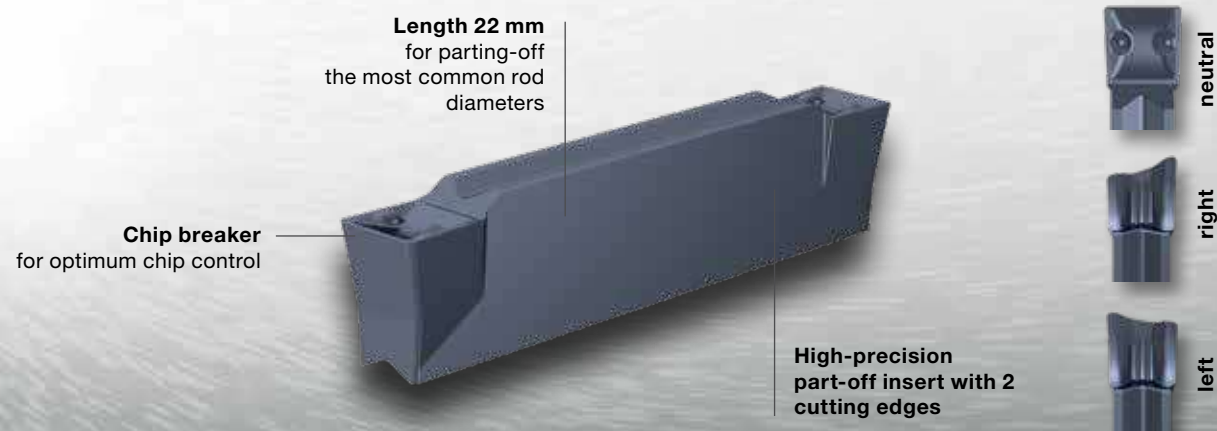
PARTING BLADE,

WITH AND WITHOUT INTERNAL COOLANT SUPPLY



INDEXABLE INSERT,

VERSION NEUTRAL, RIGHT, LEFT

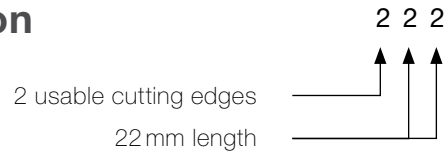


NEW SYSTEM

2 cutting edges | 22 mm length | for grooving and parting-off

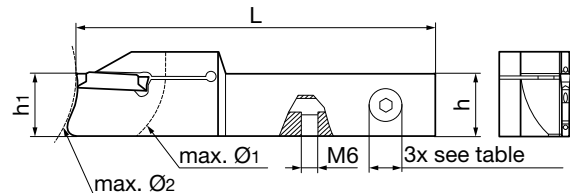
Explanation of the item description

System description

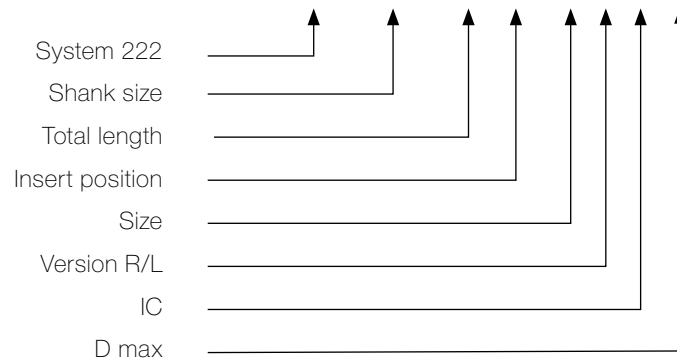


Series description

Tool holder

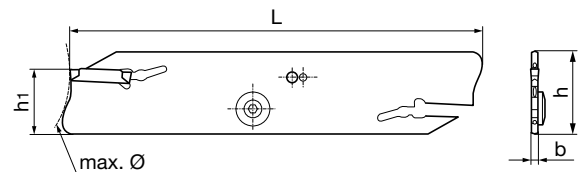


Tool description: Example: GH222.2020.109.00.03.R.IK.52

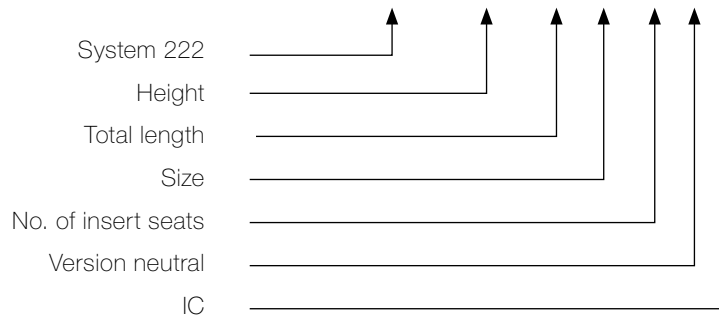


Series description

Parting blade



Tool description: Example: GS222.0032.147.03.02.N.IK



When ordering please always state the
Series and the Code No. i.e.:
Item GZ222.0300.020.PM.01.R.08, FIREX coated = **26602 22.030**

Ordering example

Indexable inserts for parting-off



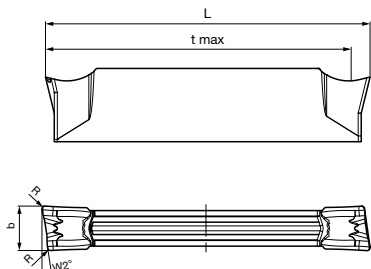
Indexable inserts for parting-off



- with chip breaker

for tool holders type GH222/GS222 see from page 6

Cutting data page 14



Right hand version shown
Left hand version mirror image



Series **26602**
Version right

Series

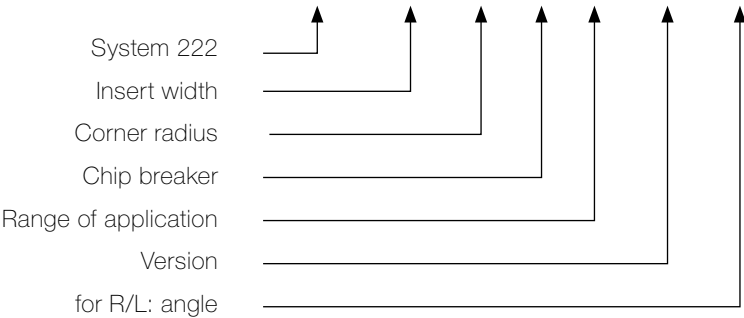
Code no.	Description	t max	b ±0.025	L ±0.1	R	W2
		mm	mm	mm	mm	°
22.0301	GZ222.0300.020.PM.01.R.08	21.00	3.00	22.00	0.20	8

Code no.

Series description Indexable insert



Tool description: Example: GZ222.0300.020.PM.01.N/R/L.08

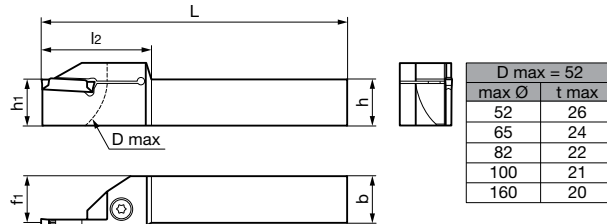


**Square shank holders straight, external machining, without IC**

- **t_{max} 21mm (max grooving depth before 2nd cutting edge engages)**
- without internal coolant supply
- includes Torx-Plus wrench

Type GH222

for indexable inserts type 222 see pages 12-15



Right hand version shown
Left hand version mirror image

Series **26100**

Version right

Code no.	Description	h	h	b	b	L	l2	h1	f1	D max	Size
		mm	inch	mm	inch	mm	mm	mm	mm	mm	
22.110	GH222.1010.125.00.02.R.00.26	10.00		10.00		125.00	30.00	10.00	9.00	26.00	02
22.120	GH222.1212.125.00.02.R.00.26	12.00		12.00		125.00	30.00	12.00	11.00	26.00	02
22.121	GH222.1212.125.00.02.R.00.34	12.00		12.00		125.00	34.00	12.00	11.00	34.00	02
22.130	GH222.0500.500.00.02.R.00.26	12.70	1/2	12.70	1/2	127.00	30.00	12.70	11.70	26.00	02
22.131	GH222.0500.500.00.02.R.00.34	12.70	1/2	12.70	1/2	127.00	34.00	12.70	11.70	34.00	02
22.140	GH222.0625.500.00.02.R.00.45	15.87	5/8	15.87	5/8	127.00	39.50	15.87	14.87	45.00	02
22.150	GH222.1616.125.00.02.R.00.45	16.00		16.00		125.00	39.50	16.00	15.00	45.00	02
22.160	GH222.0750.500.00.02.R.00.45	19.05	3/4	19.05	3/4	127.00	39.00	19.05	19.05	45.00	02
22.170	GH222.2020.125.00.02.R.00.45	20.00		20.00		125.00	39.00	20.00	20.00	45.00	02
22.020	GH222.1212.125.00.03.R.00.34	12.00		12.00		125.00	34.00	12.00	10.50	34.00	03
22.030	GH222.0500.500.00.03.R.00.34	12.70	1/2	12.70	1/2	127.00	34.00	12.70	11.20	34.00	03
22.040	GH222.0625.500.00.03.R.00.45	15.87	5/8	15.87	5/8	127.00	39.50	15.87	14.37	45.00	03
22.050	GH222.1616.125.00.03.R.00.45	16.00		16.00		125.00	39.50	16.00	14.50	45.00	03
22.060	GH222.0750.500.00.03.R.00.52	19.05	3/4	19.05	3/4	127.00	45.00	19.05	19.05	52.00	03
22.070	GH222.2020.125.00.03.R.00.52	20.00		20.00		125.00	45.00	20.00	20.00	52.00	03
22.080	GH222.2525.150.00.03.R.00.52	25.00		25.00		150.00	45.00	25.00	25.00	52.00	03
22.090	GH222.1000.600.00.03.R.00.52	25.40	1.0	25.40	1.0	152.40	45.00	25.40	25.40	52.00	03

Spare parts

Series	Clamping screw	Tightening torque	Description
25906		Nm	
4.000	M4x15.5x15IP	3.5	GH222.1212....; GH222.0500....; GH222.0625....; GH222.1616....
Series	Clamping screw	Torque Nm	Description
25907			
5.000	M5x18x25IP	6	GH222.0750....; GH222.2020....; GH222.2525....; GH222.1000....
Series	Torx-Plus wrench		
25904			
Code 15.001	T15IP		
Series	Torx-Plus wrench		
25922			
Code 15.000	T25IP		

Series **26101**

Version left

Code no.	Description	h	h	b	b	L	l2	h1	f1	D max	Size
		mm	inch	mm	inch	mm	mm	mm	mm	mm	
22.110	GH222.1010.125.00.02.L.00.26	10.00		10.00		125.00	30.00	10.00	9.00	26.00	02
22.120	GH222.1212.125.00.02.L.00.26	12.00		12.00		125.00	30.00	12.00	11.00	26.00	02
22.121	GH222.1212.125.00.02.L.00.34	12.00		12.00		125.00	34.00	12.00	11.00	34.00	02
22.130	GH222.0500.500.00.02.L.00.26	12.70	1/2	12.70	1/2	127.00	30.00	12.70	11.70	26.00	02
22.131	GH222.0500.500.00.02.L.00.34	12.70	1/2	12.70	1/2	127.00	34.00	12.70	11.70	34.00	02
22.140	GH222.0625.500.00.02.L.00.45	15.87	5/8	15.87	5/8	127.00	39.50	15.87	14.87	45.00	02
22.150	GH222.1616.125.00.02.L.00.45	16.00		16.00		125.00	39.50	16.00	15.00	45.00	02
22.160	GH222.0750.500.00.02.L.00.45	19.05	3/4	19.05	3/4	127.00	39.00	19.05	19.05	45.00	02
22.170	GH222.2020.125.00.02.L.00.45	20.00		20.00		125.00	39.00	20.00	20.00	45.00	02
22.020	GH222.1212.125.00.03.L.00.34	12.00		12.00		125.00	34.00	12.00	10.50	34.00	03
22.030	GH222.0500.500.00.03.L.00.34	12.70	1/2	12.70	1/2	127.00	34.00	12.70	11.20	34.00	03
22.040	GH222.0625.500.00.03.L.00.45	15.87	5/8	15.87	5/8	127.00	39.50	15.87	14.37	45.00	03
22.050	GH222.1616.125.00.03.L.00.45	16.00		16.00		125.00	39.50	16.00	14.50	45.00	03
22.060	GH222.0750.500.00.03.L.00.52	19.05	3/4	19.05	3/4	127.00	45.00	19.05	19.05	52.00	03
22.070	GH222.2020.125.00.03.L.00.52	20.00		20.00		125.00	45.00	20.00	20.00	52.00	03
22.080	GH222.2525.150.00.03.L.00.52	25.00		25.00		150.00	45.00	25.00	25.00	52.00	03
22.090	GH222.1000.600.00.03.L.00.52	25.40	1.0	25.40	1.0	152.40	45.00	25.40	25.40	52.00	03

Spare parts

Series	Clamping screw	Tightening torque	Description
25906		Nm	
4.000	M4x15.5x15IP	3.5	GH222.1212....; GH222.0500....; GH222.0625....; GH222.1616....
Series	Clamping screw	Torque Nm	Description
25907			
5.000	M5x18x25IP	6	GH222.0750....; GH222.2020....; GH222.2525....; GH222.1000....
Series	Torx-Plus wrench		
25904			
Code 15.001	T15IP		
Series	Torx-Plus wrench		
25922			
Code 15.000	T25IP		

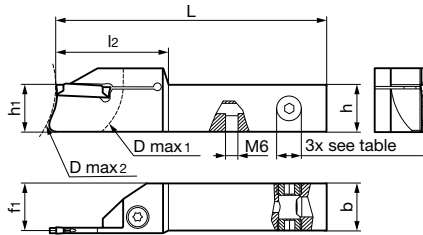


Square shank holders straight, external machining, with IC

- **tmax 21mm (max grooving depth before 2nd cutting edge engages)**
- with internal coolant supply from above and below
- TL (tubeless): tubeless coolant supply from location face from shank size 19.05x19.05
- includes Torx-Plus wrench

Type GH222

for indexable inserts type 222 see pages 12-15



□	●
12/12	M8x1
12,7/12,7	M8x1
15,87/15,87	G1/8
16/16	G1/8
19,05/19,05	G1/8
20/20	G1/8
25/25	G1/8
25,4/25,4	G1/8

D max 1 = 52	
max Ø	t max
52	26
65	24
82	22
100	21
120	20



Right hand version shown
Left hand version mirror image

Series **26102**

Version right

Code no.	Description	h	h	b	b	L	l2	h1	f1	D max1	D max2	Size
		mm	inch	mm	inch	mm	mm	mm	mm	mm	mm	
22.110	GH222.1010.125.00.02.R.IK.26	10.00		10.00		125.00	30.00	10.00	9.00	26.00	65.00	02
22.120	GH222.1212.125.00.02.R.IK.26	12.00		12.00		125.00	30.00	12.00	11.00	26.00	65.00	02
22.121	GH222.1212.125.00.02.R.IK.34	12.00		12.00		125.00	34.00	12.00	11.00	34.00	65.00	02
22.130	GH222.0500.500.00.02.R.IK.26	12.70	1/2	12.70	1/2	127.00	30.00	12.70	11.70	26.00	65.00	02
22.131	GH222.0500.500.00.02.R.IK.34	12.70	1/2	12.70	1/2	127.00	34.00	12.70	11.70	34.00	65.00	02
22.140	GH222.0625.500.00.02.R.IK.45	15.87	5/8	15.87	5/8	127.00	39.50	15.87	14.87	45.00	82.00	02
22.150	GH222.1616.125.00.02.R.IK.45	16.00		16.00		125.00	39.50	16.00	15.00	45.00	82.00	02
22.160	GH222.0750.404.00.02.R.IK.45	19.05	3/4	19.05	3/4	127.00	39.00	19.05	19.05	45.00	82.00	02
22.170	GH222.2020.103.00.02.R.IK.45	20.00		20.00		102.50	39.00	20.00	20.00	45.00	82.00	02
22.020	GH222.1212.125.00.03.R.IK.34	12.00		12.00		125.00	34.00	12.00	10.50	34.00	65.00	03
22.030	GH222.0500.500.00.03.R.IK.34	12.70	1/2	12.70	1/2	127.00	34.00	12.70	11.20	34.00	65.00	03
22.040	GH222.0625.500.00.03.R.IK.45	15.87	5/8	15.87	5/8	127.00	39.50	15.87	14.37	45.00	82.00	03
22.050	GH222.1616.125.00.03.R.IK.45	16.00		16.00		125.00	39.50	16.00	14.50	45.00	82.00	03
22.060	GH222.0750.427.00.03.R.IK.52	19.05	3/4	19.05	3/4	108.50	45.00	19.05	19.05	52.00	82.00	03
22.070	GH222.2020.109.00.03.R.IK.52	20.00		20.00		109.00	45.00	20.00	20.00	52.00	82.00	03
22.080	GH222.2525.120.00.03.R.IK.52	25.00		25.00		120.50	45.00	25.00	25.00	52.00	120.00	03
22.090	GH222.1000.474.00.03.R.IK.52	25.40	1.0	25.40	1.0	120.50	45.00	25.40	25.40	52.00	120.00	03

Spare parts

Series	Clamping screw	Tightening torque	Description
25906		Nm	
4.000	M4x15.5x15IP	3.5	GH222.1212....; GH222.0500....; GH222.0625....; GH222.1616....
Series	Clamping screw	Torque Nm	Description
25907			
5.000	M5x18x25IP	6	GH222.0750....; GH222.2020....; GH222.2525....; GH222.1000....
Series	Torx-Plus wrench		
25904			
Code 15.001	T15IP		
Series	Torx-Plus wrench		
25922			
Code 15.000	T25IP		

Series **26103**

Version left

Code no.	Description	h	h	b	b	L	h1	f1	l2	D max1	D max2	Size
		mm	inch	mm	inch	mm	mm	mm	mm	mm	mm	
22.110	GH222.1010.125.00.02.L.IK.26	10.00		10.00		125.00	10.00	9.00	30.00	26.00	65.00	02
22.120	GH222.1212.125.00.02.L.IK.26	12.00		12.00		125.00	12.00	11.00	30.00	26.00	65.00	02
22.121	GH222.1212.125.00.02.L.IK.34	12.00		12.00		125.00	12.00	11.00	34.00	34.00	65.00	02
22.130	GH222.0500.500.00.02.L.IK.26	12.70	1/2	12.70	1/2	127.00	12.70	11.70	30.00	26.00	65.00	02
22.131	GH222.0500.500.00.02.L.IK.34	12.70	1/2	12.70	1/2	127.00	12.70	11.70	34.00	34.00	65.00	02
22.140	GH222.0625.500.00.02.L.IK.45	15.87	5/8	15.87	5/8	127.00	15.87	14.87	39.50	45.00	82.00	02
22.150	GH222.1616.125.00.02.L.IK.45	16.00		16.00		125.00	16.00	15.00	39.50	45.00	82.00	02
22.160	GH222.0750.404.00.02.L.IK.45	19.05	3/4	19.05	3/4	127.00	19.05	19.05	39.00	45.00	82.00	02
22.170	GH222.2020.103.00.02.L.IK.45	20.00		20.00		102.50	20.00	20.00	39.00	45.00	82.00	02
22.020	GH222.1212.125.00.03.L.IK.34	12.00		12.00		125.00	12.00	10.50	34.00	34.00	65.00	03
22.030	GH222.0500.500.00.03.L.IK.34	12.70	1/2	12.70	1/2	127.00	12.70	11.20	34.00	34.00	65.00	03
22.040	GH222.0625.500.00.03.L.IK.45	15.87	5/8	15.87	5/8	127.00	15.87	14.37	39.50	45.00	82.00	03
22.050	GH222.1616.125.00.03.L.IK.45	16.00		16.00		125.00	16.00	14.50	39.50	45.00	82.00	03
22.060	GH222.0750.427.00.03.L.IK.52	19.05	3/4	19.05	3/4	108.50	19.05	19.05	45.00	52.00	82.00	03
22.070	GH222.2020.109.00.03.L.IK.52	20.00		20.00		109.00	20.00	20.00	45.00	52.00	82.00	03
22.080	GH222.2525.120.00.03.L.IK.52	25.00		25.00		120.50	25.00	25.00	45.00	52.00	120.00	03
22.090	GH222.1000.474.00.03.L.IK.52	25.40	1.0	25.40	1.0	120.50	25.40	25.40	45.00	52.00	120.00	03

Spare parts

Series	Clamping screw	Tightening torque	Description
25906		Nm	
4.000	M4x15.5x15IP	3.5	GH222.1212.....; GH222.0500.....; GH222.0625.....; GH222.1616.....
Series	Clamping screw	Torque Nm	Description
25907			
5.000	M5x18x25IP	6	GH222.0750.....; GH222.2020.....; GH222.2525.....; GH222.1000.....
Series	Torx-Plus wrench		
25904			
Code 15.001	T15IP		
Series	Torx-Plus wrench		
25922			
Code 15.000	T25IP		

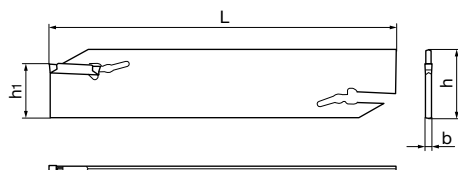


Parting blades, without IC

- without internal coolant supply
- includes mounting key

Type GS222

for indexable inserts type 222 see pages 12-15



Series **26200**

Version neutral

Code no.	Description	t max	b	h	h1	L	Size
		mm	mm	mm	mm	mm	
22.102	GS222.0026.120.02.02.N	35.00	1.55	26.00	21.40	120.00	02
22.103	GS222.0032.150.02.02.N	45.00	1.55	32.00	25.00	150.00	02
22.002	GS222.0026.120.03.02.N	35.00	2.25	26.00	21.40	120.00	03
22.003	GS222.0032.150.03.02.N	45.00	2.25	32.00	25.00	150.00	03

Mounting key

Series **25921**



- Accessory for parting blades GS222



l1	Code no.
mm	
120.00	15.000

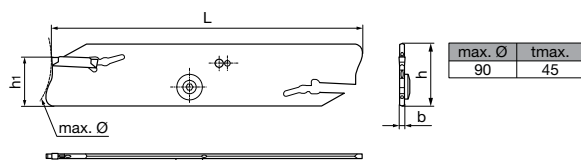


Parting blades, with IC

- with internal coolant supply from above and below
- includes mounting key

Type GS222

for indexable inserts type 222 see pages 12-15

Series **26201**

Version neutral

Code no.	Description	t max	b	h	h1	L	D max	Size
		mm	mm	mm	mm	mm	mm	
22.102	GS222.0026.118.02.02.N.IK	35.00	1.55	26.00	21.40	118.00	70.00	02
22.103	GS222.0032.147.02.02.N.IK	45.00	1.55	32.00	25.00	147.50	90.00	02
22.002	GS222.0026.118.03.02.N.IK	35.00	2.25	26.00	21.40	118.00	70.00	03
22.003	GS222.0032.147.03.02.N.IK	45.00	2.25	32.00	25.00	147.50	90.00	03

Mounting key

Series **25921**

- Accessory for parting blades GS222



l1	Code no.
mm	
120.00	15.000

IC locking screw

Series **25909**

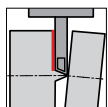
- Accessory for parting blades GS222



Size	d1	l1	Code no.
		mm	
SW 3	M4	4.60	4.000



Indexable inserts for parting-off



- with chip breaker

for tool holders type GH222/GS222 see from page 6

Tool material **Solid carbide**

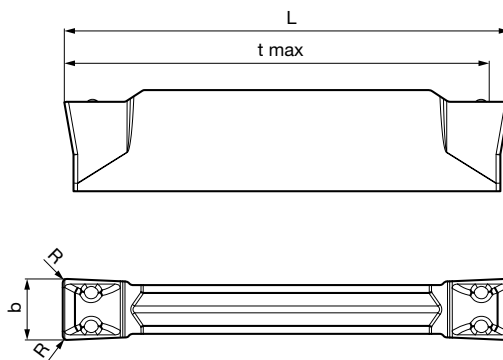
Type GZ222

Surface **F**

FIREX

Cutting data page 16

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



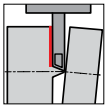
Series **26601**

Version neutral

Code no.	Description	t max	b ±0.025	L ±0.1	R	W2
		mm	mm	mm	mm	°
22.020	GZ222.0200.020.PP.02.N	21.00	2.00	22.00	0.20	0
22.030	GZ222.0300.020.PP.02.N	21.00	3.00	22.00	0.20	0



Indexable inserts for parting-off



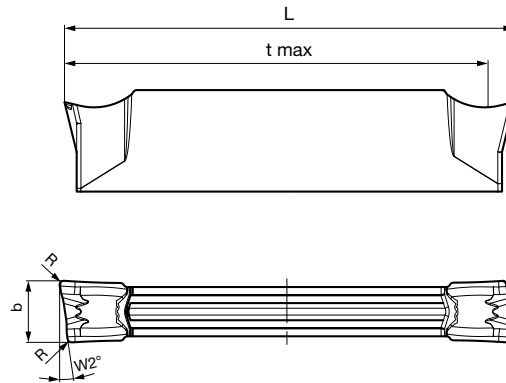
- with chip breaker

for tool holders type GH222/GS222 see from page 6

Tool material	Solid carbide
Type	GZ222
Surface	F
	FIREX

Cutting data page 16

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



Right hand version shown Left hand version mirror image



Series **26602**

Version right

Code no.	Description	t max	b ±0.025	L ±0.1	R	W2
		mm	mm	mm	mm	°
22.030	GZ222.0300.020.PM.01.R.08	21.00	3.00	22.00	0.20	8

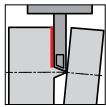
Series **26603**

Version left

Code no.	Description	t max	b ±0.025	L ±0.1	R	W2
		mm	mm	mm	mm	°
22.030	GZ222.0300.020.PM.01.L.08	21.00	3.00	22.00	0.20	8



Indexable inserts for parting-off



- with chip breaker
- single-sided insert

for tool holders type GH222/GS222 see from page 6

Tool material **Solid carbide**

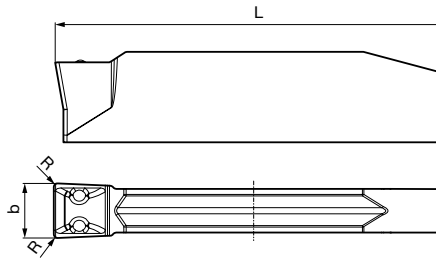
Type GZ122

Surface **F**

FIREX

Cutting data page 16

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



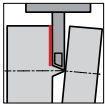
Series **26604**

Version left and right

Code no.	Description	b ±0.02	L ±0.1	R	W2
		mm	mm	mm	°
22.030	GZ122.0300.020.PP.02.N	3.00	21.54	0.20	



Indexable inserts for parting-off



- with chip breaker

for tool holders type GH222/GS222 see from page 6

Tool material **Solid carbide**

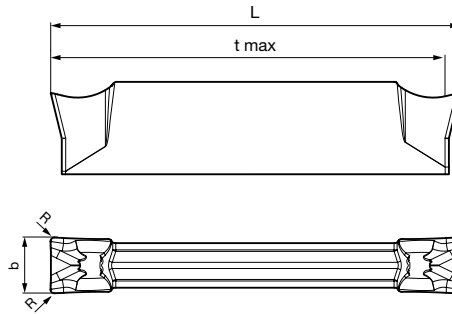
Type GZ222

Surface **a**

nano-A

Cutting data page 16

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



Series **26605**

Version neutral

Code no.	Description	t max	b ±0.025	L ±0.1	R	W2
		mm	mm	mm	mm	°
22.030	GZ222.0300.020.MP.02.N	21.00	3.00	22.00	0.20	0



System 222

	Feed rate f (IPR) ↓ 0.0024 - 0.007		Feed rate f (IPR) ↓ 0.0016 - 0.0039		Feed rate f (IPR) ↓ 0.0015 - 0.0063
Geometry .PP02		Geometry .PM01		Geometry .MP02	

↓ = radial feed direction

ISO	Material		Material examples/ material number	Tensile strength (N/mm ²)	Brinell hard- ness (HB)	Cutting speed SFM (surface feet / min)
P	Carbon steel	C ≤ 0.15 %	11SMn30+C / 1.0715 C15 / 1.0401	500 600	150 180	492 - 722
		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	426 - 590
	Low-alloyed steel (alloy content ≤ 5%)	annealed	16MnCr5 / 1.7131 18CrNi8 / 1.5920	650 650	200 200	394 - 558
		heat-treatable	25CrMoV4 / 1.7218 42CrMo4V / 1.7225	900 1100	270 320	295 - 492
		annealed	X37CrMoV5-1 / 1.2343 X153CrMoV12 / 1.2379	750 850	220 250	426 - 590
		heat-treatable	55NiCrMoV7 / 1.2714	1200	350	230 - 394
	Cast steel	un-alloyed, low-alloyed	GS52 / 1.0552	600	180	426 - 590
		high-alloyed	GX40CrNiSi22-10 / 1.4826	750	220	328 - 459
	M	Stainless steel	martensitic, ferritic, tempered	X14CrMoS17 / 1.4104 X4CrNiMo16-5-1 / 1.4418	800 1000	230 - 525
			austenitic, Ni > 8 %	X5CrNi18-10 / 1.4301 X2CrNiMo17-12-2 / 1.4404	650 850	
		austenitic, ferritic (Duplex)	X2CrNiMoCuN25-6-3 / 1.4507 X2CrNiMoN25-7-4 / 1.4410		250	
K	Cast iron	Grey cast iron	A48-20/30/40/50 B, A159G1800, A159G2500, A159G3000, A159G3500, A159G4000	--	180	230 - 492

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

General machining information

- The use of neutral indexable inserts is always preferable to right-hand or left-hand cutting inserts:
 - better chip control
 - even wear on the cutting edge
 - higher process reliability
 - higher feed rates possible
 - even for parting-off a neutral insert is first choice for reduced edge wear
- Reduce feed rate by approx. 40 % when using right or left-hand indexable inserts.
- Reduce the feed rate by approx. 50 %-60 % when the cutting edge reaches 2-3 mm from center.

General formulas

Cutting speed (SFM)
RPM x Dia. / 3.82 = SFM

Revolutions per minute (RPM)
SFM x 3.82 / Dia. = RPM

Feed rate (IPM)
IPM x RPM = IPM

**Clamping screw**Series **25906**

- Accessory for tool holders GH222



Size	d1	for shank size ☐	Code no.
		mm	
15IP	M4	12/12 – 16/16	4.000

Clamping screwSeries **25907**

- Accessory for tool holders GH222



Size	d1	for shank size ☐	Code no.
		mm	
25IP	M5	19.05/19.05 – 25.4/25.4	5.000

IC locking screw for tubeless coolant supply (TL)Series **25910**

- Accessory for tool holders GH222



Size	d1	l1	Code no.
		mm	
SW 3	M6	6.00	6.000

Set screwsSeries **25905**

- Accessory for tool holders GH222 with IC



Size	d1	l1	Code no.
		mm	
SW 4	G1/8	5.00	5.000

Series **25913**

Size	d1	l1	Code no.
		mm	
SW 4	M8 x 1	5.00	8.000

Torx-Plus wrenchSeries **25904**

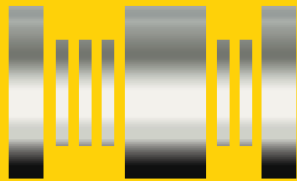
- Accessory for tool holders GH222



Size	l1	Code no.
	mm	
15IP	65.00	15.001

Series **25922**

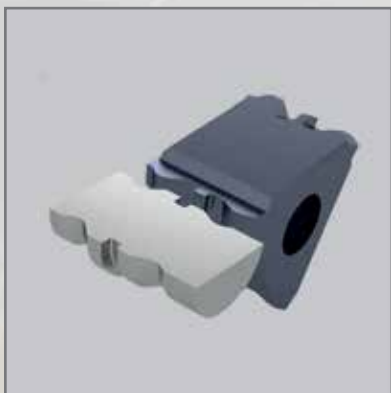
Size	l1	Code no.
	mm	
25IP	80.00	15.000



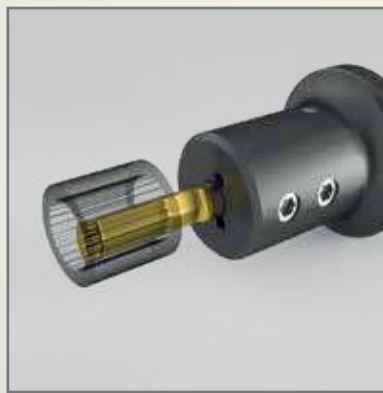
GROOVING SYSTEMS

BY **GUHRING**

GUHRING CAN SOLVE YOUR APPLICATION CHALLENGES WITH SPECIAL GEOMETRIES FOR:



PROFILE FORM INSERT,
EXTERNAL CONTOUR



BROACHING AN
INTERNAL SPLINE,
ROUGH AND
FINISH CUTTER IN
ONE TOOL

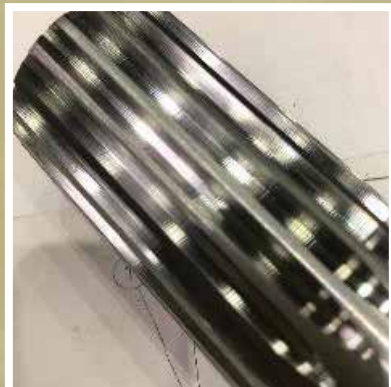


CUSTOMIZED EXTERNAL
GROOVING TOOL



EXTERNAL/
INTERNAL
CIRCULAR
MILLING
OF FORM
RECESSES

CUSTOM SOLUTION:
SPLINE PROFILE GROOVE MILL



Whether required for a small production lot or for continuous production, customer-specific solutions are one of our strengths. Our vertical integration -- from carbide production, in-house coating technology, and in-house development, through to our competent product specialists -- makes our tools incredibly adept at mastering even the most demanding machining tasks. By continuously adding new products to the portfolio, Guhring is truly meeting the expectations of a complete supplier.



AUTOMOTIVE
COMPONENTS



AREOSPACE



MEDICAL IMPLANTS
AND TOOLS



FIREARM COMPONENTS

Case History:

High flow cavity o-ring groove in 6061 aluminum block

Original process:

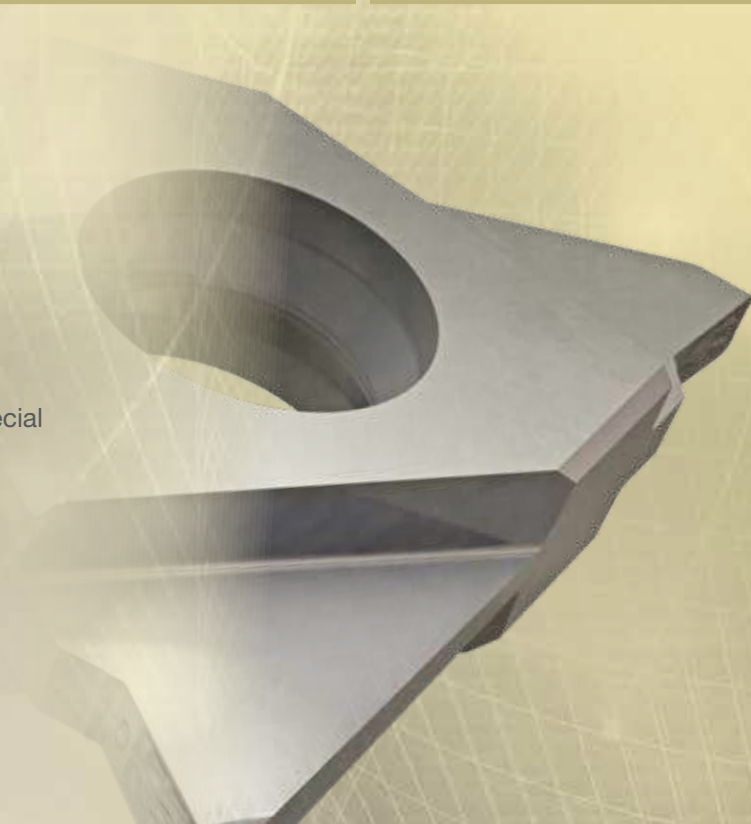
Circular interpolate the groove with 0.187" end mill, then follow with a chamfer tool to edge break inside and outside of groove. **Machine time: 5 minutes 15 seconds.**

Guhring custom solution:

Produce groove and chamfer by plunging with single tool - special-made system 305 milling cutter body with 6 effective special form groove inserts. **Machine time 15 seconds.**

Cost Savings:

At 12,000 parts per year, time savings is 1,000 hours
Total cost savings is **\$34,000 per year!**





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