

# GUHRING



with **SIRIUS®**-coating

- effective wear protection and longer tool life thanks to **SIRIUS®**-coating
- economically efficient and process reliable drilling in stainless steels
- low feed forces and optimal centering thanks to 130° split point

## HSCO-VA-Twist drill

GUHRING – YOUR WORLD-WIDE PARTNER

# SIRIUS

## HSCO-VA-Twist drill with Sirius-coating

- standard range
- Ø 1.00 -13.00 mm

### Flute

Special flute geometry ensures process reliable chip production and chip evacuation especially with the machining of stainless steels.

### 130° split point

Optimal 130° split point:

- minimal feed forces
- accurate spotting without centre punching or centering

### Tool material

5% cobalt-alloyed high speed steel for long tool life and high heat resistance enable the machining of stainless steels at high temperatures.

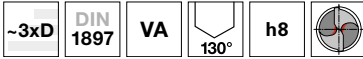


When drilling stainless steels the cutting edges of HSCO-VA twist drills are subjected to extreme stresses. A strong mechanically resistant coating with low friction value prevents damage to the cutting edges. Pre-requisite is a very low chemical interaction with stainless steels.

The tough-hard TiAlN developed coating guarantees a high wear-resistance. The zirconium nitride cover coating significantly improves chip flow as the chemical reaction between coating and workpiece is reduced. Therefore, the SIRIUS® offers optimal features for the machining of stainless steels.

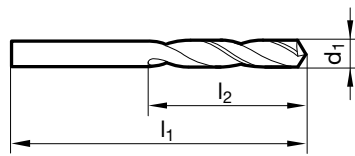


### Stub drills



<b>P</b>	○	Web thinning ≥ 2.360 mm • optimised split point • Co-alloyed HSS steel • increased wear-resistance
<b>M</b>	●	
<b>K</b>	○	
<b>N</b>	○	Stainless-/acid-/heat-resistant austenitic steels (V2A and V4A) • special alloys
<b>S</b>	●	
<b>H</b>		

Tool material	<b>HSCo</b>
Surface finish	<b>S</b>
Cutting direction	<b>R</b>
Discount group	139



Guhring no. **572**

d1	l1	l2	Availability	d1	l1	l2	Availability	d1	l1	l2	Availability
mm	mm	mm		mm	mm	mm		mm	mm	mm	
1.000	26.000	6.000	•	5.100	62.000	26.000	•	9.100	84.000	40.000	•
1.100	28.000	7.000	•	5.200	62.000	26.000	•	9.200	84.000	40.000	•
1.200	30.000	8.000	•	5.300	62.000	26.000	•	9.250	84.000	40.000	•
1.300	30.000	8.000	•	5.400	66.000	28.000	•	9.300	84.000	40.000	•
1.400	32.000	9.000	•	5.500	66.000	28.000	•	9.400	84.000	40.000	•
1.500	32.000	9.000	•	5.550	66.000	28.000	•	9.500	84.000	40.000	•
1.600	34.000	10.000	•	5.600	66.000	28.000	•	9.600	89.000	43.000	•
1.700	34.000	10.000	•	5.700	66.000	28.000	•	9.700	89.000	43.000	•
1.800	36.000	11.000	•	5.800	66.000	28.000	•	9.800	89.000	43.000	•
1.900	36.000	11.000	•	5.900	66.000	28.000	•	9.900	89.000	43.000	•
2.000	38.000	12.000	•	6.000	66.000	28.000	•	10.000	89.000	43.000	•
2.100	38.000	12.000	•	6.100	70.000	31.000	•	10.200	89.000	43.000	•
2.200	40.000	13.000	•	6.200	70.000	31.000	•	10.500	89.000	43.000	•
2.300	40.000	13.000	•	6.300	70.000	31.000	•	11.000	95.000	47.000	•
2.400	43.000	14.000	•	6.400	70.000	31.000	•	11.200	95.000	47.000	•
2.500	43.000	14.000	•	6.500	70.000	31.000	•	11.500	95.000	47.000	•
2.600	43.000	14.000	•	6.600	70.000	31.000	•	11.800	95.000	47.000	•
2.700	46.000	16.000	•	6.700	70.000	31.000	•	12.000	102.000	51.000	•
2.800	46.000	16.000	•	6.800	74.000	34.000	•	12.500	102.000	51.000	•
2.900	46.000	16.000	•	6.900	74.000	34.000	•	13.000	102.000	51.000	•
3.000	46.000	16.000	•	7.000	74.000	34.000	•				
3.100	49.000	18.000	•	7.100	74.000	34.000	•				
3.200	49.000	18.000	•	7.200	74.000	34.000	•				
3.300	49.000	18.000	•	7.300	74.000	34.000	•				
3.400	52.000	20.000	•	7.400	74.000	34.000	•				
3.500	52.000	20.000	•	7.450	74.000	34.000	•				
3.600	52.000	20.000	•	7.500	74.000	34.000	•				
3.700	52.000	20.000	•	7.600	79.000	37.000	•				
3.800	55.000	22.000	•	7.700	79.000	37.000	•				
3.900	55.000	22.000	•	7.800	79.000	37.000	•				
4.000	55.000	22.000	•	7.900	79.000	37.000	•				
4.100	55.000	22.000	•	8.000	79.000	37.000	•				
4.200	55.000	22.000	•	8.100	79.000	37.000	•				
4.300	58.000	24.000	•	8.200	79.000	37.000	•				
4.400	58.000	24.000	•	8.300	79.000	37.000	•				
4.500	58.000	24.000	•	8.400	79.000	37.000	•				
4.600	58.000	24.000	•	8.500	79.000	37.000	•				
4.650	58.000	24.000	•	8.600	84.000	40.000	•				
4.700	58.000	24.000	•	8.700	84.000	40.000	•				
4.800	62.000	26.000	•	8.800	84.000	40.000	•				
4.900	62.000	26.000	•	8.900	84.000	40.000	•				
5.000	62.000	26.000	•	9.000	84.000	40.000	•				

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