

GUHRING

Series 546 - 723 - 724

Material group	Hardness	SFM	Feed Rate - IPR									
			1/16 in. 1.590 mm	1/8 in. 3.170 mm	1/4 in. 6.350 mm	3/8 in. 9.520 mm	1/2 in. 12.700mm	5/8 in. 15.870mm	3/4 in. 19.050mm	1 in. 25.400mm	1 1/4 in. 31.75mm	1 1/2 in. 38.10mm
Common structural steels	≤ 20 HRC	245		0.0031	0.0049	0.0079	0.0079	0.0098	0.0124	0.0157		
	≤ 32 HRC	230		0.0025	0.0039	0.0063	0.0063	0.0079	0.0098	0.0124		
Free-cutting steels	≤ 25 HRC	260		0.0031	0.0049	0.0079	0.0079	0.0098	0.0124	0.0157		
	≤ 32 HRC	230		0.0025	0.0039	0.0063	0.0063	0.0079	0.0098	0.0124		
Unalloyed heat-treatable steels	≤ 20 HRC	260		0.0025	0.0039	0.0063	0.0063	0.0079	0.0098	0.0124		
	≤ 25 HRC	230		0.0025	0.0039	0.0063	0.0063	0.0079	0.0098	0.0124		
	≤ 32 HRC	195		0.0025	0.0039	0.0063	0.0063	0.0079	0.0098	0.0124		
Alloyed heat-treatable steels	≤ 32 HRC	195		0.0025	0.0039	0.0063	0.0063	0.0079	0.0098	0.0124		
	≤ 43 HRC	165		0.0020	0.0031	0.0049	0.0049	0.0063	0.0079	0.0098		
Unalloyed case hardened steels	≤ 25 HRC	260		0.0031	0.0049	0.0079	0.0079	0.0098	0.0124	0.0157		
Alloyed case hardened steels	≤ 32 HRC	195		0.0025	0.0039	0.0063	0.0063	0.0079	0.0098	0.0124		
	≤ 43 HRC	165		0.0020	0.0031	0.0049	0.0049	0.0063	0.0079	0.0098		
Nitriding steels	≤ 32 HRC	165		0.0025	0.0039	0.0063	0.0063	0.0079	0.0098	0.0124		
	≤ 43 HRC	130		0.0020	0.0031	0.0049	0.0049	0.0063	0.0079	0.0098		
Tool steels	≤ 25 HRC	165		0.0020	0.0031	0.0049	0.0049	0.0063	0.0079	0.0098		
	≤ 43 HRC	130		0.0016	0.0025	0.0039	0.0039	0.0049	0.0063	0.0079		
High speed steels	≤ 43 HRC	130		0.0016	0.0025	0.0039	0.0039	0.0049	0.0063	0.0079		
Spring steels	≤ 38 HRC	80		0.0016	0.0025	0.0039	0.0039	0.0049	0.0063	0.0079		
Stainless steels	sulphured austenitic martensitic	≤ 28 HRC	80		0.0025	0.0039	0.0063	0.0063	0.0079	0.0098	0.0124	
		≤ 36 HRC	80		0.0020	0.0031	0.0049	0.0049	0.0063	0.0079	0.0098	
		≤ 46 HRC	80		0.0020	0.0031	0.0049	0.0049	0.0063	0.0079	0.0098	
Hardened steels	≤ 48 HRC	65		0.0020	0.0031	0.0049	0.0049	0.0063	0.0079	0.0098		
	≤ 66 HRC											
Special alloys	≤ 54 HRC	50		0.0016	0.0025	0.0039	0.0039	0.0049	0.0063	0.0079		
Cast iron	≤ 23 HRC	295		0.0025	0.0039	0.0063	0.0063	0.0079	0.0098	0.0124		
	≤ 38 HRC	260		0.0025	0.0039	0.0063	0.0063	0.0079	0.0098	0.0124		
Spheroidal graphite iron and malleable cast iron	≤ 23 HRC	260		0.0025	0.0039	0.0063	0.0063	0.0079	0.0098	0.0124		
	≤ 38 HRC	230		0.0025	0.0039	0.0063	0.0063	0.0079	0.0098	0.0124		
Chilled cast iron	≤ 38 HRC											
Ti and Ti-alloys	≤ 25 HRC	65		0.0020	0.0031	0.0049	0.0049	0.0063	0.0079	0.0098		
	≤ 43 HRC	50		0.0016	0.0025	0.0039	0.0039	0.0049	0.0063	0.0079		
Aluminum and Al-alloys	≤120HB	655		0.0049	0.0079	0.0124	0.0124	0.0157	0.0197	0.0248		
Al wrought alloys	≤200HB	655		0.0049	0.0079	0.0124	0.0124	0.0157	0.0197	0.0248		
Al cast alloys	≤ 10% Si ≤ 24% Si	≤180HB	490		0.0039	0.0063	0.0098	0.0098	0.0124	0.0157	0.0197	
		≤180HB	395		0.0039	0.0063	0.0098	0.0098	0.0124	0.0157	0.0197	
Magnesium alloys	≤120HB	590		0.0031	0.0049	0.0079	0.0079	0.0098	0.0124	0.0157		
Copper	low-alloyed ≤ 80 HB	260		0.0031	0.0049	0.0079	0.0079	0.0098	0.0124	0.0157		
Brass	short-chipping ≤180HB	590		0.0031	0.0049	0.0079	0.0079	0.0098	0.0124	0.0157		
	long-chipping ≤180HB	590		0.0031	0.0049	0.0079	0.0079	0.0098	0.0124	0.0157		
Bronze	short-chipping ≤180HB	395		0.0031	0.0049	0.0079	0.0079	0.0098	0.0124	0.0157		
	≤ 25 HRC	395		0.0031	0.0049	0.0079	0.0079	0.0098	0.0124	0.0157		
Bronze	long-chipping ≤ 25 HRC	230		0.0025	0.0039	0.0063	0.0063	0.0079	0.0098	0.0124		
	≤ 32 HRC	165		0.0020	0.0031	0.0049	0.0049	0.0063	0.0079	0.0098		
Duroplastics	-	130		0.0020	0.0031	0.0049	0.0049	0.0063	0.0079	0.0098		
Thermoplastics	-											

Guhring, Inc. Main Office
P.O. Box 643, Brookfield, WI 53008-0643

Shipping Address
1445 Commerce Avenue
Brookfield, WI 53045
Tel (262) 784-6730 (800) 776-6170
Fax (262) 784-9096

**West Coast Distribution Center and
Reconditioning Facility**
15581 Computer Ln
Huntington Beach, CA 92649

Reconditioning Facility
121 W Dudley Town Rd.
Bloomfield, CT 06002

**Manufacturing and
Reconditioning Facility**
29550 W.K. Smith Rd. Suite B
New Hudson, MI 48165

Guhring Corporation
20 Steckle Place, Unit #14
Kitchener, ON N2E 2C3
Tel (519) 748-9664 (800) 463-5555
Fax (519) 748-2954

Item #400001283