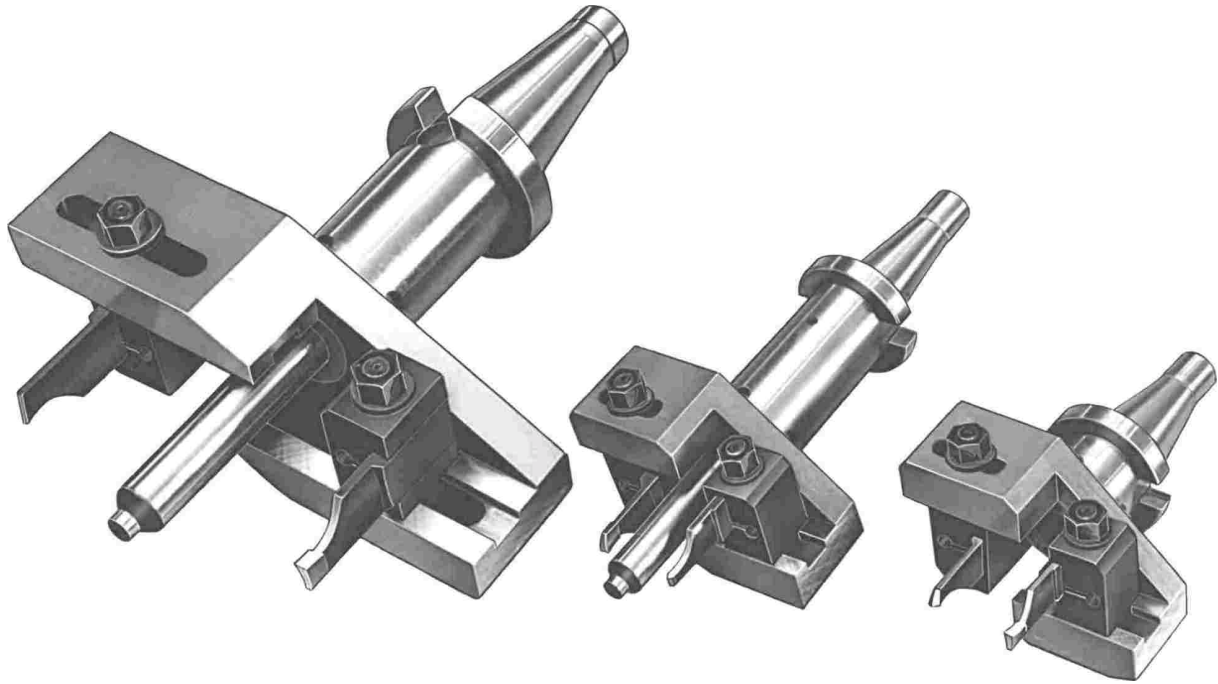


# *GFS - Trepanning Tools*

## **Over 60 years of successful operation**

For trepanning bores and plunge-cutting ring grooves in metals and plastics  
By sharing the cut between two blades (precutting and finishing blades), large plunging depths are possible with optimum chip guidance.



2 versions – 4 sizes – from 40 mm to 300 mm / 1.580'' to 11.810'' , up to 75 mm / 2.950''  
plunging depth from one side

### **Important**

When using the trepanning tool, choose the largest possible shank diameter as this has a direct effect on stability and smooth running.

Each tool is supplied with one set = 2 pairs of blades, consisting of one pair of **inner blades** (for the inner diameter; the steel holder's **clamping vee points INWARDS**) and one pair of **outer blades** (for the outer diameter; the steel holder's **clamping vee points OUTWARDS**).

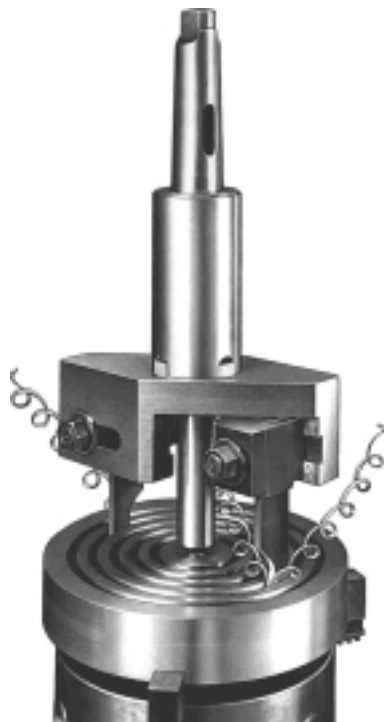
The inner and outer blades each consist of a precutting and a finishing blade. It is advisable to select a blade plunging depth no larger than is absolutely necessary as this maximizes blade stability.

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**Ausführung CN, m. Zentrierzapfen, kompl. m. 2 Paar HSS Messern (HM auf Anfrage)**  
**CN Model with centering pin, including two pair of HSS cutters (HM on request)**  
**Modello CN con perno di centraggio e 2 coppie di coltelli HSS (HM su richiesta)**  
**Exécution CN avec queue de centrage, au complet avec 2 paires de couteaux HSS**

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<b>Größe - Size</b> <b>Misura - Dimension</b>	<b>Bereich - Range</b>	<b>Art.No.</b>
1 / MK 3 (MT 3)	40 - 120 mm Ø	1015103
1 / MK 4 (MT 4)	40 - 120 mm Ø	1015104
1 / MK 5 (MT 5)	40 - 120 mm Ø	1015105
1 / SK 40 (ISO40)	40 - 120 mm Ø	1015240
1 / SK 50 (ISO50)	40 - 120 mm Ø	1015250
2 / MK 4 (MT 4)	50 - 160 mm Ø	1016104
2 / MK 5 (MT 5)	50 - 160 mm Ø	1016105
2 / SK 40 (ISO40)	50 - 160 mm Ø	1016240
2 / SK 50 (ISO50)	50 - 160 mm Ø	1016250
3 / MK 4 (MT 4)	60 - 200 mm Ø	1017104
3 / MK 5 (MT 5)	60 - 200 mm Ø	1017105
3 / MK 6 (MT 6)	60 - 200 mm Ø	1017106
3 / SK 40 (ISO40)	60 - 200 mm Ø	1017240
3 / SK 50 (ISO50)	60 - 200 mm Ø	1017250
4 / MK 4 (MT 4)	80 - 300 mm Ø	1018104
4 / MK 5 (MT 5)	80 - 300 mm Ø	1018105
4 / MK 6 (MT 6)	80 - 300 mm Ø	1018106
4 / SK 40 (ISO40)	80 - 300 mm Ø	1018240
4 / SK 50 (ISO50)	80 - 300 mm Ø	1018250



### **Ausführung CN**

mit federndem bzw versenkbarem Zentrierzapfen für die Verwendung auf Bohrmaschinen

### **CN Model**

with centering pin, for the use on drilling machines.

### **Modello CN**

con perno di centraggio elastico, ossia abbassabile per l'impiego su trapanatrici.

### **Exécution CN**

avec queue de centrage à suspension élastique ou descendante pour utilisation sur perceuses

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**Ausführung DN, m. Zentrierbohrer, kompl. m. 2 Paar HSS Messern (HM auf Anfrage)**  
**DN Model with center drill, including two pair of HSS cutters (HM on request)**  
**Modello DN con punta da centri e 2 coppie di coltelli HSS (HM su richiesta) Exécution**  
**DN avec foret de centrage, au complet avec 2 paires de couteaux HSS**

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<b>Größe - Size</b> <b>Misura - Dimension</b>	<b>Bereich - Range</b>	<b>Art.No.</b>
1 / MK 3 (MT 3)	40 - 120 mm Ø	1025103
1 / MK 4 (MT 4)	40 - 120 mm Ø	1025104
1 / MK 5 (MT 5)	40 - 120 mm Ø	1025105
1 / SK 40 (ISO 40)	40 - 120 mm Ø	1025240
1 / SK 50 (ISO 50)	40 - 120 mm Ø	1025250
1 / Weldon 32	40 - 120 mm Ø	1025332
1 / Weldon 40	40 - 120 mm Ø	1025340
2 / MK 4 (MT 4)	50 - 160 mm Ø	1026104
2 / MK 5 (MT 5)	50 - 160 mm Ø	1026105
2 / SK 40 (ISO 40)	50 - 160 mm Ø	1026240
2 / SK 50 (ISO 50)	50 - 160 mm Ø	1026250
2 / Weldon 40	50 - 160 mm Ø	1026340
3 / MK 4 (MT 4)	60 - 200 mm Ø	1027104
3 / MK 5 (MT 5)	60 - 200 mm Ø	1027105
3 / MK 6 (MT 6)	60 - 200 mm Ø	1027106
3 / SK 40 (ISO 40)	60 - 200 mm Ø	1027240
3 / SK 50 (ISO 50)	60 - 200 mm Ø	1027250
4 / MK 4 (MT 4)	80 - 300 mm Ø	1028104
4 / MK 5 (MT 5)	80 - 300 mm Ø	1028105
4 / MK 6 (MT 6)	80 - 300 mm Ø	1028106
4 / SK 40 (ISO 40)	80 - 300 mm Ø	1028240
4 / SK 50 (ISO 50)	80 - 300 mm Ø	1028250



**Ausführung DN**

mit Zentrierbohrer oder ohne Zentrierung (zum Einstechen von Ringnuten). Zum Einsatz auf Drehmaschinen, Bohrwerken, CNC-Maschinen.

**DN Model**

with center drill or without centering (for plunge-cutting ring grooves). For use on centre Lathes, Milling Machines and CNC Machines.

**Modello DN**

con punta da centri o senza centratura (per l'incisione di scanalature anulari). Per l'impiego su macchine tornitrici, alesatrici, macchine a controllo numerico.

**Exécution DN**

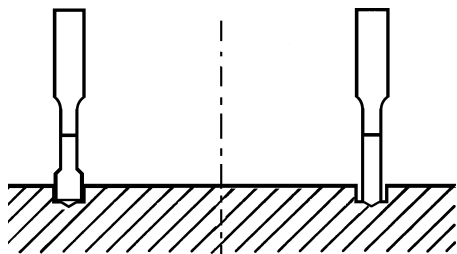
avec foret de centrage ou sans centrage (pour réalisation de rainures annulaires), à utiliser sur tours, aléseuses, machines CNC.

**Messer Gr. 1 - Blades size 1 - Coltelli gr. 1 - Couteaux Dim. 1**

Type		Ø Bereich Ø Range Ø di foratura Ø de découpe	Stechtiefe Cutting depth Profondità di passata Profondeur de percement	Art.No.
Innenmesser	HSS	40-88 mm	20 mm	2015120
Inner cutters	HSS	40-88 mm	30 mm	2015130
Coltelli interni	HSS	40-88 mm	40 mm	2015140
Couteaux intérieur	HM	40-88 mm	20 mm	2015122
	HM	40-88 mm	40 mm	2015142
Außenmesser	HSS	88-120 mm	20 mm	2015220
Outer cutters	HSS	88-120 mm	30 mm	2015230
Coltelli esterni	HSS	88-120 mm	40 mm	2015240
Couteaux extérieur	HM	88-120 mm	20 mm	2015222
	HM	88-120 mm	40 mm	2015242

**Messer Gr. 2 - Blades size 2 - Coltelli gr. 2 - Couteaux Dim. 2**

Type		Ø Bereich Ø Range Ø di foratura Ø de découpe	Stechtiefe Cutting depth Profondità di passata Profondeur de percement	Art.No.
Innenmesser	HSS	50-105 mm	20 mm	2016120
Inner cutters	HSS	50-105 mm	30 mm	2016130
Coltelli interni	HSS	50-105 mm	50 mm	2016150
Couteaux intérieur	HM	50-105 mm	20 mm	2016122
	HM	50-105 mm	40 mm	2016142
Außenmesser	HSS	105-160 mm	20 mm	2016220
Outer cutters	HSS	105-160 mm	30 mm	2016230
Coltelli esterni	HSS	105-160 mm	50 mm	2016250
Couteaux extérieur	HM	105-160 mm	20 mm	2016222
	HM	105-160 mm	40 mm	2016242



Die Messer werden immer paarweise geliefert, d.h. je ein Vorschneider und ein Fertigschneider bilden eine Verpackungseinheit.

The cutters are always delivered as a pair, one pre-cutter and one finisher are a packing unit.

I coltelli vengono forniti sempre a coppia, ossia un'unità confezionata comprende rispettivamente un maschio sbozzatore e un maschio rifinitore.

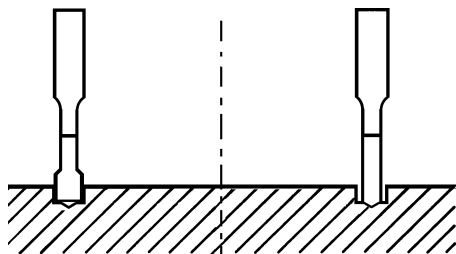
Les couteaux sont toujours livrés par paire: un couteau ébaucheur et un couteau de finition constituent une unité de conditionnement.

**Messer Gr. 3 - Blades size 3 - Coltelli gr. 3 - Couteaux gr. 3**

Type		Ø Bereich Ø Range Ø di foratura Ø de découpe	Stechtiefe Cutting depth Profondità di passata Profondeur de perçement	Art.No.
Innenmesser	HSS	60-125 mm	40 mm	2017140
Inner cutters	HSS	60-125 mm	55 mm	2017155
Coltelli interni	HSS	60-125 mm	70 mm	2017170
Couteaux intérieur	HM	60-125 mm	20 mm	2017122
	HM	60-125 mm	40 mm	2017142
Außenmesser	HSS	125-200 mm	40 mm	2017240
Outer cutters	HSS	125-200 mm	55 mm	2017255
Coltelli esterni	HSS	125-200 mm	70 mm	2017270
Couteaux extérieur	HM	125-200 mm	20 mm	2017222
	HM	125-200 mm	40 mm	2017242

**Messer Gr. 4 - Blades size 4 - Coltelli gr. 4 - Couteaux gr. 4**

Type		Ø Bereich Ø Range Ø di foratura Ø de découpe	Stechtiefe Cutting depth Profondità di passata Profondeur de perçement	Art.No.
Innenmesser	HSS	80-125 mm	40 mm	2017140
Inner cutters	HSS	80-125 mm	55 mm	2017155
Coltelli interni	HSS	80-125 mm	75 mm	2017170
Couteaux intérieur	HM	80-125 mm	20 mm	2017122
	HM	80-125 mm	40 mm	2017142
Außenmesser	HSS	125-300 mm	40 mm	2017240
Outer cutters	HSS	125-300 mm	55 mm	2017255
Coltelli esterni	HSS	125-300 mm	75 mm	2017270
Couteaux extérieur	HM	125-300 mm	20 mm	2017222
	HM	125-300 mm	40 mm	2017242



Die Messer werden immer paarweise geliefert, d.h. je ein Vorschneider und ein Fertigschneider bilden eine Verpackungseinheit.

The cutters are always delivered as a pair, one pre-cutter and one finisher are a packing unit.

I coltelli vengono forniti sempre a coppia, ossia un'unità confezionata comprende rispettivamente un maschio sbozzatore e un maschio rifinitore.

Les couteaux sont toujours livrés par paire: un couteau ébaucheur et un couteau de finition constituent une unité de conditionnement.