

Step drills

Tool illustration				Tool material	Guhring no.
Standard	Type	Surface	Cutting direction	Diameter range	

Straight shank subland drills

				HSS	538
DIN 8376	N	●	rh	6,000 - 18,000	
				Solid carbide	738
Guhring std.	N	○	rh	6,000 - 18,000	
				HSS	514
Guhring std.	N	●	rh	5,900 - 17,500	
				HSS	540
DIN 8378	N	●	rh	3,400 - 13,500	
				Solid carbide	739
Guhring std.	N	○	rh	4,500 - 11,000	

Taper shank subland drills

				HSS	570
DIN 8375	N	●	rh	12,000 - 23,000	
				HSS	537
Guhring std.	N	●	rh	11,000 - 29,000	
				HSS	637
Guhring std.	N	●	rh	11,500 - 30,000	
				HSS	639
Guhring std.	N	●	rh	10,000 - 26,000	
				HSS	539
DIN 8377	N	●	rh	10,000 - 33,000	
				Carbide	741
Guhring std.	N	○	rh	18,000 - 18,000	
				HSS	520
Guhring std.	N	●	rh	9,400 - 33,000	
				HSS	541
DIN 8379	N	●	rh	9,000 - 22,000	

Center drills

Tool illustration				Tool material	Guhring no.
Standard	Form	Surface	Cutting direction	Diameter range	

Center drills without flat

				HSS	594
ASA	A	○	rh	1,190 - 7,940	
				HSS	595
ASA	B	○	rh	1,190 - 6,350	
				HSS	292
B.S. 328	A	○	rh	1,190 - 7,940	
				HSS	294
B.S. 328	A	○	lh	1,190 - 7,940	
				HSS	581
DIN 333	A	○	rh	0,500 - 12,500	
				HSS	582
DIN 333	A	○	lh	0,500 - 12,500	
				HSS	583
DIN 333	R	○	rh	0,500 - 12,500	
				HSS	584
DIN 333	R	○	lh	0,800 - 5,000	
				HSS	613
DIN 333	A	●S	rh	0,500 - 8,000	
				HSS	614
DIN 333	R	●S	rh	0,800 - 8,000	
				HSCO	381
DIN 333	A	○	rh	1,000 - 4,000	
				HSS	590
Guhring std.	A	○	rh	1,000 - 12,500	
				Solid carbide	736
Guhring std.	A	○	rh	0,500 - 6,300	
				HSS	281
Guhring std.	A	○	rh	0,500 - 10,000	

○ bright	● steam tempered	● nitrided lands	● nitrided	● golden brown	● TiAlN
● A TiAlN	● C TiCN	● F FIRE	● P AlCrN	● S TiN	● M MolyGlide

Center drills/Core drills

Tool illustration				Tool material	Guhring no.
Standard	Form	Surface	Cutting direction	Diameter range	

Center drills without flat

				HSS	282
Guhring std.	A	○	lh	0,800 - 5,000	
				HSS	283
Guhring std.	R	○	rh	0,500 - 10,000	
				HSS	284
Guhring std.	R	○	lh	1,250 - 4,000	
				HSS	585
DIN 333	B	○	rh	1,000 - 10,000	
				HSS	586
DIN 333	B	○	lh	1,000 - 10,000	
				HSS	591
Guhring std.	B	○	rh	1,000 - 10,000	
				HSS	280
Guhring std.	A	○	rh	1,000 - 3,150	
				HSS	285
Guhring std.	B	○	rh	1,000 - 6,300	

Center drills with flat

				HSS	587
Guhring std.	A	○	rh	1,600 - 10,000	
				HSS	588
Guhring std.	R	○	rh	1,000 - 8,000	
				HSS	287
Guhring std.	A	○	rh	1,600 - 10,000	
				HSS	288
Guhring std.	R	○	rh	1,600 - 8,000	
				HSS	589
Guhring std.	B	○	rh	1,600 - 8,000	

Tool illustration				Tool material	Guhring no.
Standard	Form	Surface	Cutting direction	Diameter range	

Center drills with flat

				HSS	289
Guhring std.	B	○	rh	1,600 - 5,000	

Tool illustration				Tool material	Guhring no.
Standard	Type	Surface	Cutting direction	Diameter range	

Straight shank core drills

				Carbide	750
Guhring std.	N	○	rh	3,800 - 17,750	
				HSS	533
DIN 344	N	●	rh	3,800 - 20,000	

Taper shank core drills

				Carbide	729
DIN 8043	N	○	rh	18,700 - 40,000	
				HSS	534
DIN 343	N	●	rh	7,400 - 50,000	
				HSCO	634
DIN 343	N	●	rh	7,800 - 34,600	
				HSS	555
DIN 1864	N	●	rh	5,000 - 30,000	
				HSCO	635
DIN 1864	N	●	rh	8,000 - 26,000	

Shell core drills

				Carbide	728
DIN 8022	N	○	rh	32,000 - 74,000	

○ bright	● steam tempered	● nitrided lands	● nitrided	● golden brown	● TiAlN
● A AlTiN	● C TiCN	● F FIRE	● P AlCrN	● S TiN	● M MolyGlide