

DRILLING TOOLS & GUN DRILLS



GUHRING

Ratio drills

Tool illustration					Tool material	Guhring no.
Standard	Type	Surface	Drilling depth	Shank design	Diameter range	

Ratio drills without oil feed

	Solid carbide	1184
DIN 6537 K RT 100 U	3 x D HE	3,000 - 20,000
	Solid carbide	1673
DIN 6537 K RT 100 U	3 x D HA	3,000 - 20,000
	Solid carbide	2472
DIN 6537 K RT 100 U	3 x D HE	3,000 - 20,000
	Solid carbide	2480
DIN 6537 K RT 100 U	3 x D HA	3,000 - 20,000
	Solid carbide	1659
DIN 6537 K RT 100 F	3 x D HA	4,600 - 13,000
	Solid carbide	2475
DIN 6537 K RT 100 F	3 x D HA	3,700 - 13,000
	Solid carbide	2717
DIN 6537 L RT 100 U	5 x D HA	3,000 - 16,000
	Solid carbide	2718
DIN 6537 L RT 100 U	5 x D HE	3,000 - 16,000
	Solid carbide	2719
DIN 6537 L RT 100 U	5 x D HE	3,000 - 20,000
	Solid carbide	2996
DIN 6537 L RT 100 U	5 x D HA	3,000 - 20,000
	Solid carbide	2712
DIN 6537 L RT 100 F	5 x D HA	3,000 - 16,000
	Solid carbide	1242
DIN 6539 RT 100 U	3 x D DZ	3,000 - 16,000
	Solid carbide	2473
DIN 6539 RT 100 U	3 x D DZ	3,000 - 16,000
	Solid carbide	1702
DIN 6539 RT 100 F	3 x D DZ	3,000 - 15,000

bright
 AlTiN

steam tempered

nitrided lands

nitrided

golden brown

TiAlN
 MolyGlide

Ratio drills without oil feed

	Solid carbide	1798
DIN 6539 RT 100 G	3 x D DZ	3,000 - 16,000
	Solid carbide	1243
Guhring std. RT 100 U	5 x D DZ	5,000 - 16,000
	Solid carbide	2474
Guhring std. RT 100 U	5 x D DZ	5,000 - 16,000
	Solid carbide	1799
Guhring std. RT 100 G	5 x D DZ	5,000 - 15,000

Ratio drills with oil feed

	Solid carbide	1181
DIN 6537 K RT 100 U	3 x D HE	3,000 - 20,000
	Solid carbide	1661
DIN 6537 K RT 100 U	3 x D HA	5,000 - 21,000
	Solid carbide	2469
DIN 6537 K RT 100 U	3 x D HE	3,000 - 20,000
	Solid carbide	2477
DIN 6537 K RT 100 U	3 x D HA	3,000 - 20,000
	Solid carbide	1180
DIN 6537 K RT 100 F	3 x D HE	3,300 - 25,000
	Solid carbide	1660
DIN 6537 K RT 100 F	3 x D HA	3,100 - 22,000
	Solid carbide	2468
DIN 6537 K RT 100 F	3 x D HE	3,000 - 20,000
	Solid carbide	1183
DIN 6537 L RT 100 U	5 x D HE	3,300 - 20,000
	Solid carbide	1663
DIN 6537 L RT 100 U	5 x D HA	3,000 - 19,500

Ratio drills

Tool illustration					Tool material	Guhring no.
Standard	Type	Surface	Drilling depth	Shank design	Diameter range	

Ratio drills with oil feed

	Solid carbide	2471
DIN 6537 L RT 100 U	5 x D HE	3,000 - 20,000
	Solid carbide	2479
DIN 6537 L RT 100 U	5 x D HA	3,000 - 20,000
	Solid carbide	1182
DIN 6537 L RT 100 F	5 x D HE	3,000 - 25,000
	Solid carbide	1662
DIN 6537 L RT 100 F	5 x D HA	3,000 - 24,500
	Solid carbide	2470
DIN 6537 L RT 100 F	5 x D HE	3,000 - 20,000
	Solid carbide	2478
DIN 6537 L RT 100 F	5 x D HA	3,000 - 20,000
	Solid carbide	6501
DIN 6537 L RT 100 R	5 x D HA	3,000 - 20,000
	Solid carbide	2711
Guhring std. RT 100 U	7 x D HA	3,000 - 19,500
	Solid carbide	4044
Guhring std. RT 100 U	7 x D HA	3,000 - 20,000
	Solid carbide	4045
Guhring std. RT 100 U	7 x D HE	3,000 - 20,000
	Solid carbide	6502
Guhring std. RT 100 R	7 x D HA	4,000 - 20,000
	Solid carbide	768
Guhring std. RT 150 GG	4 x D HA	3,000 - 20,000
	Solid carbide	6068
Guhring std. RT 150 GG	4 x D HA	3,000 - 20,000
	Solid carbide	769
Guhring std. RT 150 GG	7 x D HA	3,000 - 20,000

bright
 AlTiN

steam tempered
 TiCN

nitrided lands
 FIRE

nitrided
 AlCrN

golden brown
 TiN

TiAIN
 MolyGlide

Ratio drills with oil feed

	Solid carbide	6069
Guhring std. RT 150 GG	7 x D HA	3,000 - 20,000
	Solid carbide	770
Guhring std. RT 150 GG	10 x D HA	3,000 - 20,000
	Solid carbide	6070
Guhring std. RT 150 GG	10 x D HA	3,000 - 20,000
	Solid carbide	773
Guhring std. RT 150 GN	15 x D HA	5,000 - 14,000
	Solid carbide	6511
Guhring std. RT 100 T	20 x D HA	3,000 - 14,000
	Solid carbide	6512
Guhring std. RT 100 T	25 x D HA	3,000 - 12,000
	Solid carbide	6513
Guhring std. RT 100 T	30 x D HA	3,000 - 10,000
	Solid carbide	6514
Guhring std. RT 100 T	40 x D HA	3,000 - 8,000
	Carbide	1171
DIN 6538 K RT 80 U	3 x D HE	9,500 - 25,500
	Carbide	1172
DIN 6538 M RT 80 U	5 x D HE	9,500 - 25,500
	Carbide	1173
DIN 6538 L RT 80 U	7 x D HE	9,500 - 25,000

3-flute Ratio drills

	Solid carbide	2713
DIN 6537 L FT 200 G	5 x D HA	3,000 - 20,000
	Solid carbide	2939
DIN 6537 L FT 200 G	5 x D HA	5,000 - 18,500

Ratio drills

Tool illustration					Tool material	Guhring no.
Standard	Type	Surface	Drilling depth	Shank design	Diameter range	

3-flute Ratio drills

	Solid carbide	731				
DIN 6539 GS 200 U	○	5 x D	DZ	3,000 - 20,000		
	Solid carbide	611				
DIN 6539 GS 200 U	○	5 x D	DZ	3,000 - 19,500		
	Solid carbide	1021				
DIN 6539 GS 200 U	○	5 x D	DZ	3,700 - 17,000		
	Solid carbide	745				
DIN 6539 GS 200 G	○	3 x D	DZ	3,570 - 19,500		
	Solid carbide	1020				
DIN 6539 GS 200 G	○	3 x D	DZ	3,600 - 20,000		
	Solid carbide	1024				
DIN 6539 GS 200 G	○	5 x D	DZ	4,100 - 19,500		
	Solid carbide	1025				
DIN 6539 GS 200 G	○	5 x D	DZ	3,000 - 24,000		
	Solid carbide	1027				
DIN 6539 GS 200 F	○	5 x D	DZ	3,000 - 18,500		

3-flute stepped Ratio drills

	Solid carbide	1033			
Guhring std. GS 200 U	○	DZ	4,000 - 20,000		
	Solid carbide	1032			
Guhring std. GS 200 G	○	DZ	3,400 - 20,000		
	Solid carbide	1034			
Guhring std. GS 200 G	○	DZ	3,100 - 20,000		

GUHRING



HT 800 WP - RT 800 WP - LT 800 WP

The interchangeable insert drilling system T 800 is the intelligent solution for efficiently and economically machining large and deep holes applying the following types:

HT 800 WP: Drilling depths 3xD/5xD/7xD, interch. ins. bright/Fire, Ø-range 11.0 - 25.99 mm

RT 800 WP: Drilling depths 3xD/5xD/7xD, interch. ins. bright/TiN/Fire, Ø-range 16.0 - 40.5 mm

LT 800 WP: Drilling depth up to 12xD, interch. ins. bright/TiN/Fire, Ø-range 40.0 - 100.0 mm

○ bright
A AlTiN

● steam tempered
C TiCN

● nitrided lands
F FIRE

● nitrided
P AlCrN

● golden brown
S TiN

A TiAIN
M MolyGlide

Straight shank twist drills

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

Jobber drills

	HSS	205
DIN 338 N >Ø 2,36 rh	0,200 - 20,000	
	HSS	206
DIN 338 H rh	0,200 - 20,000	
	HSS	207
DIN 338 W rh	0,200 - 20,000	
	HSS	208
DIN 338 N >Ø 2,36 lh	0,200 - 20,000	
	HSS	209
DIN 338 H lh	0,300 - 20,000	
	HSS	210
DIN 338 W lh	0,250 - 20,000	
	HSS	240
DIN 338 N rh	3,000 - 16,000	
	HSS	549
DIN 338 GT 100 >Ø 2,36 rh	0,600 - 16,000	
	HSS	550
DIN 338 GT 100 >Ø 2,36 lh	1,000 - 16,000	
	HSS	560
DIN 338 N rh	2,370 - 5,610	
	HSS	651
DIN 338 N rh	0,200 - 19,500	
	HSS	652
DIN 338 GT 100 rh	1,000 - 16,000	
	HSS	664
DIN 338 N lh	0,250 - 14,250	
	HSS	665
DIN 338 GT 100 lh	1,300 - 10,200	

bright
A AlTiN

steam tempered
C TiCN

nitrided lands
F FIRE

nitrided
P AlCrN

golden brown
S TiN

TiAlN
M MolyGlide

Jobber drills

Tool illustration				Tool material	Guhring no.
Standard	Type	Surface	Cutting direction	Diameter range	
	HSS	2456			
DIN 338 N F rh	1,000 - 16,000				
	HSS	2457			
DIN 338 GT 100 F rh	1,000 - 15,000				
	HSCO	305			
DIN 338 N >Ø 2,36 rh	0,200 - 20,000				
	HSCO	308			
DIN 338 N >Ø 2,36 lh	0,360 - 20,000				
	HSCO	605			
DIN 338 Ti rh	0,200 - 19,000				
	HSCO	608			
DIN 338 Ti lh	1,000 - 9,500				
	HSCO	622			
DIN 338 GT 100 >Ø 2,36 rh	1,000 - 16,000				
	HSCO	657			
DIN 338 Ti rh	0,500 - 14,500				
	HSCO	658			
DIN 338 GT 100 S rh	1,000 - 16,000				
	HSCO	1221			
DIN 338 VA C rh	3,000 - 12,000				
	HSCO	1223			
DIN 338 GT 100 A rh	3,000 - 12,000				
	HSCO	1260			
DIN 338 VA rh	1,000 - 13,000				
	HSCO	2047			
DIN 338 P2000 rh	1,000 - 13,000				
	HSCO	2458			
DIN 338 GT 100 F rh	0,400 - 15,000				

Straight shank twist drills

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

Jobber drills

	HSCO	2459
DIN 338 GT 100 F rh	1,000 - 16,000	
	HSCO	2997
DIN 338 N S rh	1,000 - 14,500	
	M42	1146
DIN 338 N O rh	0,500 - 16,000	
	Carbide	710
Guhring std. Duro 150 O rh	3,000 - 14,000	
	Solid carbide	732
Guhring std. N O rh	1,000 - 12,000	
	Solid carbide	2464
Guhring std. N F rh	1,000 - 12,000	

Stub drills

	HSS	223
DIN 1897 N O >Ø 2,36 rh	0,350 - 48,000	
	HSS	224
DIN 1897 H O rh	0,690 - 22,000	
	HSS	225
DIN 1897 W O rh	1,000 - 22,000	
	HSS	226
DIN 1897 N O >Ø 2,36 lh	0,320 - 50,000	
	HSS	227
DIN 1897 H O lh	0,750 - 24,000	
	HSS	228
DIN 1897 W O lh	1,000 - 20,000	
	HSS	552
DIN 1897 GT 80 <Ø 2,36 >Ø 16,00 rh	1,000 - 20,000	

○ bright
A AlTiN

● steam tempered
C TiCN

● nitrided lands
F FIRE

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

Stub drills

	HSS	553
DIN 1897 GT 80 <Ø 2,36 >Ø 16,0 lh	1,000 - 20,000	
	HSS	653
DIN 1897 N S rh	0,500 - 30,160	
	HSS	672
DIN 1897 N S lh	0,900 - 16,000	
	HSS	2460
DIN 1897 N F rh	1,000 - 16,000	
	HSCO	329
DIN 1897 GV 120 <Ø 2,36 >Ø rh	0,400 - 48,000	
	HSCO	330
DIN 1897 GV 120 <Ø 2,36 >Ø lh	0,450 - 35,000	
	HSCO	659
DIN 1897 GV 120 S rh	0,500 - 15,500	
	HSCO	1228
DIN 1897 GT 80 S rh	1,000 - 20,000	
	HSCO	1261
DIN 1897 VA O rh	1,000 - 12,000	
	HSCO	2048
DIN 1897 P2000 M rh	1,000 - 13,000	
	HSCO	2461
DIN 1897 GV 120 F rh	1,000 - 20,000	
	HSCO	2498
DIN 1897 GT 80 F rh	1,000 - 16,000	
	M42	1259
DIN 1897 N O rh	1,000 - 15,870	
	HSS-E-PM	515
DIN 1897 GT 500 F rh	1,000 - 14,000	

● nitrided
P AlCrN

● golden brown
S TiCN

A TiAIN
M MolyGlide

Straight shank twist drills

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

Stub drills

	Solid carbide	730
DIN 6539 N ○ rh	0,500 - 16,000	
	Solid carbide	2463
DIN 6539 N F rh	1,000 - 16,000	
	Solid carbide	702
Guhring std. N ○ rh	0,500 - 6,500	
	Solid carbide	709
Guhring std. N ○ rh	2,820 - 11,910	

Set of jobber drills

	HSS/ HSCO	200
DIN 338 N rh -		

Set of jobber drills in case

	HSCO	195
DIN 338 VA ○ rh -		
	HSS/ HSCO	201
DIN 338 N S rh -		
	HSCO	2049
DIN 338 P2000 ○ rh -		
	HSCO	2050
DIN 1897 P2000 M rh -		

Twist drills with oversize straight shank

	HSCO	512
Guhring std. GU 500 S rh 2,000 - 20,000		
	HSS-E- PM	513
Guhring std. GT 500 F rh 2,000 - 13,000		

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

Twist drills with oversize straight shank

	HSCO	511
Guhring std. GU 500 S rh 2,000 - 20,000		
	Solid carbide	1946

Jobber drills with 12.7 mm dia. shank

	HSS	268
Guhring std. N ○ rh 13,000 - 31,750		

Stub drills with 16.0 mm dia. shank

	HSCO	128
Guhring std. N ○ rh 16,000 - 40,000		

Stub drills with 25.4 mm dia. shank

	HSCO	129
Guhring std. N ○ rh 25,000 - 40,000		
	HSCO	136
Guhring std. N ○ lh 25,000 - 39,000		

90° NC-spotting drills

	HSS	557
Guhring std. N ○ rh 2,950 - 25,400		
	HSS	568
Guhring std. N S rh 3,000 - 25,400		
	Solid carbide	723
Guhring std. N ○ rh 5,000 - 20,000		
	HSS	559
Guhring std. N ○ rh 6,350 - 25,400		

○ bright	● steam tempered	● nitrided lands
AITiN	TiCN	FIRE
● nitrided	● golden brown	● TiAIN
AlCrN	TiN	MolyGlide

Straight shank twist drills

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

120° NC-spotting drills

	HSS	556
Guhring std. N rh	3,000 - 25,400	
	HSS	567
Guhring std. N rh	3,000 - 25,400	
	Solid carbide	724
Guhring std. N rh	5,000 - 20,000	

142° NC-spotting drills

	Solid carbide	546
Guhring std. N rh	4,000 - 20,000	

Straight shank drills double-ended

	HSS	554
Guhring std. DK 77 >Ø 2,36 rh	1,500 - 10,500	

Micro-precision drills without oil feed

	HSS-E-PM	301
DIN 1899 N rh	0,050 - 1,920	
	HSS-E-PM	303
DIN 1899 N lh	0,130 - 1,945	
	HSS-E-PM	660
DIN 1899 N rh	0,128 - 1,900	
	Solid carbide	701
Guhring std. N rh	0,200 - 1,400	
	Solid carbide	6400
Guhring std. N rh	0,800 - 3,000	
	Solid carbide	6401
Guhring std. N rh	0,800 - 3,000	

Micro-precision drills with oil feed

	Solid carbide	6408
Guhring std. N rh	1,400 - 3,000	
	Solid carbide	6412
Guhring std. N rh	1,400 - 3,000	

Long series twist drills

	HSS	204
DIN 340 N rh	2,950 - 25,250	
	HSS	217
DIN 340 N rh	0,400 - 36,510	
	HSS	218
DIN 340 H rh	0,500 - 18,000	
	HSS	219
DIN 340 W rh	0,400 - 20,640	
	HSS	220
DIN 340 N lh	0,450 - 29,000	
	HSS	221
DIN 340 H lh	0,430 - 15,000	
	HSS	501
DIN 340 GT50 rh	1,000 - 14,000	
	HSS	506
DIN 340 GT 100 lh	1,400 - 13,000	
	HSS	535
DIN 340 GT 100 rh	1,000 - 14,000	

bright
A AlTiN

steam tempered
C TiCN

nitrided lands
F FIRE

nitrided
P AlCrN

golden brown
S TiN

TiAlN
M MolyGlide

Straight shank twist drills

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

Long series twist drills

	HSS	667
DIN 340 N rh	0,500 - 22,220	
	HSS	668
DIN 340 GT 100 rh	1,000 - 14,000	
	HSS	2462
DIN 340 GT 100 rh	1,000 - 10,000	
	HSCO	317
DIN 340 N rh	0,500 - 26,000	
	HSCO	336
DIN 340 GT 100 rh	1,000 - 16,000	
	HSCO	396
DIN 340 GT 100 rh	1,000 - 12,000	
	HSCO	617
DIN 340 Ti rh	1,000 - 13,000	
	HSCO	669
DIN 340 Ti rh	1,000 - 10,200	
	Solid carbide	706
Guhring std. N rh	0,500 - 1,500	

Extra length twist drills, series 1

	HSS	235
DIN 1869 N rh	1,600 - 13,000	
	HSS	502
DIN 1869 GT 100 rh	1,950 - 13,000	
	HSS	524
DIN 1869 GT 50 rh	2,000 - 12,700	
	HSS	670
DIN 1869 GT 100 rh	1,980 - 12,700	

Extra length twist drills, series 1

	HSCO	618
DIN 1869 GT 100 rh	2,700 - 10,000	

Extra length twist drills, series 2

	HSS	236
DIN 1869 N rh	2,700 - 13,000	
	HSS	503
DIN 1869 GT 100 rh	2,000 - 13,000	
	HSS	528
DIN 1869 GT 50 rh	3,000 - 13,000	
	HSS	671
DIN 1869 GT 100 rh	2,700 - 8,500	
	HSCO	619
DIN 1869 GT 100 rh	3,000 - 10,000	

Extra length twist drills, series 3

	HSS	237
DIN 1869 N rh	3,500 - 13,000	
	HSS	504
DIN 1869 GT 100 rh	2,500 - 13,000	
	HSS	529
DIN 1869 GT 50 rh	2,500 - 13,000	

Extra length twist drills

	HSS	242
Guhring std. GT 100 rh	6,000 - 12,000	
	HSS	243
Guhring std. GT 100 rh	8,000 - 12,000	

bright
A AlTiN

steam tempered
C TiCN

nitrided lands
F FIRE

nitrided
P AlCrN

golden brown
S TiN

TiAIN
M MolyGlide

Straight shank twist drills

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

Extra length twist drills

	HSS	244
Guhring std. GT 100	GT 100	○ rh 10,000 - 12,000

Aircraft extension drills, 6 inches long

	HSS	577
NAS 907	N	○ rh 1,500 - 8,000
	HSS	579
NAS 907	N	○ >Ø 2,36 rh 1,500 - 8,000

Aircraft extension drills, 12 inches long

	HSS	578
NAS 907	N	○ rh 1,500 - 8,000
	HSS	580
NAS 907	N	○ >Ø 2,36 rh 1,500 - 8,000

Taper pin drills

	HSS	531
DIN 1898	N	○ >Ø 2,36 rh 1,000 - 12,000

Carbide-tipped twist drill

	Carbide	703
DIN 8037	N	○ rh 1,700 - 24,000
	Carbide	704
DIN 8038	N	○ rh 1,500 - 24,500

Kevlar drills

	Solid carbide	1149
Guhring std.	N	○ rh 2,500 - 12,000

Tool illustration				Tool material	Guhring no.	
Standard	Type	Surface	Cutting direction	Oil feed type	Diameter range	
Guhring std.	GT 80 IK	○	rh axial	5,000 - 20,000		1131
Guhring std.	GT 80 IK	○	rh axial	5,000 - 20,000		1132
Guhring std.	GT 80 IK	(S)	rh axial	5,000 - 20,000		1132
Guhring std.	N	○	rh axial	3,000 - 13,000		390

	bright		steam tempered		nitrided lands
	AITiN		TiCN		FIRE

	PAlCrN		STiN		TiAIN
	MolyGlide				

Carbide tipped spade drills

	Carbide	707
Guhring std.	GT 100	○ rh 3,000 - 12,000

Masonry drills

	Carbide	716
Guhring std.	N	○ rh 3,000 - 15,000

Bushing length twist drills

	HSS	211
DIN 339	N	○ >Ø 2,36 rh 0,800 - 20,000
	HSS	561
DIN 339	N	○ rh 2,400 - 5,000
	HSS	666
DIN 339	N	(S) rh 1,000 - 13,000
	HSCO	311
DIN 339	N	○ >Ø 2,36 rh 1,100 - 19,000

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

Oil feed drills

	HSCO	1131
Guhring std.	GT 80 IK	○ rh axial 5,000 - 20,000
	HSCO	1132
Guhring std.	GT 80 IK	(S) rh axial 5,000 - 20,000
	HSS	390
Guhring std.	N	○ rh axial 3,000 - 13,000

Taper shank twist drills

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

Short length twist drills

	HSCO	363
Guhring std. GV 120	rh	7,000 - 43,000
	HSCO	663
Guhring std. GV 120	rh	10,500 - 31,000
	HSCO	1263
Guhring std. VA	rh	10,000 - 30,500

Twist drills

	HSS	229
DIN 345 N	rh	8,000 - 59,000
	HSS	245
DIN 345 N	rh	2,000 - 98,420
	HSS	246
DIN 345 H	rh	6,700 - 47,000
	HSS	247
DIN 345 W	rh	3,200 - 43,000
	HSS	248
DIN 345 N	lh	6,000 - 60,000
	HSS	558
DIN 345 GT 100	rh	7,940 - 31,750
	HSS	592
DIN 345 N	rh	10,000 - 28,000
	HSS	606
DIN 345 GT 100	rh	7,940 - 29,000
	HSS	654
DIN 345 N	rh	3,000 - 31,000
	HSCO	345
DIN 345 N	rh	3,000 - 50,000

bright
 AITiN

steam tempered
 TiCN

nitrided lands
 FIRE

nitrided
 AlCrN

golden brown
 TiN

TiAIN
 MolyGlide

Twist drills

	HSCO	645
DIN 345 GT 100	rh	9,520 - 39,000
	HSCO	661
DIN 345 N	rh	8,000 - 30,000
	HSCO	662
DIN 345 GT 100	rh	10,000 - 28,500
	HSCO	1222
DIN 345 GT 100	rh	10,000 - 30,160
	HSCO	1224
DIN 345 VA	rh	10,400 - 30,160
	HSCO	1262
DIN 346 N	rh	10,000 - 76,000
	HSCO	351
DIN 346 N	rh	10,000 - 31,500

Bushing length twist drills

	HSS	257
DIN 341 N	rh	2,900 - 50,000
	HSS	505
DIN 341 GT 50	rh	5,500 - 29,500
	HSS	551
DIN 341 GT 100	rh	5,500 - 32,000
	HSS	655
DIN 341 N	rh	4,000 - 22,000
	HSS	656
DIN 341 GT 100	rh	6,200 - 23,000

Taper shank twist drills

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

Bushing length twist drills

	HSCO	357
DIN 341 N  rh	4,750 - 44,000	
	HSCO	623
DIN 341 GT 100  rh	10,000 - 27,780	
	HSS	523
Guhring std. N  rh	10,000 - 29,000	

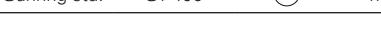
Extra length twist drills, series 1

	HSS	266
DIN 1870 N  rh	8,000 - 50,000	
	HSS	525
DIN 1870 GT50  rh	7,900 - 33,000	
	HSS	526
DIN 1870 GT 100  rh	8,000 - 31,000	
	HSCO	620
DIN 1870 GT 100  rh	9,520 - 30,000	

Extra length twist drills, series 2

	HSS	267
DIN 1870 N  rh	7,700 - 45,000	
	HSS	527
DIN 1870 GT 100  rh	8,000 - 30,000	
	HSS	542
DIN 1870 GT50  rh	8,000 - 31,000	
	HSCO	621
DIN 1870 GT 100  rh	9,520 - 29,500	

Extra length twist drills

	HSS	563
Guhring std. GT 100  rh	6,000 - 7,500	
	HSS	566
Guhring std. GT 100  rh	8,000 - 40,000	
	HSS	293
Guhring std. GT 100  rh	14,000 - 40,000	
	HSS	564
Guhring std. GT 100  rh	6,000 - 10,000	
	HSS	565
Guhring std. GT 100  rh	6,000 - 17,000	
	HSS	298
Guhring std. GT 100  rh	14,000 - 18,000	
	HSS	299
Guhring std. GT 100  rh	14,000 - 18,000	

Taper pin drills

	HSS	532
DIN 1898 N  rh	5,000 - 25,000	

Carbide-tipped twist drill

	Carbide	705
DIN 8041 N  rh	8,000 - 49,000	

 bright
A AlTiN

 steam tempered
C TiCN

 nitrided lands
F FIRE

 nitrided
P AlCrN

 golden brown
S TiN

 TiAlN
M MolyGlide

Taper shank twist drills

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

Oil feed drills short

	HSS	269
Guhring std. N rh radial 9,520 - 23,020		

Oil feed drills, flute length to DIN 341

	HSS	1101
Guhring std. N rh DIN 228 BK 10,000 - 32,000		
	HSS	270
Guhring std. N rh axial 10,000 - 49,000		
	HSS	271
Guhring std. N rh radial 10,000 - 44,450		
	HSS	272
Guhring std. N rh radial 10,000 - 49,000		
	HSCO	370
Guhring std. GT 100 rh axial 11,000 - 34,920		
	HSCO	371
Guhring std. GT 100 rh radial 11,000 - 34,920		
	HSCO	372
Guhring std. GT 100 rh radial 12,500 - 34,000		

Oil feed drills, flute length to DIN 1870

	HSCO	374
Guhring std. GT 100 rh axial 11,000 - 32,540		
	HSCO	375
Guhring std. GT 100 rh radial 11,000 - 34,000		
	HSCO	376
Guhring std. GT 100 rh radial 11,000 - 34,000		

Step drills

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

Stepped drills for centering to DIN 332

	HSS	274
Guhring std. N rh 8,000 - 40,000		
	HSS	574
Guhring std. N rh 8,000 - 40,000		
	HSS	576
Guhring std. N rh 14,000 - 40,000		
	HSS	575
Guhring std. N rh 8,000 - 20,000		

Straight shank short step drills

	HSS	378
Guhring std. N rh 6,000 - 19,000		
	HSS	1147
Guhring std. N rh 6,600 - 21,500		
	HSS	379
Guhring std. N rh 6,000 - 18,000		
	HSS	380
Guhring std. N rh 3,400 - 13,500		

Straight shank subland drills

	HSS	569
DIN 8374 N rh 7,500 - 19,000		
	HSS	536
DIN 8374 N rh 6,000 - 19,000		
	HSS	636
Guhring std. N rh 6,600 - 17,200		
	HSS	638
Guhring std. N rh 6,000 - 8,000		

bright
A AlTiN

steam tempered
C TiCN

nitrided lands
F FIRE

nitrided
P AlCrN

golden brown
S TiN

TiAlN
M MolyGlide

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 rh	0,500 - 8,000	
	HSS	614
DIN 333 R 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
A AlTiN

steam tempered
C TiCN

nitrided lands
F FIRE

nitrided
P AlCrN

golden brown
S TiN

TiAIN
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

○ bright
Ⓐ AlTiN

● steam tempered
Ⓒ TiCN

● nitrided lands
Ⓕ FIRE

● nitrided
Ⓟ AlCrN

● golden brown
Ⓢ TiN

Ⓐ TiAIN
Ⓜ MolyGlide

Center drills with flat

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

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

Taper shank core drills

	Carbide	729
DIN 1864 N	○ rh	18,700 - 40,000
	HSS	534
DIN 1864 N	● rh	7,400 - 50,000
	HSCO	634
DIN 1864 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

Gun drills

Tool illustration			Tool material	Guhring no.
Standard	Type	Surface	Flute length (mm)	Diameter range

EB 100 single-fluted gun drills

	Solid carbide	5024
Guhring std. EB 100	45.00	1.200 - 3.200
	Solid carbide	5632
Guhring std. EB 100	45.00	2.000 - 3.200
	Solid carbide	5020
Guhring std. EB 100	80.00	1.200 - 5.000
	Solid carbide	5633
Guhring std. EB 100	80.00	2.000 - 5.000
	Solid carbide	5026
Guhring std. EB 100	120.00	1.500 - 5.000
	Solid carbide	5637
Guhring std. EB 100	120.00	2.000 - 5.000
	Solid carbide	5021
Guhring std. EB 100	160.00	1.500 - 8.000
	Solid carbide	5638
Guhring std. EB 100	160.00	2.000 - 8.000

EB 80 single-fluted gun drills

	Carbide	5018
Guhring std. EB 80	20 x D	4.000 - 12.000
	Carbide	5639
Guhring std. EB 80	20 x D	4.000 - 12.000
	Carbide	5460
Guhring std. EB 80	30 x D	4.000 - 12.000
	Carbide	5640
Guhring std. EB 80	30 x D	4.000 - 12.000
	Carbide	5022
Guhring std. EB 80	40 x D	4.000 - 12.000
	Carbide	5641
Guhring std. EB 80	40 x D	4.000 - 12.000
	Carbide	5023
Guhring std. EB 80	80 x D	4.950 - 11.950
	Carbide	5642
Guhring std. EB 80	80 x D	4.950 - 11.950

EB 800 single-fluted gun drills with indexable inserts

	Carbide	5644
Guhring std. EB 800	30 x D	16.000 - 24.000

ZB 80 two-fluted gun drills

	Carbide	5019
Guhring std. ZB 80	30 x D	8.000 - 12.000
	Carbide	5643
Guhring std. ZB 80	30 x D	8.000 - 12.000

bright
 AITiN

steam tempered
 TiCN

nitrided lands
 FIRE

nitrided
 AlCrN

golden brown
 TiIN

TiAIN
 MolyGlide

SL range summary

SL drills

Ratio drills

Standard (DIN)	Type	Shank form	Drilling depth	Tool illustration	Tool material	Carbide grade	Surface	Internal cooling	Ø-range mm	Guhr. no.	Page
DIN 6537 short	RT100 U	HA	3 x D		Carb.-UF	K/P	F	-	3.00...20.00	5514	14
	RT100 U	HE					F	-	3.00...16.00	5614	14
	RT100 U	HA					F	■	3.00...20.00	5510	14
	RT100 U	HE					F	■	3.00...20.00	5610	14
	RT100 VA	HA					a	■	3.00...20.00	8510	14
	RT100 VA	HE					a	■	3.00...20.00	8610	14
DIN 6537 long	RT100 U	HA	5 x D		Carb.-UF	K/P	F	-	3.00...20.00	5515	18
	RT100 U	HE					F	-	3.00...16.00	5615	18
	RT100 U	HA					F	■	3.00...20.00	5511	18
	RT100 U	HE					F	■	3.00...20.00	5611	18
	RT100 VA						a	■	3.00...20.00	8511	18
	RT100 VA						a	■	3.00...20.00	8611	18
Guhring std.	RT100 U	HA	7 x D		Carb.-UF	K/P	F	■	4.00...20.00	5512	23
		HE					F	■	4.00...20.00	5612	23
Guhring std.	RT100	HA	12 x D		Carb.-UF	K/P	F	■	4.00...20.00	5525	25
Guhring std.	RT150 GG	HA	10 x D		Carb.-UF	K	○	■	3.00...16.00	5513	28

3-flute Ratio drills

DIN 6537 long	FT200	HA	5 x D		Carb.-UF	K	○	-	3.00...20.00	5518	29
---------------	-------	----	-------	--	----------	---	---	---	--------------	-------------	----

GuhringNavigator drilling tools

42

○ bright F FIRE a TiAlN nanoA ■ tool with internal cooling

SL range summary

SL drills

Carbide twist drills

Standard (DIN)	Type	Shank form	Drilling depth	Tool illustration	Tool material	Carbide grade	Surface	Internal cooling	Ø-range mm	Guhr. no.	Page
DIN 6539	N	-	3 x D		Carb.-UF	K		-	2.00...12.00	5516	31
Guhring std.	N	-	5 x D		Carb.-UF	K		-	2.00...12.00	5517	32

High speed steel twist drills

DIN 1897	GU500 DZ	-	3 x D		HSCO	-		-	1.00...14.00	5524	33
DIN 1897	GU500 DZ	-	3 x D		HSCO	-		-	1.00...14.00	5520	33
	GT500 DZ	-	3 x D		PM HSS-E	-		-	1.00...14.00	5521	33
DIN 338	GU500 DZ	-	5 x D		HSCO	-		-	1.00...14.00	5523	36
DIN 338	GU500 DZ	-	5 x D		HSCO	-		-	1.00...14.00	5519	36
DIN 338	GT500 DZ	-	5 x D		PM HSS-E	-		-	1.00...14.00	5522	36
DIN 338	GU500 DZ	-	5 x D	Sets of Guhring no. 5523	HSCO	-		-	-	201	39