### Straight shank twist drills

<table>
<thead>
<tr>
<th>Tool illustration</th>
<th>Tool material</th>
<th>Guhring no.</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Jobber drills</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>DIN 338 N</td>
<td>HSS</td>
<td>205</td>
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<tr>
<td>DIN 338 H</td>
<td>HSS</td>
<td>206</td>
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<tr>
<td>DIN 338 W</td>
<td>HSS</td>
<td>207</td>
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<td>208</td>
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<tr>
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<td>DIN 338 N</td>
<td>HSS</td>
<td>309</td>
</tr>
<tr>
<td>DIN 338 H</td>
<td>HSS</td>
<td>605</td>
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<tr>
<td>DIN 338 Ti</td>
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<td>DIN 338 Ti</td>
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<tr>
<td>DIN 338 GT 100</td>
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<td>657</td>
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<tr>
<td>DIN 338 Ti</td>
<td>HSS</td>
<td>658</td>
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<td>DIN 338 GT 100</td>
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<td>DIN 338 GT 100</td>
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<td>DIN 338 VA</td>
<td>HSS</td>
<td>2047</td>
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<tr>
<td>DIN 338 P2000</td>
<td>HSS</td>
<td>2458</td>
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</tbody>
</table>

**Notes:**
- Bright
- Steam tempered
- Nitrided lands
- Nitrided
- Golden brown
- TiAlN
- AlTiN
- TiCN
- AIC+N
- TiN
- MolyGlide

26 GUHRING AND ITS PRODUCTS
## Straight shank twist drills

<table>
<thead>
<tr>
<th>Tool illustration</th>
<th>Tool material</th>
<th>Guhring no.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Standard</td>
<td>Type</td>
<td>Surface</td>
</tr>
</tbody>
</table>

### Jobber drills

- **DIN 338** GT 100<br>Surface: bright steam tempered<br>Cutting direction: rh<br>Diameter range: 1,000 - 16,000<br>Tool material: HSCO 2459

- **DIN 338** N<br>Surface: nitrided<br>Cutting direction: rh<br>Diameter range: 1,000 - 14,500<br>Tool material: HSCO 2997

- **DIN 338** N<br>Surface: nitrided golden brown TiAlN<br>Cutting direction: rh<br>Diameter range: 0,500 - 16,000<br>Tool material: M42 1146

### Stub drills

- **DIN 1897** GT 80<br>Surface: bright<br>Cutting direction: lh<br>Diameter range: 1,000 - 20,000<br>Tool material: HSS 553

- **DIN 1897** N<br>Surface: nitrided<br>Cutting direction: rh<br>Diameter range: 0,500 - 30,160<br>Tool material: HSS 653

- **DIN 1897** N<br>Surface: nitrided<br>Cutting direction: lh<br>Diameter range: 0,900 - 16,000<br>Tool material: HSS 672

- **DIN 1897** GV 120<br>Surface: bright<br>Cutting direction: lh<br>Diameter range: 0,400 - 48,000<br>Tool material: M42 1259

- **DIN 1897** GV 120<br>Surface: nitrided<br>Cutting direction: lh<br>Diameter range: 0,450 - 35,000<br>Tool material: M42 1261

- **DIN 1897** P2000<br>Surface: bright<br>Cutting direction: rh<br>Diameter range: 1,000 - 13,000<br>Tool material: MolyGlide 2461
### Straight Shank Twist Drills

<table>
<thead>
<tr>
<th>Standard</th>
<th>Type</th>
<th>Surface</th>
<th>Cutting Direction</th>
<th>Diameter Range</th>
<th>Tool Material</th>
<th>Guhring No.</th>
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<tr>
<td>DIN 6539</td>
<td>N</td>
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<td>0.500 - 16.000</td>
<td>Solid Carbide</td>
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<tr>
<td>DIN 6539</td>
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<td>rh</td>
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<td>1.000 - 16.000</td>
<td>Solid Carbide</td>
<td>2463</td>
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<td>Guhring Std.</td>
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<td>Guhring Std.</td>
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<td>2.820 - 11.910</td>
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### Twist Drills with Oversize Straight Shank

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<th>Type</th>
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<th>Cutting Direction</th>
<th>Diameter Range</th>
<th>Tool Material</th>
<th>Guhring No.</th>
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<tbody>
<tr>
<td>Guhring Std.</td>
<td>GU 500</td>
<td>rh</td>
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<td>2.000 - 20.000</td>
<td>HSCO</td>
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<tr>
<td>DIN 6537 K</td>
<td>H</td>
<td>rh</td>
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<td>3.000 - 12.000</td>
<td>Solid Carbide</td>
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### Jobber Drills with 12.7 mm Dia. Shank

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<th>Cutting Direction</th>
<th>Diameter Range</th>
<th>Tool Material</th>
<th>Guhring No.</th>
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<tbody>
<tr>
<td>Guhring Std.</td>
<td>N</td>
<td>rh</td>
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<td>13.000 - 31.750</td>
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### Stub Drills with 16.0 mm Dia. Shank

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<th>Cutting Direction</th>
<th>Diameter Range</th>
<th>Tool Material</th>
<th>Guhring No.</th>
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</thead>
<tbody>
<tr>
<td>Guhring Std.</td>
<td>N</td>
<td>rh</td>
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<td>16.000 - 40.000</td>
<td>HSCO</td>
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### Stub Drills with 25.4 mm Dia. Shank

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<th>Diameter Range</th>
<th>Tool Material</th>
<th>Guhring No.</th>
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</thead>
<tbody>
<tr>
<td>Guhring Std.</td>
<td>N</td>
<td>rh</td>
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<td>25.000 - 39.000</td>
<td>HSCO</td>
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### 90° NC-Spotting Drills

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<th>Type</th>
<th>Surface</th>
<th>Cutting Direction</th>
<th>Diameter Range</th>
<th>Tool Material</th>
<th>Guhring No.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Guhring Std.</td>
<td>N</td>
<td>rh</td>
<td></td>
<td>2.950 - 25.400</td>
<td>HSS</td>
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### Set of Jobber Drills

| DIN 338 | N | rh | - | HSS/HSCO | 200 |

### Set of Jobber Drills in Case

| DIN 338 | VA | rh | - | HSCO | 195 |
| DIN 338 | N | rh | - | HSS/HSCO | 201 |
| DIN 338 | P2000 | rh | - | HSCO | 2049 |
| DIN 1897 | P2000 | rh | - | HSCO | 2050 |

### Twist Drills with Oversize Straight Shank

<table>
<thead>
<tr>
<th>Guhring Std.</th>
<th>Type</th>
<th>Surface</th>
<th>Cutting Direction</th>
<th>Diameter Range</th>
<th>Tool Material</th>
<th>Guhring No.</th>
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<tbody>
<tr>
<td>Guhring Std.</td>
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<td>Guhring Std.</td>
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<td>rh</td>
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<td>2.000 - 13.000</td>
<td>HSS-E-P</td>
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</table>

- Bright
- Steam Tempered
- Nitrided Lands
- Nitrided
- Golden Brown
- TiAlN
- AlCrN
- TiN
- MolyGlide
### Straight shank twist drills

<table>
<thead>
<tr>
<th>Standard</th>
<th>Type</th>
<th>Surface</th>
<th>Cutting Direction</th>
<th>Diameter Range</th>
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**120° NC-spotting drills**

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<th>Surface</th>
<th>Cutting Direction</th>
<th>Diameter Range</th>
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</thead>
<tbody>
<tr>
<td></td>
<td>N</td>
<td>rh</td>
<td></td>
<td>3,000 - 25,400</td>
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</table>

Guhring std. N  rh  3,000 - 25,400

<table>
<thead>
<tr>
<th>Guhring std.</th>
<th>Type</th>
<th>Surface</th>
<th>Cutting Direction</th>
<th>Diameter Range</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>N</td>
<td>rh</td>
<td></td>
<td>3,000 - 25,400</td>
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</tbody>
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Guhring std. N  rh  3,000 - 25,400

<table>
<thead>
<tr>
<th>Guhring std.</th>
<th>Type</th>
<th>Surface</th>
<th>Cutting Direction</th>
<th>Diameter Range</th>
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**142° NC-spotting drills**

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<tbody>
<tr>
<td></td>
<td>N</td>
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Guhring std. N  rh  4,000 - 20,000

**Straight shank drills double-ended**

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<tr>
<td></td>
<td>DK 77</td>
<td>rh</td>
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Guhring std. DK 77  rh  1,500 - 10,500

**Micro-precision drills without oil feed**

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<th>Type</th>
<th>Surface</th>
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<tbody>
<tr>
<td></td>
<td>N</td>
<td>rh</td>
<td></td>
<td>0,050 - 1,920</td>
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DIN 1899 N  rh  0,050 - 1,920

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<th>DIN 1899</th>
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<td></td>
<td>N</td>
<td>lh</td>
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<td>0,130 - 1,945</td>
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DIN 1899 N  lh  0,130 - 1,945

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<tbody>
<tr>
<td></td>
<td>N</td>
<td>s</td>
<td>rh</td>
<td>0,128 - 1,900</td>
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DIN 1899 N  s  rh  0,128 - 1,900

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<td>rh</td>
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<td>0,200 - 1,400</td>
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Guhring std. N  rh  0,200 - 1,400

<table>
<thead>
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<th>Surface</th>
<th>Cutting Direction</th>
<th>Diameter Range</th>
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</thead>
<tbody>
<tr>
<td></td>
<td>N</td>
<td>rh</td>
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<td>0,800 - 3,000</td>
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Guhring std. N  rh  0,800 - 3,000

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<th>Cutting Direction</th>
<th>Diameter Range</th>
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**Micro-precision drills with oil feed**

<table>
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<tbody>
<tr>
<td></td>
<td>N</td>
<td>rh</td>
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<td>1,400 - 3,000</td>
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Guhring std. N  rh  1,400 - 3,000

**Long series twist drills**

<table>
<thead>
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<th>DIN 340</th>
<th>Type</th>
<th>Surface</th>
<th>Cutting Direction</th>
<th>Diameter Range</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>N</td>
<td>rh</td>
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<td>2,950 - 25,250</td>
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DIN 340 N  rh  2,950 - 25,250

<table>
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<th>Type</th>
<th>Surface</th>
<th>Cutting Direction</th>
<th>Diameter Range</th>
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<tbody>
<tr>
<td></td>
<td>N</td>
<td>rh</td>
<td></td>
<td>0,400 - 38,510</td>
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DIN 340 N  rh  0,400 - 38,510

<table>
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<th>Cutting Direction</th>
<th>Diameter Range</th>
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<tr>
<td></td>
<td>H</td>
<td>rh</td>
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DIN 340 H  rh  0,500 - 18,000

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<th>Diameter Range</th>
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<tr>
<td></td>
<td>N</td>
<td>s  rh</td>
<td></td>
<td>0,450 - 29,000</td>
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DIN 340 H  rh  0,450 - 29,000

<table>
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<th>Surface</th>
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<th>Diameter Range</th>
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</thead>
<tbody>
<tr>
<td></td>
<td>H</td>
<td>s  lh</td>
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<td>0,430 - 15,000</td>
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DIN 340 H  rh  0,430 - 15,000

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<th>Diameter Range</th>
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<td>N</td>
<td>s  lh</td>
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DIN 340 GT50  rh  1,000 - 14,000

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<tr>
<td></td>
<td>N</td>
<td>s  lh</td>
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<td>1,400 - 13,000</td>
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DIN 340 GT100  rh  1,400 - 13,000

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<th>Diameter Range</th>
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<td>N</td>
<td>s  lh</td>
<td></td>
<td>1,000 - 14,000</td>
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</table>

DIN 340 GT100  rh  1,000 - 14,000

### Notes

- **Tool Illustration**
- **Tool Material**
- **Guhring no.**
- **Standard**
- **Type**
- **Surface**
- **Cutting Direction**
- **Diameter Range**

**Guhring and its products**

- Straight shank twist drills
- Micro-precision drills
- Long series twist drills
- Tool illustration
- Tool material
- Guhring no.
### Straight Shank Twist Drills

<table>
<thead>
<tr>
<th>Tool Illustration</th>
<th>Tool Material</th>
<th>Guhring no.</th>
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<tbody>
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<td></td>
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<td>667</td>
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<td></td>
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<td>HSS</td>
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<td></td>
<td>Solid carbide</td>
<td>706</td>
</tr>
<tr>
<td></td>
<td>HSS</td>
<td>235</td>
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<tr>
<td></td>
<td>HSS</td>
<td>502</td>
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<td></td>
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<td>524</td>
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<tr>
<td></td>
<td>HSS</td>
<td>670</td>
</tr>
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### Long Series Twist Drills

- **DIN 340**
  - N: HSS
  - GT 100: HSS
  - Ti: HSS

### Extra Length Twist Drills, Series 1

- **DIN 1869**
  - GT 100: HSS
  - Ti: HSS

### Extra Length Twist Drills, Series 2

- **DIN 1869**
  - GT 100: HSS
  - GT 50: HSS

### Extra Length Twist Drills, Series 3

- **DIN 1869**
  - GT 100: HSS
  - Ti: HSS

### Extra Length Twist Drills

- **Guhring std.**
  - GT 100: HSS
  - 670
### Straight shank twist drills

<table>
<thead>
<tr>
<th>Tool illustration</th>
<th>Tool material</th>
<th>Guhring no.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Standard</td>
<td>Type</td>
<td>Surface</td>
</tr>
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<td></td>
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</table>

#### Extra length twist drills

<table>
<thead>
<tr>
<th>Tool illustration</th>
<th>Tool material</th>
<th>Guhring no.</th>
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</thead>
<tbody>
<tr>
<td>Guhring std.</td>
<td>GT 100</td>
<td>rh</td>
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</table>

#### Aircraft extension drills, 6 inches long

<table>
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<tr>
<th>Tool illustration</th>
<th>Tool material</th>
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<tbody>
<tr>
<td>NAS 907</td>
<td>N</td>
<td>rh</td>
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#### Aircraft extension drills, 12 inches long

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<td>rh</td>
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#### Taper pin drills

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<tr>
<td>DIN 1998</td>
<td>N</td>
<td>rh</td>
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#### Carbide tipped spade drills

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<tr>
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#### Masonry drills

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#### Bushing length twist drills

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<td>DIN 339</td>
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#### Oil feed drills

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### Kevlar drills

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</thead>
<tbody>
<tr>
<td>Guhring std.</td>
<td>N</td>
<td>rh</td>
</tr>
</tbody>
</table>

- bright
- steam tempered
- nitrided lands
- nitrided
- golden brown
- TiAlN
- TiCN
- TiCN
- TiCN
- TiCN
- TiCN
- AlCrN
- TiN
- AlTiN
- TiAlN
- MolyGlide