

Straight shank twist drills

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

Jobber drills

	HSS	205			
DIN 338	N		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		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		rh	0,600 - 16,000	
	HSS	550			
DIN 338	GT 100		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	

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

Jobber drills

	HSS	2456			
DIN 338	N		rh	1,000 - 16,000	
	HSS	2457			
DIN 338	GT 100		rh	1,000 - 15,000	
	HSCO	305			
DIN 338	N		rh	0,200 - 20,000	
	HSCO	308			
DIN 338	N		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		rh	1,000 - 16,000	
	HSCO	657			
DIN 338	Ti		rh	0,500 - 14,500	
	HSCO	658			
DIN 338	GT 100		rh	1,000 - 16,000	
	HSCO	1221			
DIN 338	GT 100		rh	3,000 - 12,000	
	HSCO	1223			
DIN 338	GT 100		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	Ti		rh	0,400 - 15,000	

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

Straight shank twist drills

Tool illustration				Tool material	Gühring 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	○	rh	0,500 - 16,000	
				Carbide	710
Gühring std.	Duro 150	○	rh	3,000 - 14,000	
				Solid carbide	732
Gühring std.	N	○	rh	1,000 - 12,000	
				Solid carbide	2464
Gühring std.	N	F	rh	1,000 - 12,000	

Stub drills

				HSS	223
DIN 1897	N	$\begin{matrix} >0 \\ 2,36 \end{matrix}$	rh	0,350 - 48,000	
				HSS	224
DIN 1897	H	○	rh	0,690 - 22,000	
				HSS	225
DIN 1897	W	○	rh	1,000 - 22,000	
				HSS	226
DIN 1897	N	$\begin{matrix} >0 \\ 2,36 \end{matrix}$	lh	0,320 - 50,000	
				HSS	227
DIN 1897	H	○	lh	0,750 - 24,000	
				HSS	228
DIN 1897	W	○	lh	1,000 - 20,000	
				HSS	552
DIN 1897	GT 80	$\begin{matrix} <0 \\ 2,36 \end{matrix}$ $\begin{matrix} >0 \\ 16,0 \end{matrix}$	rh	1,000 - 20,000	

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

Stub drills

				HSS	553
DIN 1897	GT 80	$\begin{matrix} <0 \\ 2,36 \end{matrix}$ $\begin{matrix} >0 \\ 16,0 \end{matrix}$	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	$\begin{matrix} >0 \\ 2,36 \end{matrix}$	rh	0,400 - 48,000	
				HSCO	330
DIN 1897	GV 120	$\begin{matrix} >0 \\ 2,36 \end{matrix}$	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	○	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	○	rh	1,000 - 15,870	
				HSS-E-PM	515
DIN 1897	GT 500	F	rh	1,000 - 14,000	

○ bright	● steam tempered	● nitrided lands	● nitrided	● golden brown	● TiAlN
● AlTiN	● TiCN	● FIRE	● AlCrN	● TiN	● 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
DIN 6537 K	H	● ^A	rh	3,000 - 12,000	

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	● nitrided	● golden brown	● ^A TiAlN
● ^A AlTiN	● ^C TiCN	● ^F FIRE	● ^P AlCrN	● ^S TiN	● ^M MolyGlide

Straight shank twist drills

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

120° NC-spotting drills

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

142° NC-spotting drills

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

Straight shank drills double-ended

				HSS	554	
Gühring std.	DK 77	⊙ _{2,36} ^{>0}	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	
Gühring std.	N	○	rh	0,200 - 1,400		
				Solid carbide	6400	
Gühring std.	N	Ⓐ	rh	0,800 - 3,000		
				Solid carbide	6401	
Gühring std.	N	Ⓐ	rh	0,800 - 3,000		

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

Micro-precision drills with oil feed

				Solid carbide	6408	
Gühring std.	N	Ⓐ	rh	1,400 - 3,000		
				Solid carbide	6412	
Gühring 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	⊙ _{2,36} ^{>0}	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	⊙ _{2,36} ^{>0}	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	⊙ _{2,36} ^{>0}	lh	1,400 - 13,000		
				HSS	535	
DIN 340	GT 100	⊙ _{2,36} ^{>0}	rh	1,000 - 14,000		

○ bright	● steam tempered	⊙ nitrided lands	● nitrided	● golden brown	Ⓐ TiAlN
Ⓐ AlTiN	Ⓒ TiCN	Ⓕ FIRE	⒫ AlCrN	Ⓢ TiN	Ⓜ 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	GT50	rh	2,000 - 12,700
	HSS	670	
DIN 1869	GT 100	rh	1,980 - 12,700

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

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	GT50	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	GT50	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	steam tempered	nitrided lands	nitrided	golden brown	TiAlN
AlTiN	TiCN	FIRE	AlCrN	TiN	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		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		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		rh	1,500 - 8,000	



Taper pin drills













				HSS	531
DIN 1898	N		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	


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

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









Carbide tipped spade drills

				Carbide	707
Guhring std.			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		rh	0,800 - 20,000	
				HSS	561
DIN 339	N		rh	2,400 - 5,000	
				HSS	666
DIN 339	N		rh	1,000 - 13,000	
				HSCO	311
DIN 339	N		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		rh	axial	5,000 - 20,000
				HSS	390
Guhring std.	N		rh	axial	3,000 - 13,000