

# Taper shank twist drills

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

## Short length twist drills

	HSCO	<b>363</b>			
Gühring std.	GV 120		rh	7,000 - 43,000	
	HSCO	<b>663</b>			
Gühring std.	GV 120		rh	10,500 - 31,000	
	HSCO	<b>1263</b>			
Gühring std.	VA		rh	10,000 - 30,500	

## Twist drills

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

Tool illustration				Tool material	Gühring no.
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## Twist drills

	HSCO	<b>645</b>			
DIN 345	GT 100		rh	9,520 - 39,000	
	HSCO	<b>661</b>			
DIN 345	N		rh	8,000 - 30,000	
	HSCO	<b>662</b>			
DIN 345	GT 100		rh	10,000 - 28,500	
	HSCO	<b>1222</b>			
DIN 345	GT 100		rh	10,000 - 30,160	
	HSCO	<b>1224</b>			
DIN 345	GT 100		rh	10,400 - 30,160	
	HSCO	<b>1262</b>			
DIN 345	VA		rh	10,000 - 33,000	
	HSS	<b>251</b>			
DIN 346	N		rh	10,000 - 76,000	
	HSCO	<b>351</b>			
DIN 346	N		rh	10,000 - 31,500	

## Bushing length twist drills

	HSS	<b>257</b>			
DIN 341	N		rh	2,900 - 50,000	
	HSS	<b>505</b>			
DIN 341	GT50		rh	5,500 - 29,500	
	HSS	<b>551</b>			
DIN 341	GT 100		rh	5,500 - 32,000	
	HSS	<b>655</b>			
DIN 341	N		rh	4,000 - 22,000	
	HSS	<b>656</b>			
DIN 341	GT 100		rh	6,200 - 23,000	

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

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## Bushing length twist drills

				HSCO	357
DIN 341	N	●	rh	4,750 - 44,000	
				HSCO	623
DIN 341	GT 100	● $\frac{>\varnothing}{16,0}$	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	● $\frac{>\varnothing}{16,0}$	rh	8,000 - 31,000	
				HSCO	620
DIN 1870	GT 100	● $\frac{>\varnothing}{16,0}$	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	● $\frac{>\varnothing}{16,0}$	rh	8,000 - 30,000	
				HSS	542
DIN 1870	GT50	○	rh	8,000 - 31,000	
				HSCO	621
DIN 1870	GT 100	● $\frac{>\varnothing}{16,0}$	rh	9,520 - 29,500	

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

## Extra length twist drills

				HSS	563
Guhring std.	GT 100	●	rh	6,000 - 7,500	
				HSS	566
Guhring std.	GT 100	● $\frac{>\varnothing}{16,0}$	rh	8,000 - 40,000	
				HSS	293
Guhring std.	GT 100	● $\frac{>\varnothing}{16,0}$	rh	14,000 - 40,000	
				HSS	564
Guhring std.	GT 100	●	rh	6,000 - 10,000	
				HSS	565
Guhring std.	GT 100	● $\frac{>\varnothing}{16,0}$	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    ● steam tempered    ● nitrided lands    ● nitrided    ● golden brown    ● TiAlN  
 ● AlTiN    ● TiCN    ● FIRE    ● AlCrN    ● TiN    ● MolyGlide

## Taper shank twist drills

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

### Oil feed drills short

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

### Oil feed drills, flute length to DIN 341

					HSS	1101
Gühring std.	N	●	rh	DIN 228 BK	10,000 - 32,000	

					HSS	270
Gühring std.	N	●	rh	axial	10,000 - 49,000	

					HSS	271
Gühring std.	N	●	rh	radial	10,000 - 44,450	

					HSS	272
Gühring std.	N	●	rh	radial	10,000 - 49,000	

					HSCO	370
Gühring std.	GT 100	●	rh	axial	11,000 - 34,920	

					HSCO	371
Gühring std.	GT 100	●	rh	radial	11,000 - 34,920	

					HSCO	372
Gühring std.	GT 100	●	rh	radial	12,500 - 34,000	

### Oil feed drills, flute length to DIN 1870

					HSCO	374
Gühring std.	GT 100	●	rh	axial	11,000 - 32,540	

					HSCO	375
Gühring std.	GT 100	●	rh	radial	11,000 - 34,000	

					HSCO	376
Gühring std.	GT 100	●	rh	radial	11,000 - 34,000	

## Step drills

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

### Stepped drills for centering to DIN 332

					HSS	274
Gühring std.	N	●	rh	8,000 - 40,000		

					HSS	574
Gühring std.	N	●	rh	8,000 - 40,000		

					HSS	576
Gühring std.	N	●	rh	14,000 - 40,000		

					HSS	575
Gühring std.	N	●	rh	8,000 - 20,000		

### Straight shank short step drills

					HSS	378
Gühring std.	N	○	rh	6,000 - 19,000		

					HSS	1147
Gühring std.	N	○	rh	6,600 - 21,500		

					HSS	379
Gühring std.	N	○	rh	6,000 - 18,000		

					HSS	380
Gühring 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
Gühring std.	N	●	rh	6,600 - 17,200		

					HSS	638
Gühring std.	N	●	rh	6,000 - 8,000		

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