

Taper shank twist drills

Step 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	

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

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