

GUHRING

 *Select*

**GT 500 DZ
Premium PM Cobalt
FIREX[®] Coated Drills**

• **NEW for 2011** •



**Premium quality, competitively priced
high-performance cutting tools**

GUHRING





The Tool Company

Overview and Table of Contents:








Powdered Metal Cobalt Parabolic Drills

Series	Length	Shank	Coolant	Substrate	Finish	Type	Page	
515	3xD	Straight	External	PM Cobalt	FIREX®	GT 500 DZ	6	
530	5xD	Straight	External	PM Cobalt	FIREX®	GT 500 DZ	6	




General Purpose Carbide Drills

Series	Length	Shank	Coolant	Substrate	Finish	Type	Page	
730	Stub	Straight	External	Carbide	Bright	General Purpose	8	
2463	Stub	Straight	External	Carbide	FIREX®	General Purpose	10	
732	Jobber	Straight	External	Carbide	Bright	General Purpose	8	
2464	Jobber	Straight	External	Carbide	FIREX®	General Purpose	10	

High Performance Carbide Drills

Series	Length	Shank	Coolant	Substrate	Finish	Type	Page	
5510	3xD	Reinforced	Internal	Carbide	FIREX®	RT 100 U	12	
5511	5xD	Reinforced	Internal	Carbide	FIREX®	RT 100 U	12	
5512	7xD	Reinforced	Internal	Carbide	FIREX®	RT 100 U	12	
5525	12xD	Reinforced	Internal	Carbide	nano-FIREX®	RT 100 C	16	
5514	3xD	Reinforced	External	Carbide	FIREX®	RT 100 U	14	
5515	5xD	Reinforced	External	Carbide	FIREX®	RT 100 U	14	
5518	5xD	Reinforced	External	Carbide	Bright	GS 200 G	17	

Carbide NC Spot Drills

Series	Length	Pt. angle	Coolant	Substrate	Finish		Page	
723	short	90°	External	Carbide	Bright		17	
724	short	120°	External	Carbide	Bright		17	
546	short	142°	External	Carbide	Bright		17	



Through hole / plug cobalt taps

Series	Thread-Type	Class of Fit	Standard	Chamfer Lead	Substrate	Finish	Page	
3901	UNC	2B	ANSI	B	Cobalt	bright finish	18	
3961	UNC	2B	ANSI	B	Cobalt	MolyGlide®	18	
3902	UNF	2B	ANSI	B	Cobalt	bright finish	18	
3962	UNF	2B	ANSI	B	Cobalt	MolyGlide®	18	
3900	Metric	6H	ANSI	B	Cobalt	bright finish	19	
3960	Metric	6H	ANSI	B	Cobalt	MolyGlide®	19	

Blind hole / semi-bottoming cobalt taps

Series	Thread Type	Class of Fit	Standard	Chamfer Lead	Helix	Substrate	Finish	Page	
3904	UNC	2B	ANSI	C	40° helix	Cobalt	bright finish	20	
3964	UNC	2B	ANSI	C	40° helix	Cobalt	MolyGlide®	20	
3905	UNF	2B	ANSI	C	40° helix	Cobalt	bright finish	20	
3965	UNF	2B	ANSI	C	40° helix	Cobalt	MolyGlide®	20	
3903	Metric	6H	ANSI	C	40° helix	Cobalt	bright finish	19	
3963	Metric	6H	ANSI	C	40° helix	Cobalt	MolyGlide®	19	

RF 100 U variable helix carbide end mills, center cutting, FIREX® coated

Round Shank Series	Flatted Shank Series	Standard	Length	Number of Flutes	Type	Page	
3113	3099	fractional	stub	4	universal	21	
3731		metric	stub	4	universal / reduced neck	21	
3114	3100	fractional	standard	4	universal	21	
3736	3732	metric	standard	4	universal / reduced neck	21	
3839	3871	metric	long	4	universal / reduced neck	22	
3837	3838	metric	long	4	universal / reduced neck	22	
3627		metric	extra long	4	universal / reduced neck	22	
3079		fractional	standard	4	universal / corner radius	23	
3872	3873	metric	standard	4	universal / corner radius / reduced neck	23	
3891	3892	metric	standard	3	universal / reduced neck	23	
3893	3894	metric	standard	3	universal / reduced neck / stub flute	22	

GUHRING

Select

For well over 100 years, the name Guhring has been associated with cutting tool innovation and quality. High-production facilities on every continent rely on Guhring technology to elevate their productivity, and manufacturers of high-precision parts know that Guhring provides consistent quality and performance.

Now smaller machine shops can also take advantage of Guhring's renown cutting tool expertise with **GUHRING Select**, a new category of stocked standard drills, taps and variable helix carbide end mills. This category is comprised of existing cutting tool series; current products which are already favorites in many machine shops across the United States.

Each **GUHRING Select** series has been chosen because of its versatility in a wide range of materials and machining operations, to provide you with a full compliment of quality drill, tap and end mill options at an economical price. These top-quality carbide tools will increase your productivity, and because they're **GUHRING Select**, you can **save 22% - 40% over similar style tools** by purchasing them. For the 3-man shop or the high-production facility, Guhring has a **GUHRING Select** tool which can help increase profitability.

Meet the Guhring Select family:

✓ **PM cobalt parabolic drill offering** - *performance geometry with cost-effective cobalt substrate*

Parabolic flute drills by Guhring allow you to drill deeper with fewer drill retracts, and at high feed rates. The GT 500 drill has a 130° point angle and specialized web thin for improved cutting edge strength, with FIREX® heat-resistant coating for added tool life. These drills are well-suited for common steel, alloyed heated steel, stainless steel and cast iron applications.

✓ **General purpose carbide drill offering** - *ideal for lower-volume users, extremely price sensitive*

Guhring's general purpose offering consists of a bright and a FIREX® coated version of the popular 118° point, stub and jobber length carbide drill. These are great for shops who drill a wide variety of materials such as aluminum, steel, brass and even plastics. Our carbide NC Spot drills are part of the GUHRING Select program to provide high-precision spot drill choices.

✓ **High performance carbide drill selection** - *Guhring performance at the lowest possible price*

GUHRING Select high performance drills include our popular RT100 high penetration rate series drills. These drills are offered in solid and coolant fed styles in various lengths, and they provide unmatched penetration rates and tool life. Also included is the unique 3-flute Series 5518 drill - an excellent choice for superior hole surface finish and stability in the cut.

✓ **GUHRING Select taps** - *a competitively priced high performance alternative to generic taps*

When a material specific tap is not needed the **GUHRING Select** yellow ring general purpose tap is an excellent choice. These taps are available from stock in a wide assortment of UNC, UNF and metric sizes. Choose either bright finish or our "non-stick" MolyGlide® coating for added lubricity, and you have excellent options for the job shop manufacturing environment.

✓ **Variable helix GUHRING Select carbide end mills** - *Guhring's newest family of high performance tools*

The hottest tool concept in milling is the variable helix style end mill, and Guhring has produced the widest variety of styles in the industry. Our RF100U end mill series have a universal design that can be used across a wide spectrum of workpiece materials and operations. As part of the **GUHRING Select** offering the RF100U end mill is an unbeatable value.

Go to www.guhring.com to see Guhring's full product offering. Check out Guhring Navigator to help you find the best cutting tool for your application.



Parabolic drills from Guhring -

Kick your HSS/HSCO drilling into high gear

New to the **GUHRING Select** family are the GT 500 DZ parabolic drills. Guhring's parabolic flute design has numerous advantages:

- **Reduce -- and even eliminate -- the need for chip clearing peck cycles**
- **Increased feed rates over standard high speed steel drill flute designs**
- **Chip evacuation is improved for better finished hole and part quality**
- **Reduce cycle times and improve manufacturing efficiency**



Progressive manufacturers are continually looking for ways to reduce production costs but they may be overlooking one of the most common applications: high speed steel drilling. Although a high speed steel drill is an inexpensive tool, it can actually increase the cost of manufacturing through marginal performance. Fortunately, there is an alternative. A general purpose high speed steel (HSS) or cobalt (HSCO) drill with a standard flute design can be replaced with a GT (parabolic flute) drill, and production rates and part quality can both be significantly improved.

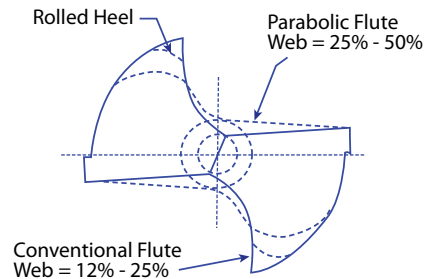
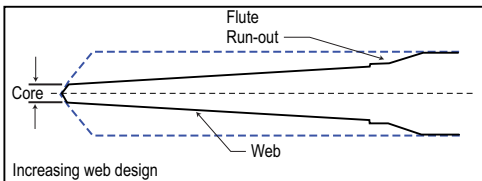


figure 1



The parabolic flute design was originally developed for deep hole drilling applications where chip packing limits the effectiveness of general purpose flute designs. Extra length drills were manufactured with a parabolic flute to increase the flute spacing by 50% and allow for maximized chip control characteristics and better coolant flow (figure 1).

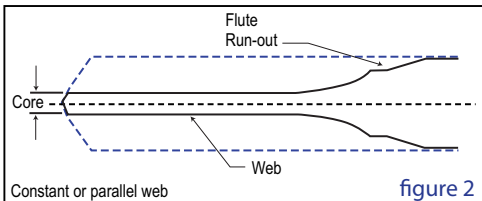


figure 2

A general purpose (Type N) flute profile incorporates an increasing web design that is tapered front to rear, which progressively reduces the flute spacing the farther the drill penetrates. The parabolic flute form has a constant web design from the front to the back of the flute (figure 2). This constant web design means that the chip space within the flute remains the same no matter how deep the drill goes. The extra flute space and constant web design reduce the need for drill retractions to clear chip packing -- known as pecking -- and allows the user to increase feed rates (figure 3). Manufacturing cycle

times are decreased along with production costs.

Guhring employs the parabolic flute style not only on extra length drills, but taper length, jobber length and even stub length tools. While other manufacturers use parabolic drills for softer, non-ferrous materials, Guhring has developed a variety of designs that improve production in not only aluminum and copper, but also cast iron, alloyed steels, unalloyed steels and stainless steels. The maximized chip evacuation and coolant delivery to the cutting zone equates to higher production rates and longer tool life at any hole depth.

GT 500 DZ

- **Replaces standard general purpose high speed steel and cobalt drills**
- **Drill stainless steel, alloyed steels, cast iron, unalloyed steels and more**
- **Unique point geometry with a GN-B web thinning**
- **Longer lasting premium powdered metal cobalt drill substrate**
- **FIREX® coating provides heat and wear resistance under higher operating temperatures**

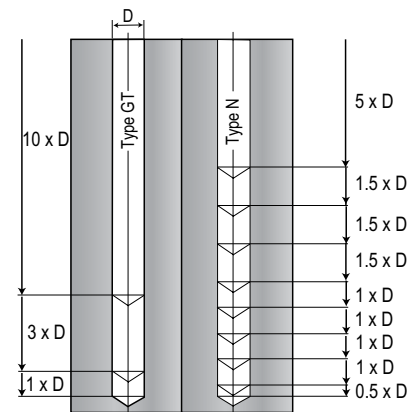


figure 3



PM Cobalt GT 500 DZ Parabolic Drills

- Powdered metal cobalt substrate is cost-effective yet durable
- Specialized Type B 130° cone relief point geometry
- Open GT 500 parabolic flute profile
- FIREX® coated for maximum heat and wear resistance
- Applications: Steels, stainless steels, alloyed or heat treated steels, and cast iron



Series 515 - Stub length (3xD)

Series 530 - Jobber length (5xD)

Dec. inch	Diameter		mm	Series 515		Series 530	
	Fract. inch	Wire / letter		Overall Length	Flute Length	Overall Length	Flute Length
0.0394			1.000	26.00	6.00	34.00	12.00
0.0402		60	1.020	26.00	6.00	34.00	12.00
0.0409		59	1.040	26.00	6.00	34.00	12.00
0.0421		58	1.070	28.00	7.00	36.00	14.00
0.0429		57	1.090	28.00	7.00	36.00	14.00
0.0433			1.100	28.00	7.00	36.00	14.00
0.0465		56	1.180	28.00	7.00	36.00	14.00
0.0469	3/64		1.190	30.00	8.00	38.00	16.00
0.0472			1.200	30.00	8.00	38.00	16.00
0.0512			1.300	30.00	8.00	38.00	16.00
0.0520		55	1.320	30.00	8.00	38.00	16.00
0.0551		54	1.400	32.00	9.00	40.00	18.00
0.0591			1.500	32.00	9.00	40.00	18.00
0.0594		53	1.510	34.00	10.00	40.00	18.00
0.0626	1/16		1.590	32.00	9.00	40.00	18.00
0.0630			1.600	34.00	10.00	43.00	20.00
0.0634		52	1.610	34.00	10.00	43.00	20.00
0.0669		51	1.700	34.00	10.00	43.00	20.00
0.0701		50	1.780	36.00	11.00	46.00	22.00
0.0709			1.800	36.00	11.00	46.00	22.00
0.0728		49	1.850	36.00	11.00	46.00	22.00
0.0748			1.900	36.00	11.00	46.00	22.00
0.0760		48	1.930	36.00	11.00	46.00	22.00
0.0780	5/64		1.980	36.00	11.00	46.00	22.00
0.0783		47	1.990	38.00	12.00	49.00	24.00
0.0787			2.000	38.00	12.00	49.00	24.00
0.0811		46	2.060	38.00	12.00	49.00	24.00
0.0819		45	2.080	38.00	12.00	49.00	24.00
0.0827			2.100	38.00	12.00	49.00	24.00
0.0858		44	2.180	40.00	13.00	53.00	27.00
0.0866			2.200	40.00	13.00	53.00	27.00
0.0890		43	2.260	40.00	13.00	53.00	27.00
0.0906			2.300	40.00	13.00	53.00	27.00
0.0933		42	2.370	43.00	14.00	57.00	30.00
0.0937	3/32		2.380	43.00	14.00	57.00	30.00
0.0945			2.400	43.00	14.00	57.00	30.00
0.0961		41	2.440	43.00	14.00	57.00	30.00
0.0980		40	2.490	43.00	14.00	57.00	30.00
0.0984			2.500	43.00	14.00	57.00	30.00
0.0996		39	2.530	43.00	14.00	57.00	30.00
0.1016		38	2.580	43.00	14.00	57.00	30.00
0.1024			2.600	43.00	14.00	57.00	30.00
0.1039		37	2.640	43.00	14.00	57.00	30.00
0.1063			2.700	46.00	16.00	61.00	33.00
0.1067		36	2.710	46.00	16.00	61.00	33.00
0.1094	7/64		2.780	46.00	16.00	61.00	33.00
0.1098		35	2.790	46.00	16.00	61.00	33.00
0.1102			2.800	46.00	16.00	61.00	33.00
0.1110		34	2.820	46.00	16.00	61.00	33.00
0.1130		33	2.870	46.00	16.00	61.00	33.00
0.1142			2.900	46.00	16.00	61.00	33.00
0.1161		32	2.950	46.00	16.00	61.00	33.00
0.1181			3.000	46.00	16.00	61.00	33.00
0.1201		31	3.050	49.00	18.00	65.00	36.00
0.1220			3.100	49.00	18.00	65.00	36.00
0.1248	1/8		3.170	49.00	18.00	65.00	36.00
0.1260			3.200	49.00	18.00	65.00	36.00

Dec. inch	Diameter		mm	Series 515		Series 530	
	Fract. inch	Wire / letter		Overall Length	Flute Length	Overall Length	Flute Length
0.1283		30	3.260	49.00	18.00	65.00	36.00
0.1299			3.300	49.00	18.00	65.00	36.00
0.1339			3.400	52.00	20.00	70.00	39.00
0.1358		29	3.450	52.00	20.00	70.00	39.00
0.1378			3.500	52.00	20.00	70.00	39.00
0.1406	9/64	28	3.570	52.00	20.00	70.00	39.00
0.1417			3.600	52.00	20.00	70.00	39.00
0.1441		27	3.660	52.00	20.00	70.00	39.00
0.1457			3.700	52.00	20.00	70.00	39.00
0.1469		26	3.730	52.00	20.00	70.00	39.00
0.1496		25	3.800	55.00	22.00	75.00	43.00
0.1520		24	3.860	55.00	22.00	75.00	43.00
0.1535			3.900	55.00	22.00	75.00	43.00
0.1539		23	3.910	55.00	22.00	75.00	43.00
0.1563	5/32		3.970	55.00	22.00	75.00	43.00
0.1571		22	3.990	55.00	22.00	75.00	43.00
0.1575			4.000	55.00	22.00	75.00	43.00
0.1591		21	4.040	55.00	22.00	75.00	43.00
0.1610		20	4.090	55.00	22.00	75.00	43.00
0.1614			4.100	55.00	22.00	75.00	43.00
0.1654			4.200	55.00	22.00	75.00	43.00
0.1661		19	4.220	55.00	22.00	75.00	43.00
0.1693		18	4.300	58.00	24.00	80.00	47.00
0.1720	11/64		4.370	58.00	24.00	80.00	47.00
0.1728		17	4.390	58.00	24.00	80.00	47.00
0.1732			4.400	58.00	24.00	80.00	47.00
0.1772		16	4.500	58.00	24.00	80.00	47.00
0.1799		15	4.570	58.00	24.00	80.00	47.00
0.1811			4.600	58.00	24.00	80.00	47.00
0.1819		14	4.620	58.00	24.00	80.00	47.00
0.1850		13	4.700	58.00	24.00	80.00	47.00
0.1874	3/16		4.760	62.00	26.00	86.00	52.00
0.1890		12	4.800	62.00	26.00	86.00	52.00
0.1909		11	4.850	62.00	26.00	86.00	52.00
0.1929			4.900	62.00	26.00	86.00	52.00
0.1937		10	4.920	62.00	26.00	86.00	52.00
0.1961		9	4.980	62.00	26.00	86.00	52.00
0.1969			5.000	62.00	26.00	86.00	52.00
0.1992		8	5.060	62.00	26.00	86.00	52.00
0.2008			5.100	62.00	26.00	86.00	52.00
0.2012		7	5.110	62.00	26.00	86.00	52.00
0.2031	13/64		5.160	62.00	26.00	86.00	52.00
0.2039		6	5.180	62.00	26.00	86.00	52.00
0.2047			5.200	62.00	26.00	86.00	52.00
0.2055		5	5.220	62.00	26.00	86.00	52.00
0.2087			5.300	62.00	26.00	86.00	52.00
0.2091		4	5.310	66.00	28.00	93.00	57.00
0.2126			5.400	66.00	28.00	93.00	57.00
0.2130		3	5.410	66.00	28.00	93.00	57.00
0.2165			5.500	66.00	28.00	93.00	57.00
0.2189	7/32		5.560	66.00	28.00	93.00	57.00
0.2205			5.600	66.00	28.00	93.00	57.00
0.2209		2	5.610	66.00	28.00	93.00	57.00
0.2244			5.700	66.00	28.00	93.00	57.00
0.2280		1	5.790	66.00	28.00	93.00	57.00
0.2283			5.800	66.00	28.00	93.00	57.00
0.2323			5.900	66.00	28.00	93.00	57.00



Dec. inch	Diameter			Series 515		Series 530	
	Fract. inch	Wire / letter	mm	Overall Length	Flute Length	Overall Length	Flute Length
0.2339		A	5.940	66.00	28.00	93.00	57.00
0.2343	15/64		5.950	66.00	28.00	93.00	57.00
0.2362			6.000	66.00	28.00	93.00	57.00
0.2378		B	6.040	70.00	31.00	101.00	63.00
0.2402			6.100	70.00	31.00	101.00	63.00
0.2421		C	6.150	70.00	31.00	101.00	63.00
0.2441			6.200	70.00	31.00	101.00	63.00
0.2461		D	6.250	70.00	31.00	101.00	63.00
0.2480			6.300	70.00	31.00	101.00	63.00
0.2500	1/4	E	6.350	70.00	31.00	101.00	63.00
0.2520			6.400	70.00	31.00	101.00	63.00
0.2559			6.500	70.00	31.00	101.00	63.00
0.2571		F	6.530	70.00	31.00	101.00	63.00
0.2598			6.600	70.00	31.00	101.00	63.00
0.2610		G	6.630	70.00	31.00	101.00	63.00
0.2638			6.700	70.00	31.00	101.00	63.00
0.2657	17/64		6.750	70.00	31.00	101.00	63.00
0.2677			6.800	74.00	34.00	109.00	69.00
0.2717		I	6.900	74.00	34.00	109.00	69.00
0.2756			7.000	74.00	34.00	109.00	69.00
0.2768		J	7.030	74.00	34.00	109.00	69.00
0.2795			7.100	74.00	34.00	109.00	69.00
0.2811	9/32	K	7.140	74.00	34.00	109.00	69.00
0.2835			7.200	74.00	34.00	109.00	69.00
0.2874			7.300	74.00	34.00	109.00	69.00
0.2902		L	7.370	74.00	34.00	109.00	69.00
0.2913			7.400	74.00	34.00	109.00	69.00
0.2949		M	7.490	74.00	34.00	109.00	69.00
0.2953			7.500	74.00	34.00	109.00	69.00
0.2969	19/64		7.540	74.00	34.00	109.00	69.00
0.2992			7.600	79.00	37.00	117.00	75.00
0.3020		N	7.670	79.00	37.00	117.00	75.00
0.3031			7.700	79.00	37.00	117.00	75.00
0.3071			7.800	79.00	37.00	117.00	75.00
0.3110			7.900	79.00	37.00	117.00	75.00
0.3126	5/16		7.940	79.00	37.00	117.00	75.00
0.3150			8.000	79.00	37.00	117.00	75.00
0.3161		O	8.030	79.00	37.00	117.00	75.00
0.3189			8.100	79.00	37.00	117.00	75.00
0.3228		P	8.200	79.00	37.00	117.00	75.00
0.3268			8.300	79.00	37.00	117.00	75.00
0.3280	21/64		8.330	79.00	37.00	117.00	75.00
0.3307			8.400	79.00	37.00	117.00	75.00
0.3319		Q	8.430	79.00	37.00	117.00	75.00
0.3346			8.500	79.00	37.00	117.00	75.00
0.3386			8.600	84.00	40.00		
0.3390		R	8.610	84.00	40.00	125.00	81.00
0.3425			8.700	84.00	40.00		

Dec. inch	Diameter			Series 515		Series 530	
	Fract. inch	Wire / letter	mm	Overall Length	Flute Length	Overall Length	Flute Length
0.3437	11/32		8.730	84.00	40.00	125.00	81.00
0.3465			8.800	84.00	40.00	125.00	81.00
0.3480		S	8.840	84.00	40.00	125.00	81.00
0.3504			8.900	84.00	40.00	125.00	81.00
0.3543			9.000	84.00	40.00	125.00	81.00
0.3579		T	9.090	84.00	40.00	125.00	81.00
0.3583			9.100	84.00	40.00	125.00	81.00
0.3594	23/64		9.130	84.00	40.00	125.00	81.00
0.3622			9.200	84.00	40.00	125.00	81.00
0.3661			9.300	84.00	40.00	125.00	81.00
0.3677		U	9.340	84.00	40.00	125.00	81.00
0.3681			9.350	84.00	40.00		
0.3701			9.400	84.00	40.00	125.00	81.00
0.3740			9.500	84.00	40.00	125.00	81.00
0.3748	3/8		9.520	84.00	40.00	125.00	81.00
0.3772		V	9.580	89.00	43.00	133.00	87.00
0.3780			9.600	84.00	40.00	133.00	87.00
0.3819			9.700	84.00	40.00	133.00	87.00
0.3858		W	9.800	89.00	43.00	133.00	87.00
0.3898			9.900	84.00	40.00	133.00	87.00
0.3906	25/64		9.920	89.00	43.00	133.00	87.00
0.3937			10.000	89.00	43.00	133.00	87.00
0.3969		X	10.080	89.00	43.00	133.00	87.00
0.4016			10.200	89.00	43.00	133.00	87.00
0.4039		Y	10.260	89.00	43.00	133.00	87.00
0.4063	13/32		10.320	89.00	43.00	133.00	87.00
0.4130		Z	10.490	89.00	43.00	133.00	87.00
0.4134			10.500	89.00	43.00	133.00	87.00
0.4220	27/64		10.720	89.00	43.00	133.00	87.00
0.4331			11.000	95.00	47.00	142.00	94.00
0.4374	7/16		11.110	95.00	47.00	142.00	94.00
0.4528			11.500	95.00	47.00	142.00	94.00
0.4531	29/64		11.510	84.00	40.00	142.00	94.00
0.4646			11.800	84.00	40.00		
0.4689	15/32		11.910	95.00	47.00	151.00	101.00
0.4724			12.000	102.00	51.00	151.00	101.00
0.4843	31/64		12.300	102.00	51.00	151.00	101.00
0.4921			12.500	102.00	51.00	151.00	101.00
0.5000	1/2		12.700	102.00	51.00	151.00	101.00
0.5118			13.000	102.00	51.00	151.00	101.00
0.5157	33/64		13.100	102.00	51.00	151.00	101.00
0.5311	17/32		13.490	107.00	54.00	160.00	108.00
0.5315			13.500	107.00	54.00	160.00	108.00
0.5512			14.000	107.00	54.00	160.00	108.00
0.5626	9/16		14.290	111.00	56.00	169.00	114.00

Shank Diameter info, Series 515, 530: Cutting dia. = shank dia.

Application alternatives:

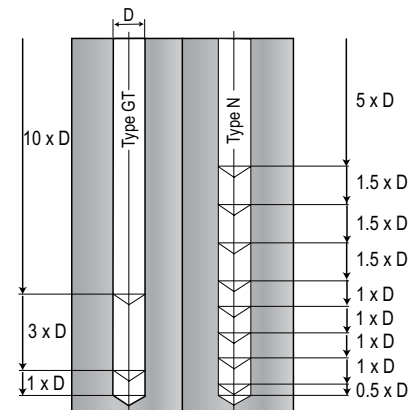


Series 5521 - GT500, stub length PM cobalt drill, 130° point, straight shank, TiN coated, diameters from 1.0 - 13.0 mm.

Series 658 - GT100, jobber length cobalt drill, 130° point, straight shank, TiN coated, diameters from 1.0-13.0 mm.

Parabolic vs. Standard Flute

- Reduce or eliminate peck cycles
- Run higher chip loads at deeper depths for faster drilling
- Improve chip evacuation and increase tool life





General Purpose Carbide Drills

- Longer tool life than cobalt drills, plus more accurate hole size & location
- Sub micro-grain carbide for added toughness
- 118° faceted point, straight shank
- h7 tolerance on drill diameter
- Bright finish
- Applications: Universal

Series 730 - Stub length (3xD)

Series 732 - Jobber length (5xD)



Diameter				Series 730		Series 732	
Dec. inch	Fract. inch	Wire / letter	mm	Overall Length mm	Flute Length mm	Overall Length mm	Flute Length mm
0.0197			0.500	20.00	3.00		
0.0236			0.600	21.00	3.50		
0.0276			0.700	23.00	4.50		
0.0315			0.800	24.00	5.00		
0.0354			0.900	25.00	5.50		
0.0394			1.000	26.00	6.00	34.00	12.00
0.0402		60	1.020	26.00	6.00	34.00	12.00
0.0409		59	1.040	26.00	6.00	34.00	12.00
0.0421		58	1.070	28.00	7.00	36.00	14.00
0.0429		57	1.090	28.00	7.00	36.00	14.00
0.0433			1.100	28.00	7.00	36.00	14.00
0.0465		56	1.180	28.00	7.00	36.00	14.00
0.0469	3/64		1.190	28.00	7.00	38.00	16.00
0.0472			1.200	28.00	7.00	38.00	16.00
0.0512			1.300	28.00	7.00	38.00	16.00
0.0520		55	1.320	30.00	8.00	38.00	16.00
0.0551		54	1.400	32.00	9.00	40.00	18.00
0.0591			1.500	32.00	9.00	40.00	18.00
0.0594		53	1.510	34.00	10.00	40.00	18.00
0.0626	1/16		1.590	34.00	10.00	40.00	18.00
0.0630			1.600	34.00	10.00	43.00	20.00
0.0634		52	1.610	34.00	10.00	43.00	20.00
0.0669		51	1.700	34.00	10.00	43.00	20.00
0.0701		50	1.780	36.00	11.00	46.00	22.00
0.0709			1.800	36.00	11.00	46.00	22.00
0.0728		49	1.850	36.00	11.00	46.00	22.00
0.0748			1.900	36.00	11.00	46.00	22.00
0.0760		48	1.930	38.00	12.00	49.00	24.00
0.0781	5/64		1.980	38.00	12.00	49.00	24.00
0.0783		47	1.990	38.00	12.00	49.00	24.00
0.0787			2.000	38.00	12.00	49.00	24.00
0.0811		46	2.060	38.00	12.00	49.00	24.00
0.0819		45	2.080	38.00	12.00	49.00	24.00
0.0827			2.100	38.00	12.00	49.00	24.00
0.0858		44	2.180	40.00	13.00	53.00	27.00
0.0866			2.200	40.00	13.00	53.00	27.00
0.0886			2.250	40.00	13.00		
0.0890		43	2.260	40.00	13.00	53.00	27.00
0.0906			2.300	40.00	13.00	53.00	27.00
0.0933		42	2.370	43.00	14.00	57.00	30.00
0.0938	3/32		2.380	43.00	14.00	57.00	30.00
0.0945			2.400	43.00	14.00	57.00	30.00
0.0961		41	2.440	43.00	14.00	57.00	30.00
0.0980		40	2.490	43.00	14.00	57.00	30.00
0.0984			2.500	43.00	14.00	57.00	30.00
0.0996		39	2.530	43.00	14.00	57.00	30.00
0.1016		38	2.580	43.00	14.00	57.00	30.00
0.1024			2.600	43.00	14.00	57.00	30.00
0.1039		37	2.640	43.00	14.00	57.00	30.00
0.1063			2.700	46.00	16.00	61.00	33.00
0.1067		36	2.710	46.00	16.00	61.00	33.00
0.1094	7/64		2.780	46.00	16.00	61.00	33.00
0.1098		35	2.790	46.00	16.00	61.00	33.00
0.1102			2.800	46.00	16.00	61.00	33.00
0.1110		34	2.820	46.00	16.00	61.00	33.00
0.1130		33	2.870	46.00	16.00	61.00	33.00
0.1142			2.900	46.00	16.00	61.00	33.00
0.1161		32	2.950	46.00	16.00	61.00	33.00
0.1181			3.000	46.00	16.00	61.00	33.00
0.1200			3.050	49.00	18.00	65.00	36.00

Diameter				Series 730		Series 732	
Dec. inch	Fract. inch	Wire / letter	mm	Overall Length mm	Flute Length mm	Overall Length mm	Flute Length mm
0.1220			3.100	49.00	18.00	65.00	36.00
0.1248	1/8		3.170	49.00	18.00	65.00	36.00
0.1260			3.200	49.00	18.00	65.00	36.00
0.1283		30	3.260	49.00	18.00	65.00	36.00
0.1299			3.300	49.00	18.00	65.00	36.00
0.1339			3.400	52.00	20.00	70.00	39.00
0.1360		29	3.450	52.00	20.00	70.00	39.00
0.1378			3.500	52.00	20.00	70.00	39.00
0.1406	9/64		3.570	52.00	20.00	70.00	39.00
0.1417			3.600	52.00	20.00	70.00	39.00
0.1441		27	3.660	52.00	20.00	70.00	39.00
0.1457			3.700	52.00	20.00	70.00	39.00
0.1469		26	3.730	52.00	20.00	70.00	39.00
0.1496		25	3.800	55.00	22.00	75.00	43.00
0.1520		24	3.860	55.00	22.00	75.00	43.00
0.1535			3.900	55.00	22.00	75.00	43.00
0.1539		23	3.910	55.00	22.00	75.00	43.00
0.1562	5/32		3.970	55.00	22.00	75.00	43.00
0.1571		22	3.990	55.00	22.00	75.00	43.00
0.1575			4.000	55.00	22.00	75.00	43.00
0.1591		21	4.040	55.00	22.00	75.00	43.00
0.1610		20	4.090	55.00	22.00	75.00	43.00
0.1614			4.100	55.00	22.00	75.00	43.00
0.1654			4.200	55.00	22.00	75.00	43.00
0.1661		19	4.220	55.00	22.00	75.00	43.00
0.1693		18	4.300	58.00	24.00	80.00	47.00
0.1719	11/64		4.370	58.00	24.00	80.00	47.00
0.1730		17	4.390	58.00	24.00	80.00	47.00
0.1732			4.400	58.00	24.00	80.00	47.00
0.1772		16	4.500	58.00	24.00	80.00	47.00
0.1799		15	4.570	58.00	24.00	80.00	47.00
0.1811			4.600	58.00	24.00	80.00	47.00
0.1819		14	4.620	58.00	24.00	80.00	47.00
0.1850		13	4.700	58.00	24.00	80.00	47.00
0.1875	3/16		4.760	62.00	26.00	86.00	52.00
0.1890		12	4.800	62.00	26.00	86.00	52.00
0.1910		11	4.850	62.00	26.00	86.00	52.00
0.1929			4.900	62.00	26.00	86.00	52.00
0.1935		10	4.920	62.00	26.00	86.00	52.00
0.1961		9	4.980	62.00	26.00	86.00	52.00
0.1969			5.000	62.00	26.00	86.00	52.00
0.1992		8	5.060	62.00	26.00	86.00	52.00
0.2008			5.100	62.00	26.00	86.00	52.00
0.2012		7	5.110	62.00	26.00	86.00	52.00
0.2031	13/64		5.160	62.00	26.00	86.00	52.00
0.2039		6	5.180	62.00	26.00	86.00	52.00
0.2047			5.200	62.00	26.00	86.00	52.00
0.2055		5	5.220	62.00	26.00	86.00	52.00
0.2087			5.300	62.00	26.00	86.00	52.00
0.2091		4	5.310	66.00	28.00	93.00	57.00
0.2126			5.400	66.00	28.00	93.00	57.00
0.2130		3	5.410	66.00	28.00	93.00	57.00
0.2165			5.500	66.00	28.00	93.00	57.00
0.2188	7/32		5.560	66.00	28.00	93.00	57.00
0.2205			5.600	66.00	28.00	93.00	57.00
0.2205		2	5.610	66.00	28.00	93.00	57.00
0.2244			5.700	66.00	28.00	93.00	57.00
0.2280		1	5.790	66.00	28.00	93.00	57.00
0.2283			5.800	66.00	28.00	93.00	57.00
0.2323			5.900	66.00	28.00	93.00	57.00



Diameter				Series 730		Series 732	
Dec. inch	Fract. inch	Wire / letter	mm	Overall Length mm	Flute Length mm	Overall Length mm	Flute Length mm
0.2338			5.940	66.00	28.00	93.00	57.00
0.2344	15/64		5.950	66.00	28.00	93.00	57.00
0.2362			6.000	66.00	28.00	93.00	57.00
0.2377			6.040	70.00	31.00	101.00	63.00
0.2402			6.100	70.00	31.00	101.00	63.00
0.2421		C	6.150	70.00	31.00	101.00	63.00
0.2441			6.200	70.00	31.00	101.00	63.00
0.2461		D	6.250	70.00	31.00	101.00	63.00
0.2480			6.300	70.00	31.00	101.00	63.00
0.2500	1/4	E	6.350	70.00	31.00	101.00	63.00
0.2520			6.400	70.00	31.00	101.00	63.00
0.2559			6.500	70.00	31.00	101.00	63.00
0.2570			6.530	70.00	31.00	101.00	63.00
0.2598			6.600	70.00	31.00	101.00	63.00
0.2610		G	6.630	70.00	31.00	101.00	63.00
0.2638			6.700	74.00	34.00	101.00	63.00
0.2657	17/64	H	6.750	74.00	34.00	109.00	69.00
0.2677			6.800	74.00	34.00	109.00	69.00
0.2717		I	6.900	74.00	34.00	109.00	69.00
0.2756			7.000	74.00	34.00	109.00	69.00
0.2768		J	7.030	74.00	34.00	109.00	69.00
0.2795			7.100	74.00	34.00	109.00	69.00
0.2812	9/32		7.140	74.00	34.00	109.00	69.00
0.2835			7.200	74.00	34.00	109.00	69.00
0.2874			7.300	74.00	34.00	109.00	69.00
0.2902		L	7.370	74.00	34.00	109.00	69.00
0.2913			7.400	74.00	34.00	109.00	69.00
0.2949		M	7.490	74.00	34.00	109.00	69.00
0.2953			7.500	74.00	34.00	109.00	69.00
0.2969	19/64		7.540	79.00	37.00	117.00	75.00
0.2992			7.600	79.00	37.00	117.00	75.00
0.3019			7.670	79.00	37.00	117.00	75.00
0.3031			7.700	79.00	37.00	117.00	75.00
0.3071			7.800	79.00	37.00	117.00	75.00
0.3110			7.900	79.00	37.00	117.00	75.00
0.3126	5/16		7.940	79.00	37.00	117.00	75.00
0.3150			8.000	79.00	37.00	117.00	75.00
0.3161		O	8.030	79.00	37.00	117.00	75.00
0.3189			8.100	79.00	37.00	117.00	75.00
0.3228		P	8.200	79.00	37.00	117.00	75.00
0.3268			8.300	79.00	37.00	117.00	75.00
0.3281	21/64		8.330	79.00	37.00	117.00	75.00
0.3307			8.400	79.00	37.00	117.00	75.00
0.3319		Q	8.430	79.00	37.00	117.00	75.00
0.3346			8.500	79.00	37.00	117.00	75.00
0.3386			8.600	84.00	40.00	125.00	81.00
0.3390		R	8.610	84.00	40.00	125.00	81.00
0.3425			8.700	84.00	40.00	125.00	81.00

Diameter				Series 730		Series 732	
Dec. inch	Fract. inch	Wire / letter	mm	Overall Length mm	Flute Length mm	Overall Length mm	Flute Length mm
0.3438	11/32		8.730	84.00	40.00	125.00	81.00
0.3465			8.800	84.00	40.00	125.00	81.00
0.3480		S	8.840	84.00	40.00	125.00	81.00
0.3504			8.900	84.00	40.00	125.00	81.00
0.3543			9.000	84.00	40.00	125.00	81.00
0.3578			9.090	84.00	40.00	125.00	81.00
0.3583			9.100	84.00	40.00	125.00	81.00
0.3594	23/64		9.130	84.00	40.00	125.00	81.00
0.3622			9.200	84.00	40.00	125.00	81.00
0.3661			9.300	84.00	40.00	125.00	81.00
0.3677		U	9.340	84.00	40.00	125.00	81.00
0.3701			9.400	84.00	40.00	125.00	81.00
0.3740			9.500	84.00	40.00	125.00	81.00
0.3748	3/8		9.520	89.00	43.00	133.00	87.00
0.3772		V	9.580	89.00	43.00	133.00	87.00
0.3780			9.600	89.00	43.00	133.00	87.00
0.3819			9.700	89.00	43.00	133.00	87.00
0.3858		W	9.800	89.00	43.00	133.00	87.00
0.3898			9.900	89.00	43.00	133.00	87.00
0.3906	25/64		9.920	89.00	43.00	133.00	87.00
0.3937			10.000	89.00	43.00	133.00	87.00
0.3969		X	10.080	89.00	43.00	133.00	87.00
0.4016			10.200	89.00	43.00	133.00	87.00
0.4039		Y	10.260	89.00	43.00	133.00	87.00
0.4055			10.300	89.00	43.00	133.00	87.00
0.4063	13/32		10.320	89.00	43.00	133.00	87.00
0.4130		Z	10.490	89.00	43.00	133.00	87.00
0.4134			10.500	89.00	43.00	133.00	87.00
0.4220	27/64		10.720	95.00	47.00	142.00	94.00
0.4331			11.000	95.00	47.00	142.00	94.00
0.4375	7/16		11.110	95.00	47.00	142.00	94.00
0.4528			11.500	95.00	47.00	142.00	94.00
0.4531	29/64		11.510	95.00	47.00	142.00	94.00
0.4688	15/32		11.910	102.00	51.00	151.00	101.00
0.4724			12.000	102.00	51.00	151.00	101.00
0.4844	31/64		12.300	102.00	51.00	151.00	101.00
0.5000	1/2		12.700	102.00	51.00	151.00	101.00
0.5118			13.000	102.00	51.00		
0.5311	17/32		13.490	107.00	54.00		
0.5512			14.000	107.00	54.00		
0.5626	9/16		14.290	111.00	56.00		
0.5906			15.000	111.00	56.00		
0.6248	5/8		15.870	115.00	58.00		
0.6299			16.000	115.00	58.00		

Shank Diameter info, Series 730, 732: Cutting dia. = shank dia.

Application alternatives:



Series 658 - GT100, jobber length cobalt drill, 130° point, straight shank, TiN coated, diameters from 1.0 - 13.0 mm.

Series 659 - GV120 stub length heavy duty cobalt drill, 130° point, straight shank, TiN coated, diameters from 0.5-15.5 mm.

Detailed information and additional drill options can be found in our full-line drill catalog, or by contacting Tech Support at (800) 776-6170. Product information is also available on our website www.guhring.com on the Products & Services tab.





FIREX® Coated General Purpose Carbide Drills

- Longer tool life than cobalt drills, plus more accurate hole size & location
- FIREX® coated for added heat & abrasion resistance
- Sub micro-grain carbide for added toughness
- 118° faceted point, straight shank
- h7 tolerance on diameter
- Applications: Steel, alloyed steel, cast iron

Series 2463 - Stub length (3xD)

Series 2464 - Jobber length (5xD)



Diameter				Series 2463		Series 2464	
Dec. inch	Fract. inch	Wire / letter	mm	Overall Length mm	Flute Length mm	Overall Length mm	Flute Length mm
0.0394			1.000	26.00	6.00	34.00	12.00
0.0402		60	1.020	26.00	6.00	34.00	12.00
0.0409		59	1.040	26.00	6.00	34.00	12.00
0.0421		58	1.070	28.00	7.00	36.00	14.00
0.0429		57	1.090	28.00	7.00	36.00	14.00
0.0433			1.100	28.00	7.00	36.00	14.00
0.0465		56	1.180	28.00	7.00	36.00	14.00
0.0469	3/64		1.190	30.00	8.00	36.00	14.00
0.0472			1.200	30.00	8.00	38.00	16.00
0.0512			1.300	30.00	8.00	38.00	16.00
0.0520		55	1.320	30.00	8.00	38.00	16.00
0.0551		54	1.400	32.00	9.00	40.00	18.00
0.0591			1.500	32.00	9.00	40.00	18.00
0.0594		53	1.510	34.00	10.00	43.00	20.00
0.0626	1/16		1.590	34.00	10.00	43.00	20.00
0.0630			1.600	34.00	10.00	43.00	20.00
0.0634		52	1.610	34.00	10.00	43.00	20.00
0.0669		51	1.700	34.00	10.00	43.00	20.00
0.0701		50	1.780	36.00	11.00	46.00	22.00
0.0709			1.800	36.00	11.00	46.00	22.00
0.0728		49	1.850	36.00	11.00	46.00	22.00
0.0748			1.900	36.00	11.00	46.00	22.00
0.0760		48	1.930	38.00	12.00	49.00	24.00
0.0780	5/64		1.980	38.00	12.00	49.00	24.00
0.0783		47	1.990	38.00	12.00	49.00	24.00
0.0787			2.000	38.00	12.00	49.00	24.00
0.0811		46	2.060	38.00	12.00	49.00	24.00
0.0819		45	2.080	38.00	12.00	49.00	24.00
0.0827			2.100	38.00	12.00	49.00	24.00
0.0858		44	2.180	40.00	13.00	53.00	27.00
0.0866			2.200	40.00	13.00	53.00	27.00
0.0885			2.250	40.00	13.00	53.00	27.00
0.0890		43	2.260	40.00	13.00	53.00	27.00
0.0906			2.300	40.00	13.00	53.00	27.00
0.0933		42	2.370	43.00	14.00	57.00	30.00
0.0937	3/32		2.380	43.00	14.00	57.00	30.00
0.0945			2.400	43.00	14.00	57.00	30.00
0.0961		41	2.440	43.00	14.00	57.00	30.00
0.0980		40	2.490	43.00	14.00	57.00	30.00
0.0984			2.500	43.00	14.00	57.00	30.00
0.0996		39	2.530	43.00	14.00	57.00	30.00
0.1016		38	2.580	43.00	14.00	57.00	30.00
0.1024			2.600	43.00	14.00	57.00	30.00
0.1039		37	2.640	43.00	14.00	57.00	30.00
0.1063			2.700	46.00	16.00	61.00	33.00
0.1067		36	2.710	46.00	16.00	61.00	33.00
0.1094	7/64		2.780	46.00	16.00	61.00	33.00
0.1098		35	2.790	46.00	16.00	61.00	33.00
0.1102			2.800	46.00	16.00	61.00	33.00
0.1110		34	2.820	46.00	16.00	61.00	33.00
0.1130		33	2.870	46.00	16.00	61.00	33.00
0.1142			2.900	46.00	16.00	61.00	33.00
0.1161		32	2.950	46.00	16.00	61.00	33.00
0.1181			3.000	46.00	16.00	61.00	33.00
0.1201		31	3.050	49.00	18.00	65.00	36.00
0.1220			3.100	49.00	18.00	65.00	36.00
0.1248	1/8		3.170	49.00	18.00	65.00	36.00
0.1260			3.200	49.00	18.00	65.00	36.00
0.1283		30	3.260	49.00	18.00	65.00	36.00
0.1299			3.300	49.00	18.00	65.00	36.00

Diameter				Series 2463		Series 2464	
Dec. inch	Fract. inch	Wire / letter	mm	Overall Length mm	Flute Length mm	Overall Length mm	Flute Length mm
0.1339			3.400	52.00	20.00	70.00	39.00
0.1358		29	3.450	52.00	20.00	70.00	39.00
0.1378			3.500	52.00	20.00	70.00	39.00
0.1406	9/64	28	3.570	52.00	20.00	70.00	39.00
0.1417			3.600	52.00	20.00	70.00	39.00
0.1441		27	3.660	52.00	20.00	70.00	39.00
0.1457			3.700	52.00	20.00	70.00	39.00
0.1469		26	3.730	52.00	20.00	70.00	39.00
0.1496		25	3.800	55.00	22.00	75.00	43.00
0.1520		24	3.860	55.00	22.00	75.00	43.00
0.1535			3.900	55.00	22.00	75.00	43.00
0.1539		23	3.910	55.00	22.00	75.00	43.00
0.1563	5/32		3.970	55.00	22.00	75.00	43.00
0.1571		22	3.990	55.00	22.00	75.00	43.00
0.1575			4.000	55.00	22.00	75.00	43.00
0.1591		21	4.040	55.00	22.00	75.00	43.00
0.1610		20	4.090	55.00	22.00	75.00	43.00
0.1614			4.100	55.00	22.00	75.00	43.00
0.1654			4.200	55.00	22.00	75.00	43.00
0.1661		19	4.220	55.00	22.00	75.00	43.00
0.1693		18	4.300	58.00	24.00	80.00	47.00
0.1720	11/64		4.370	58.00	24.00	80.00	47.00
0.1728		17	4.390	58.00	24.00	80.00	47.00
0.1732			4.400	58.00	24.00	80.00	47.00
0.1772		16	4.500	58.00	24.00	80.00	47.00
0.1799		15	4.570	58.00	24.00	80.00	47.00
0.1811			4.600	58.00	24.00	80.00	47.00
0.1819		14	4.620	58.00	24.00	80.00	47.00
0.1850		13	4.700	58.00	24.00	80.00	47.00
0.1874	3/16		4.760	62.00	26.00	86.00	52.00
0.1890		12	4.800	62.00	26.00	86.00	52.00
0.1909		11	4.850	62.00	26.00	86.00	52.00
0.1929			4.900	62.00	26.00	86.00	52.00
0.1937		10	4.920	62.00	26.00	86.00	52.00
0.1961		9	4.980	62.00	26.00	86.00	52.00
0.1969			5.000	62.00	26.00	86.00	52.00
0.1992		8	5.060	62.00	26.00	86.00	52.00
0.2008			5.100	62.00	26.00	86.00	52.00
0.2012		7	5.110	62.00	26.00	86.00	52.00
0.2031	13/64		5.160	62.00	26.00	86.00	52.00
0.2039		6	5.180	62.00	26.00	86.00	52.00
0.2047			5.200	62.00	26.00	86.00	52.00
0.2055		5	5.220	62.00	26.00	86.00	52.00
0.2087			5.300	62.00	26.00	86.00	52.00
0.2091		4	5.310	66.00	28.00	93.00	57.00
0.2126			5.400	66.00	28.00	93.00	57.00
0.2130		3	5.410	66.00	28.00	93.00	57.00
0.2165			5.500	66.00	28.00	93.00	57.00
0.2189	7/32		5.560	66.00	28.00	93.00	57.00
0.2205			5.600	66.00	28.00	93.00	57.00
0.2209		2	5.610	66.00	28.00	93.00	57.00
0.2244			5.700	66.00	28.00	93.00	57.00
0.2280		1	5.790	66.00	28.00	93.00	57.00
0.2283			5.800	66.00	28.00	93.00	57.00
0.2323			5.900	66.00	28.00	93.00	57.00
0.2339		A	5.940	66.00	28.00	93.00	57.00
0.2343	15/64		5.950	66.00	28.00	93.00	57.00
0.2362			6.000	66.00	28.00	93.00	57.00
0.2378		B	6.040	70.00	31.00	101.00	63.00
0.2402			6.100	70.00	31.00	101.00	63.00



Diameter				Series 2463		Series 2464	
Dec. inch	Fract. inch	Wire / letter	mm	Overall Length mm	Flute Length mm	Overall Length mm	Flute Length mm
0.2421		C	6.150	70.00	31.00	101.00	63.00
0.2441			6.200	70.00	31.00	101.00	63.00
0.2461		D	6.250	70.00	31.00	101.00	63.00
0.2480			6.300	70.00	31.00	101.00	63.00
0.2500	1/4	E	6.350	70.00	31.00	101.00	63.00
0.2520			6.400	70.00	31.00	101.00	63.00
0.2559			6.500	70.00	31.00	101.00	63.00
0.2571		F	6.530	70.00	31.00	101.00	63.00
0.2598			6.600	70.00	31.00	101.00	63.00
0.2610		G	6.630	70.00	31.00	101.00	63.00
0.2638			6.700	70.00	31.00	101.00	63.00
0.2657	17/64	H	6.750	74.00	34.00	109.00	69.00
0.2677			6.800	74.00	34.00	109.00	69.00
0.2717			6.900	74.00	34.00	109.00	69.00
0.2756			7.000	74.00	34.00	109.00	69.00
0.2768		J	7.030	74.00	34.00	109.00	69.00
0.2795			7.100	74.00	34.00	109.00	69.00
0.2811	9/32	K	7.140	74.00	34.00	109.00	69.00
0.2835			7.200	74.00	34.00	109.00	69.00
0.2874			7.300	74.00	34.00	109.00	69.00
0.2902		L	7.370	74.00	34.00	109.00	69.00
0.2913			7.400	74.00	34.00	709.00	69.00
0.2949		M	7.490	74.00	34.00	109.00	69.00
0.2953			7.500	74.00	34.00	109.00	69.00
0.2969	19/64		7.540	79.00	37.00	117.00	75.00
0.2992			7.600	79.00	37.00	117.00	75.00
0.3020		N	7.670	79.00	37.00	117.00	75.00
0.3031			7.700	79.00	37.00	117.00	75.00
0.3071			7.800	79.00	37.00	117.00	75.00
0.3110			7.900	79.00	37.00	117.00	75.00
0.3126	5/16		7.940	79.00	37.00	117.00	75.00
0.3150			8.000	79.00	37.00	117.00	75.00
0.3161		O	8.030	79.00	37.00	117.00	75.00
0.3189			8.100	79.00	37.00	117.00	75.00
0.3228			8.200	79.00	37.00	117.00	75.00
0.3268			8.300	79.00	37.00	117.00	75.00
0.3280	21/64		8.330	79.00	37.00	117.00	75.00
0.3307			8.400	79.00	37.00	117.00	75.00
0.3319		Q	8.430	79.00	37.00	117.00	75.00
0.3346			8.500	79.00	37.00	117.00	75.00
0.3386			8.600	84.00	40.00	125.00	81.00
0.3390		R	8.610	84.00	40.00	125.00	81.00
0.3425			8.700	84.00	40.00	125.00	81.00
0.3437	11/32		8.730	84.00	40.00	125.00	81.00
0.3465			8.800	84.00	40.00	125.00	81.00

Diameter				Series 2463		Series 2464	
Dec. inch	Fract. inch	Wire / letter	mm	Overall Length mm	Flute Length mm	Overall Length mm	Flute Length mm
0.3480		S	8.840	84.00	40.00	125.00	81.00
0.3504			8.900	84.00	40.00	125.00	81.00
0.3543			9.000	84.00	40.00	125.00	81.00
0.3579		T	9.090	84.00	40.00	125.00	81.00
0.3583			9.100	84.00	40.00	125.00	81.00
0.3594	23/64		9.130	84.00	40.00	125.00	81.00
0.3622			9.200	84.00	40.00	125.00	81.00
0.3661			9.300	84.00	40.00	125.00	81.00
0.3677		U	9.340	84.00	40.00	125.00	81.00
0.3701			9.400	84.00	40.00	125.00	81.00
0.3740			9.500	84.00	40.00	125.00	81.00
0.3748	3/8		9.520	89.00	43.00	133.00	87.00
0.3772		V	9.580	89.00	43.00	133.00	87.00
0.3780			9.600	89.00	43.00	133.00	87.00
0.3819			9.700	89.00	43.00	133.00	87.00
0.3858		W	9.800	89.00	43.00	133.00	87.00
0.3898			9.900	89.00	43.00	133.00	87.00
0.3906	25/64		9.920	89.00	43.00	133.00	87.00
0.3937			10.000	89.00	43.00	133.00	87.00
0.3969		X	10.080	89.00	43.00	133.00	87.00
0.4016			10.200	89.00	43.00	133.00	87.00
0.4039		Y	10.260	89.00	43.00	133.00	87.00
0.4055			10.300	89.00	43.00	133.00	87.00
0.4063	13/32		10.320	89.00	43.00	133.00	87.00
0.4130		Z	10.490	89.00	43.00	133.00	87.00
0.4134			10.500	89.00	43.00	133.00	87.00
0.4220	27/64		10.720	95.00	47.00	142.00	94.00
0.4331			11.000	95.00	47.00	142.00	94.00
0.4374	7/16		11.110	95.00	47.00	142.00	94.00
0.4528			11.500	95.00	47.00	142.00	94.00
0.4531	29/64		11.510	95.00	47.00	142.00	94.00
0.4689	15/32		11.910	102.00	51.00	151.00	101.00
0.4724			12.000	102.00	51.00	151.00	101.00
0.4843	31/64		12.300	102.00	51.00	151.00	101.00
0.5000	1/2		12.700	102.00	51.00	151.00	101.00
0.5118			13.000	102.00	51.00		
0.5311	17/32		13.490	107.00	54.00		
0.5512			14.000	107.00	54.00		
0.5626	9/16		14.290	111.00	56.00		
0.5906			15.000	111.00	56.00		
0.6299			16.000	115.00	58.00		

Shank Diameter info, Series 2463, 2464: Cutting dia. = shank dia.

Application alternatives:



Series 515 - Powdered metal cobalt GT 500 DZ style drill, screw machine length, straight shank, 130° cone-relief point, FIREX® coated, 1.0-14.29 mm.

Series 530 - Powdered metal cobalt GT 500 DZ style drill, jobber length, straight shank, 130° cone-relief point, FIREX® coated, 1.0-14.29 mm.

FIREX® Coating

Developed by Guhring, high-performance FIREX® coating allows cutting tools to operate at higher temperatures for longer periods of time. FIREX is a multilayer coating that combines the heat and wear resistance of TiAlN coating with the universal applicability of TiN, to create a wear resistant heat barrier that significantly extends the life of the tool. Increases of 50-60% or more in tool life can be achieved with FIREX coating, which is featured on many Guhring stocked standard tools.





Diameter			Series 5510		Series 5511		Series 5512		
Dec. inch	Fract. inch	Wire / letter	Overall Length mm	Flute Length mm	Overall Length mm	Flute Length mm	Overall Length mm	Flute Length mm	
0.4606			11.700	102.00	55.00	118.00	71.00	163.00	114.00
0.4645			11.800	102.00	55.00	118.00	71.00	163.00	114.00
0.4685			11.900	102.00	55.00	118.00	71.00	163.00	114.00
0.4689	15/32		11.910	102.00	55.00	118.00	71.00	163.00	114.00
0.4724			12.000	102.00	55.00	118.00	71.00	163.00	114.00
0.4764			12.100	107.00	60.00	124.00	77.00	182.00	133.00
0.4803			12.200	107.00	60.00	124.00	77.00	182.00	133.00
0.4843	31/64		12.300	107.00	60.00	124.00	77.00	182.00	133.00
0.4882			12.400	107.00	60.00	124.00	77.00		
0.4921			12.500	107.00	60.00	124.00	77.00	182.00	133.00
0.4961			12.600	107.00	60.00	124.00	77.00		
0.5000	1/2		12.700	107.00	60.00	124.00	77.00	182.00	133.00
0.5039			12.800	107.00	60.00	124.00	77.00		
0.5079			12.900	107.00	60.00	124.00	77.00		
0.5118			13.000	107.00	60.00	124.00	77.00	182.00	133.00
0.5157			13.100	107.00	60.00	124.00	77.00	182.00	133.00
0.5197			13.200	107.00	60.00	124.00	77.00		
0.5236			13.300	107.00	60.00	124.00	77.00		
0.5276			13.400	107.00	60.00	124.00	77.00		
0.5311	17/32		13.490	107.00	60.00	124.00	77.00	182.00	133.00
0.5315			13.500	107.00	60.00	124.00	77.00	182.00	133.00
0.5354			13.600	107.00	60.00	124.00	77.00		
0.5394			13.700	107.00	60.00	124.00	77.00		
0.5433			13.800	107.00	60.00	124.00	77.00		
0.5469	35/64		13.890	107.00	60.00	124.00	77.00	182.00	133.00
0.5472			13.900	107.00	60.00	124.00	77.00		
0.5512			14.000	107.00	60.00	124.00	77.00	182.00	133.00
0.5551			14.100	115.00	65.00	133.00	83.00	204.00	152.00
0.5591			14.200	115.00	65.00	133.00	83.00	204.00	152.00
0.5626	9/16		14.290	115.00	65.00	133.00	83.00	204.00	152.00
0.5630			14.300	115.00	65.00	133.00	83.00		
0.5669			14.400	115.00	65.00	133.00	83.00		
0.5709			14.500	115.00	65.00	133.00	83.00	204.00	152.00
0.5748			14.600	115.00	65.00	133.00	83.00		
0.5780	37/64		14.680	115.00	65.00	133.00	83.00		
0.5787			14.700	115.00	65.00	133.00	83.00		
0.5827			14.800	115.00	65.00	133.00	83.00		
0.5866			14.900	115.00	65.00	133.00	83.00		
0.5906			15.000	115.00	65.00	133.00	83.00	204.00	152.00
0.5937	19/32		15.080	115.00	65.00	133.00	83.00		

Diameter			Series 5510		Series 5511		Series 5512		
Dec. inch	Fract. inch	Wire / letter	Overall Length mm	Flute Length mm	Overall Length mm	Flute Length mm	Overall Length mm	Flute Length mm	
0.5945			15.100	115.00	65.00	133.00	83.00	204.00	152.00
0.5984			15.200	115.00	65.00	133.00	83.00		
0.6024			15.300	115.00	65.00	133.00	83.00		
0.6063			15.400	115.00	65.00	133.00	83.00		
0.6094	39/64		15.480	115.00	65.00	133.00	83.00	204.00	152.00
0.6102			15.500	115.00	65.00	133.00	83.00	204.00	152.00
0.6142			15.600	115.00	65.00	133.00	83.00		
0.6181			15.700	115.00	65.00	133.00	83.00		
0.6220			15.800	115.00	65.00	133.00	83.00		
0.6248	5/8		15.870	115.00	65.00	133.00	83.00	204.00	152.00
0.6260			15.900	115.00	65.00	133.00	83.00		
0.6299			16.000	115.00	65.00	133.00	83.00	204.00	152.00
0.6378			16.200	115.00	65.00	143.00	93.00		
0.6406	41/64		16.270	115.00	65.00	143.00	93.00		
0.6496			16.500	123.00	73.00	143.00	93.00	223.00	171.00
0.6563	21/32		16.670	123.00	73.00	143.00	93.00	223.00	171.00
0.6575			16.700			143.00	93.00		
0.6654			16.900	123.00	73.00	143.00	93.00	223.00	171.00
0.6693			17.000	123.00	73.00	143.00	93.00	223.00	171.00
0.6720	43/64		17.070	123.00	73.00	143.00	93.00		
0.6874	11/16		17.460	123.00	73.00	143.00	93.00		
0.6890			17.500	123.00	73.00	143.00	93.00	223.00	171.00
0.6929			17.600	123.00	73.00				
0.6968			17.700	123.00	73.00	143.00	93.00		
0.7031	45/64		17.860	123.00	73.00	143.00	93.00		
0.7087			18.000	131.00	79.00	143.00	93.00	223.00	171.00
0.7189	23/32		18.260	131.00	79.00			244.00	190.00
0.7283			18.500	131.00	79.00				
0.7362			18.700			153.00	101.00		
0.7441			18.900	131.00	79.00	153.00	101.00	244.00	190.00
0.7480			19.000	131.00	79.00	153.00	101.00	244.00	190.00
0.7500	3/4		19.050	131.00	79.00	153.00	101.00	244.00	190.00
0.7543			19.160	131.00	79.00	153.00	101.00		
0.7579			19.250	131.00	79.00	153.00	101.00		
0.7598			19.300	131.00	79.00	153.00	101.00		
0.7656	49/64		19.446	131.00	79.00	153.00	101.00		
0.7677			19.500	131.00	79.00	153.00	101.00	244.00	190.00
0.7756			19.700			153.00	101.00		
0.7811	25/32		19.840	131.00	79.00	153.00	101.00		
0.7874			20.000	131.00	79.00	153.00	101.00	244.00	190.00

Shank Diameter info, Series 5510, 5511, 5512:

from diameter	to diameter	shank diameter =
3.0 mm	6.0 mm	6.0 mm
6.1	8.0	8.0
8.1	10.0	10.0
10.1	12.0	12.0
12.1	14.0	14.0
14.1	16.0	16.0
16.1	18.0	18.0
18.1	20.0	20.0

Application alternatives:



Series 2477 - RT 100 X high penetration carbide drill, 140° point, 3xD, reinforced str. shank, coolant fed, nano-FIREX® coated, dia. from 3.0 - 20.0mm

Series 2479 - RT 100 X high penetration carbide drill, 140° point, 5xD, reinforced str. shank, coolant fed, nano-FIREX® coated, dia. from 3.0 - 20.0mm

Series 4044 - RT 100 X high penetration carbide drill, 140° point, 7xD, reinforced str. shank, coolant fed, nano-FIREX® coated, dia. from 3.0 - 20.0mm

Free toolfinder software

Find the best-suited Guhring cutting tools for your application -- quickly and easily -- with Guhring Navigator. Go to www.guhring.com and click on the icon to test drive this software.





High Performance Solid Carbide Drills

- Unique flute profile and point geometry eliminates the need for peck cycles
- RT 100 U self-centering 140° SU point eliminates need for spot drilling
- FIREX® coated for added heat & abrasion resistance
- m7 tolerance on cut diameter
- Applications: Steel, alloyed steel, stainless steel, titanium and nickel alloys, and cast iron

Series 5514 - 3xD Series 5515 - 5xD



Diameter				Series 5514		Series 5515	
Dec. inch	Fract. inch	Wire / letter	mm	Overall Length mm	Flute Length mm	Overall Length mm	Flute Length mm
0.1181			3.000	62.00	20.00	66.00	28.00
0.1220			3.100	62.00	20.00	66.00	28.00
0.1248	1/8		3.170	62.00	20.00	66.00	28.00
0.1260			3.200	62.00	20.00	66.00	28.00
0.1280			3.250	62.00	20.00	66.00	28.00
0.1299			3.300	62.00	20.00	66.00	28.00
0.1339			3.400	62.00	20.00	66.00	28.00
0.1378			3.500	62.00	20.00	66.00	28.00
0.1406	9/64	28	3.570	62.00	20.00	66.00	28.00
0.1417			3.600	62.00	20.00	66.00	28.00
0.1457			3.700	62.00	20.00	66.00	28.00
0.1496		25	3.800	66.00	24.00	74.00	36.00
0.1535			3.900	66.00	24.00	74.00	36.00
0.1563	5/32		3.970	66.00	24.00	74.00	36.00
0.1575			4.000	66.00	24.00	74.00	36.00
0.1591		21	4.040	66.00	24.00	74.00	36.00
0.1614			4.100	66.00	24.00	74.00	36.00
0.1654			4.200	66.00	24.00	74.00	36.00
0.1693		18	4.300	66.00	24.00	74.00	36.00
0.1720	11/64		4.370	66.00	24.00	74.00	36.00
0.1732			4.400	66.00	24.00	74.00	36.00
0.1772		16	4.500	66.00	24.00	74.00	36.00
0.1811			4.600	66.00	24.00	74.00	36.00
0.1831			4.650	66.00	24.00	74.01	36.01
0.1850		13	4.700	66.00	24.00	74.00	36.00
0.1874	3/16		4.760	66.00	28.00	82.00	44.00
0.1890		12	4.800	66.00	28.00	82.00	44.00
0.1929			4.900	66.00	28.00	82.00	44.00
0.1969			5.000	66.00	28.00	82.00	44.00
0.2008			5.100	66.00	28.00	82.00	44.00
0.2012		7	5.110	66.00	28.00	82.00	44.00
0.2031	13/64		5.160	66.00	28.00	82.00	44.00
0.2047			5.200	66.00	28.00	82.00	44.00
0.2087			5.300	66.00	28.00	82.00	44.00
0.2126			5.400	66.00	28.00	82.00	44.00
0.2130		3	5.410	66.00	28.00	82.00	44.00
0.2165			5.500	66.00	28.00	82.00	44.00
0.2185			5.550	66.00	28.00	82.00	44.00
0.2189	7/32		5.560	66.00	28.00	82.00	44.00
0.2205			5.600	66.00	28.00	82.00	44.00
0.2244			5.700	66.00	28.00	82.00	44.00
0.2283			5.800	66.00	28.00	82.00	44.00
0.2323			5.900	66.00	28.00	82.00	44.00
0.2343	15/64		5.950	66.00	28.00	82.00	44.00
0.2362			6.000	66.00	28.00	82.00	44.00
0.2402			6.100	79.00	34.00	91.00	53.00
0.2441			6.200	79.00	34.00	91.00	53.00
0.2480			6.300	79.00	34.00	91.00	53.00
0.2500	1/4	E	6.350	79.00	34.00	91.00	53.00
0.2520			6.400	79.00	34.00	91.00	53.00
0.2559			6.500	79.00	34.00	91.00	53.00
0.2571		F	6.530	79.00	34.00	91.00	53.00
0.2598			6.600	79.00	34.00	91.00	53.00
0.2638			6.700	79.00	34.00	91.00	53.00
0.2657	17/64	H	6.750	79.00	34.00	91.00	53.00
0.2677			6.800	79.00	34.00	91.00	53.00
0.2717		I	6.900	79.00	34.00	91.00	53.00
0.2756			7.000	79.00	34.00	91.00	53.00
0.2795			7.100	79.00	34.00	91.00	53.00
0.2811	9/32	K	7.140	79.00	41.00	91.00	53.00

Diameter				Series 5514		Series 5515	
Dec. inch	Fract. inch	Wire / letter	mm	Overall Length mm	Flute Length mm	Overall Length mm	Flute Length mm
0.2835			7.200	79.00	41.00	91.00	53.00
0.2874			7.300	79.00	41.00	91.00	53.00
0.2913			7.400	79.00	41.00	91.00	53.00
0.2953			7.500	79.00	41.00	91.00	53.00
0.2969	19/64		7.540	79.00	41.00	91.00	53.00
0.2992			7.600	79.00	41.00	91.00	53.00
0.3031			7.700	79.00	41.00	91.00	53.00
0.3071			7.800	79.00	41.00	91.00	53.00
0.3110			7.900	79.00	41.00	91.00	53.00
0.3126	5/16		7.940	79.00	41.00	91.00	53.00
0.3150			8.000	79.00	41.00	91.00	53.00
0.3189			8.100	89.00	47.00	103.00	61.00
0.3228		P	8.200	89.00	47.00	103.00	61.00
0.3268			8.300	89.00	47.00	103.00	61.00
0.3280	21/64		8.330	89.00	47.00	103.00	61.00
0.3307			8.400	89.00	47.00	103.00	61.00
0.3346			8.500	89.00	47.00	103.00	61.00
0.3386			8.600	89.00	47.00	103.00	61.00
0.3425			8.700	89.00	47.00	103.00	61.00
0.3437	11/32		8.730	89.00	47.00	103.00	61.00
0.3465			8.800	89.00	47.00	103.00	61.00
0.3504			8.900	89.00	47.00	103.00	61.00
0.3543			9.000	89.00	47.00	103.00	61.00
0.3583			9.100	89.00	47.00	103.00	61.00
0.3594	23/64		9.130	89.00	47.00	103.00	61.00
0.3622			9.200	89.00	47.00	103.00	61.00
0.3642			9.250	89.00	47.00	103.00	61.00
0.3661			9.300	89.00	47.00	103.00	61.00
0.3677		U	9.340	89.00	47.00	103.00	61.00
0.3701			9.400	89.00	47.00	103.00	61.00
0.3740			9.500	89.00	47.00	103.00	61.00
0.3748	3/8		9.520	89.00	47.00	103.00	61.00
0.3780			9.600	89.00	47.00	103.00	61.00
0.3819			9.700	89.00	47.00	103.00	61.00
0.3858		W	9.800	89.00	47.00	103.00	61.00
0.3898			9.900	89.00	47.00	103.00	61.00
0.3906	25/64		9.920	89.00	47.00	103.00	61.00
0.3937			10.000	89.00	47.00	103.00	61.00
0.3976			10.100	102.00	55.00	118.00	71.00
0.4016			10.200	102.00	55.00	118.00	71.00
0.4055			10.300	102.00	55.00	118.00	71.00
0.4063	13/32		10.320	102.00	55.00	118.00	71.00
0.4094			10.400	102.00	55.00	118.00	71.00
0.4134			10.500	102.00	55.00	118.00	71.00
0.4173			10.600	102.00	55.00	118.00	71.00
0.4213			10.700	102.00	55.00	118.00	71.00
0.4220	27/64		10.720	102.00	55.00	118.00	71.00
0.4252			10.800	102.00	55.00	118.00	71.00
0.4291			10.900	102.00	55.00	118.00	71.00
0.4331			11.000	102.00	55.00	118.00	71.00
0.4370			11.100	102.00	55.00	118.00	71.00
0.4374	7/16		11.110	102.00	55.00	118.00	71.00
0.4409			11.200	102.00	55.00	118.00	71.00
0.4449			11.300	102.00	55.00	118.00	71.00
0.4488			11.400	102.00	55.00	118.00	71.00
0.4528			11.500	102.00	55.00	118.00	71.00
0.4531	29/64		11.510	102.00	55.00	118.00	71.00
0.4567			11.600	102.00	55.00	118.00	71.00
0.4606			11.700	102.00	55.00	118.00	71.00
0.4646			11.800	102.00	55.00	118.00	71.00



Diameter				Series 5514		Series 5515	
Dec. inch	Fract. inch	Wire / letter	mm	Overall Length mm	Flute Length mm	Overall Length mm	Flute Length mm
0.4685			11.900	102.00	55.00	118.00	71.00
0.4689	15/32		11.910	102.00	55.00	118.00	71.00
0.4724			12.000	102.00	55.00	118.00	71.00
0.4764			12.100	107.00	60.00	124.00	77.00
0.4803			12.200	107.00	60.00	124.00	77.00
0.4843	31/64		12.300	107.00	60.00	124.00	77.00
0.4882			12.400	107.00	60.00	124.00	77.00
0.4921			12.500	107.00	60.00	124.00	77.00
0.4961			12.600	107.00	60.00	124.00	77.00
0.5000	1/2		12.700	107.00	60.00	124.00	77.00
0.5039			12.800	107.00	60.00		
0.5079			12.900	107.00	60.00		
0.5118			13.000	107.00	60.00	124.00	77.00
0.5157	33/64		13.100	107.00	60.00	124.00	77.00
0.5197			13.200	107.00	60.00	124.00	77.00
0.5236			13.300	107.00	60.00	124.00	77.00
0.5276			13.400	107.00	60.00		
0.5311	17/32		13.490	107.00	60.00		
0.5315			13.500	107.00	60.00	124.00	77.00
0.5354			13.600	107.00	60.00		
0.5394			13.700	107.00	60.00	124.00	77.00
0.5433			13.800	107.00	60.00	124.00	77.00
0.5469	35/64		13.890	107.00	60.00		
0.5472			13.900	107.00	60.00		
0.5512			14.000	107.00	60.00	124.00	77.00
0.5551			14.100	115.00	65.00	133.00	83.00
0.5591			14.200	115.00	65.00	133.00	83.00
0.5626	9/16		14.290	107.00	60.00	133.00	83.00
0.5630			14.300	115.00	65.00	133.00	83.00
0.5669			14.400	115.00	65.00	133.00	83.00
0.5709			14.500	115.00	65.00	133.00	83.00
0.5748			14.600	115.00	65.00		
0.5780	37/64		14.680	115.00	65.00		
0.5787			14.700	115.00	65.00	133.00	83.00
0.5827			14.800	115.00	65.00		
0.5866			14.900	115.00	65.00		

Diameter				Series 5514		Series 5515	
Dec. inch	Fract. inch	Wire / letter	mm	Overall Length mm	Flute Length mm	Overall Length mm	Flute Length mm
0.5906			15.000	115.00	65.00	133.00	83.00
0.5937	19/32		15.080	115.00	65.00		
0.5945			15.100	115.00	65.00	133.00	83.00
0.5984			15.200	115.00	65.00	133.00	83.00
0.6024			15.300	115.00	65.00		
0.6063			15.400	115.00	65.00		
0.6094	39/64		15.480	115.00	65.00		
0.6102			15.500	115.00	65.00	133.00	83.00
0.6142			15.600	115.00	65.00	133.00	83.00
0.6181			15.700	115.00	65.00	133.00	83.00
0.6220			15.800	115.00	65.00	133.00	83.00
0.6248	5/8		15.870	115.00	65.00	133.00	83.00
0.6260			15.900	115.00	65.00		
0.6299			16.000	115.00	65.00	133.00	83.00
0.6406	41/64		16.270	123.00	73.00		
0.6496			16.500	123.00	73.00	143.00	93.00
0.6563	21/32		16.670	123.00	73.00		
0.6693			17.000	123.00	73.00	143.00	93.00
0.6720	43/64		17.070	123.00	73.00		
0.6874	11/16		17.460	123.00	73.00		
0.6890			17.500	123.00	73.00	143.00	93.00
0.7031	45/64		17.860	123.00	73.00		
0.7087			18.000	123.00	73.00	143.00	93.00
0.7189	23/32		18.260	131.00	79.00		
0.7283			18.500	131.00	79.00	153.00	101.00
0.7480			19.000	131.00	79.00	153.00	101.00
0.7500	3/4		19.050	131.00	79.00		
0.7579			19.250	131.00	79.00		
0.7656	49/64		19.446	131.00	79.00		
0.7677			19.500	131.00	79.00	153.00	101.00
0.7811	25/32		19.840	131.00	79.00		
0.7874			20.000	131.00	79.00	153.00	101.00

**Shank Diameter info,
Series 5514, 5515:**

from diameter	to diameter	shank diameter =
3.0 mm	6.0 mm	6.0 mm
6.1	8.0	8.0
8.1	10.0	10.0
10.1	12.0	12.0
12.1	14.0	14.0
14.1	16.0	16.0
16.1	18.0	18.0
18.1	20.0	20.0



Application alternatives:

Series 1242 - RT 100 U
high penetration carbide drill,
140° point, 3xD, str. shank, TiN
coated, dia. from 3.0 - 16.0mm

Series 1243 - RT 100 U
high penetration carbide drill,
140° point, 5xD, str. shank, TiN
coated, dia. from 5.0 - 16.0mm

Guhring offers the industry's broadest offering of high-performance drills with more than 15 styles of the popular RT100 carbide drill. Refer to the 2010 full-line drill catalog for more drill options.





Coolant Fed Deep Hole Carbide Drills

- Unique flute profile and point geometry eliminates the need for peck cycles
- Self-centering 140° SC point eliminates need for spot drilling
- Dual helical coolant ducts through the tool
- FIREX® coated tip for added heat & abrasion resistance
- m7 tolerance on cut diameter
- Applications: Steel, alloyed steel, stainless steel, titanium and nickel alloys, and cast iron

Series 5525 - 12xD



Diameter				Series 5525	
Dec. inch	Fract. inch	Wire / letter	mm	Overall Length mm	Flute Length mm
0.1181			3.000	90.00	50.00
0.1220			3.100	90.00	50.00
0.1250	1/8		3.170	90.00	50.00
0.1260			3.200	90.00	50.00
0.1280			3.250	90.00	50.00
0.1299			3.300	90.00	50.00
0.1339			3.400	90.00	50.00
0.1378			3.500	90.00	50.00
0.1406	9/64		3.570	90.00	50.00
0.1417			3.600	90.00	50.00
0.1457			3.700	90.00	50.00
0.1496		25	3.800	90.00	50.00
0.1535			3.900	90.00	50.00
0.1563	5/32		3.970	90.00	50.00
0.1575			4.000	102.00	64.00
0.1614			4.100	102.00	64.00
0.1654			4.200	102.00	64.00
0.1693		18	4.300	102.00	64.00
0.1720	11/64		4.370	102.00	64.00
0.1732			4.400	102.00	64.00
0.1772		16	4.500	102.00	64.00
0.1811			4.600	102.00	64.00
0.1831			4.650	102.00	64.00
0.1850			4.700	102.00	64.00
0.1874	3/16		4.760	102.00	64.00
0.1890			4.800	116.00	78.00
0.1929			4.900	116.00	78.00
0.1969			5.000	116.00	78.00
0.2008			5.100	116.00	78.00
0.2031	13/64		5.160	116.00	78.00
0.2047			5.200	116.00	78.00
0.2087			5.300	116.00	78.00
0.2126			5.400	116.00	78.00
0.2165			5.500	116.00	78.00
0.2189	7/32		5.560	116.00	78.00
0.2205			5.600	116.00	78.00
0.2244			5.700	116.00	78.00
0.2283			5.800	116.00	78.00
0.2323			5.900	116.00	78.00
0.2343	15/64		5.950	116.00	78.00
0.2362			6.000	116.00	78.00
0.2402			6.100	146.00	108.00
0.2441			6.200	146.00	108.00
0.2480			6.300	146.00	108.00
0.2500	1/4	E	6.350	146.00	108.00

Diameter				Series 5525	
Dec. inch	Fract. inch	Wire / letter	mm	Overall Length mm	Flute Length mm
0.2520			6.400	146.00	108.00
0.2559			6.500	146.00	108.00
0.2598			6.600	146.00	108.00
0.2638			6.700	146.00	108.00
0.2657	17/64		6.750	146.00	108.00
0.2677			6.800	146.00	108.00
0.2717			6.900	146.00	108.00
0.2756			7.000	146.00	108.00
0.2795			7.100	146.00	108.00
0.2811	9/32		7.140	146.00	108.00
0.2835			7.200	146.00	108.00
0.2874			7.300	146.00	108.00
0.2913			7.400	146.00	108.00
0.2953			7.500	146.00	108.00
0.2969	19/64		7.540	146.00	108.00
0.2992			7.600	146.00	108.00
0.3031			7.700	146.00	108.00
0.3071			7.800	146.00	108.00
0.3110			7.900	146.00	108.00
0.3126	5/16		7.940	146.00	108.00
0.3150			8.000	146.00	108.00
0.3189			8.100	162.00	120.00
0.3228			8.200	162.00	120.00
0.3268			8.300	162.00	120.00
0.3280	21/64		8.330	162.00	120.00
0.3307			8.400	162.00	120.00
0.3346			8.500	162.00	120.00
0.3386			8.600	162.00	120.00
0.3425			8.700	162.00	120.00
0.3437	11/32		8.730	162.00	120.00
0.3465			8.800	162.00	120.00
0.3504			8.900	162.00	120.00
0.3543			9.000	162.00	120.00
0.3583			9.100	162.00	120.00
0.3594	23/64		9.130	162.00	120.00
0.3622			9.200	162.00	120.00
0.3642			9.250	162.00	120.00
0.3661			9.300	162.00	120.00
0.3701			9.400	162.00	120.00
0.3740			9.500	162.00	120.00
0.3748	3/8		9.520	162.00	120.00
0.3780			9.600	162.00	120.00
0.3819			9.700	162.00	120.00
0.3858			9.800	162.00	120.00
0.3898			9.900	162.00	120.00

Diameter				Series 5525	
Dec. inch	Fract. inch	Wire / letter	mm	Overall Length mm	Flute Length mm
0.3906	25/64		9.920	162.00	120.00
0.3937			10.000	162.00	120.00
0.3976			10.100	204.00	156.00
0.4016			10.200	204.00	156.00
0.4055			10.300	204.00	156.00
0.4063	13/32		10.320	204.00	156.00
0.4134			10.500	204.00	156.00
0.4173			10.600	204.00	156.00
0.4213			10.700	204.00	156.00
0.4220	27/64		10.720	204.00	156.00
0.4252			10.800	204.00	156.00
0.4291			10.900	204.00	156.00
0.4331			11.000	204.00	156.00
0.4374	7/16		11.110	204.00	156.00
0.4528			11.500	204.00	156.00
0.4531	29/64		11.510	204.00	156.00
0.4689	15/32		11.910	204.00	156.00
0.4724			12.000	204.00	156.00
0.4843	31/64		12.300	230.00	182.00
0.4921			12.500	230.00	182.00
0.5000	1/2		12.700	230.00	182.00
0.5118			13.000	230.00	182.00
0.5311	17/32		13.490	230.00	182.00
0.5315			13.500	230.00	182.00
0.5469	35/64		13.890	230.00	182.00
0.5512			14.000	230.00	182.00
0.5709			14.500	260.00	208.00
0.5906			15.000	260.00	208.00
0.6094	39/64		15.480	260.00	208.00
0.6102			15.500	260.00	208.00
0.6299			16.000	260.00	208.00
0.6496			16.500	285.00	234.00
0.6693			17.000	285.00	234.00
0.6890			17.500	285.00	234.00
0.7087			18.000	285.00	234.00
0.7283			18.500	285.00	234.00
0.7480			19.000	310.00	258.00
0.7500	3/4		19.050	310.00	258.00
0.7677			19.500	310.00	258.00
0.7874			20.000	310.00	258.00

Shank Diameter info, Series 5525:

from diameter	to diameter	shank diameter =
3.0 mm	6.0 mm	6.0 mm
6.1	8.0	8.0
8.1	10.0	10.0
10.1	12.0	12.0
12.1	14.0	14.0
14.1	16.0	16.0
16.1	18.0	18.0
18.1	20.0	20.0

Application alternatives:

Series 6511 (20xD)

Series 6512 (25xD)

Series 6513 (30xD)

Series 6514 (40xD)

Carbide RT 100 T style drill, high penetration, coolant through, reinforced straight shank, TiAlN coated. Diameters from 3.00-14.00 mm.

3-Flute High Performance Carbide Drills

- Reduces cycle time and increases part quality
- GS 200 G self-centering 130° spiral point - no need to spot drill
- 3-flute drill provides reamer class part surface finish
- Bright finish, reinforced straight shank
- m7 tolerance on cut diameter
- Applications: Aluminum, mild steels, cast iron



Series 5518 - 3-flute drill (5xD)



Diameter				Series 5518	
Dec. inch	Fract. inch	Wire / letter	mm	Overall Length mm	Flute Length mm
0.1181			3.00	66.00	28.00
0.1220			3.10	66.00	28.00
0.1260			3.20	66.00	28.00
0.1299			3.30	66.00	28.00
0.1378			3.50	66.00	28.00
0.1457			3.70	66.00	28.00
0.1496		25	3.80	74.00	36.00
0.1575			4.00	74.00	36.00
0.1614			4.10	74.00	36.00
0.1654			4.20	74.00	36.00
0.1772		16	4.50	74.00	36.00
0.1890		12	4.80	74.00	36.00
0.1969			5.00	82.00	44.00
0.2008			5.10	82.00	44.00
0.2047			5.20	82.00	44.00
0.2087			5.30	82.00	44.00
0.2165			5.50	82.00	44.00
0.2283			5.80	82.00	44.00
0.2362			6.00	82.00	44.00
0.2402			6.10	91.00	53.00
0.2441			6.20	91.00	53.00
0.2520			6.40	91.00	53.00
0.2559			6.50	91.00	53.00
0.2638			6.70	91.00	53.00
0.2677			6.80	91.00	53.00
0.2717			6.90	91.00	53.00
0.2756			7.00	91.00	53.00

Diameter				Series 5518	
Dec. inch	Fract. inch	Wire / letter	mm	Overall Length mm	Flute Length mm
0.2795			7.10	91.00	53.00
0.2913			7.40	91.00	53.00
0.2953			7.50	91.00	53.00
0.3071			7.80	91.00	53.00
0.3150			8.00	91.00	53.00
0.3189			8.10	103.00	61.00
0.3228		P	8.20	103.00	61.00
0.3307			8.40	103.00	61.00
0.3346			8.50	103.00	61.00
0.3386			8.60	103.00	61.00
0.3425			8.70	103.00	61.00
0.3465			8.80	103.00	61.00
0.3543			9.00	103.00	61.00
0.3583			9.10	103.00	61.00
0.3740			9.50	103.00	61.00
0.3858		W	9.80	103.00	61.00
0.3937			10.00	103.00	61.00
0.3976			10.10	118.00	71.00
0.4016			10.20	118.00	71.00
0.4055			10.30	118.00	71.00
0.4134			10.50	118.00	71.00
0.4331			11.00	118.00	71.00
0.4409			11.20	118.00	71.00
0.4528			11.50	118.00	71.00
0.4646			11.80	118.00	71.00
0.4724			12.00	118.00	71.00
0.4764			12.10	124.00	77.00

Diameter				Series 5518	
Dec. inch	Fract. inch	Wire / letter	mm	Overall Length mm	Flute Length mm
0.4921			12.50	124.00	77.00
0.5118			13.00	124.00	77.00
0.5315			13.50	124.00	77.00
0.5512			14.00	124.00	77.00
0.5709			14.50	133.00	83.00
0.5906			15.00	133.00	83.00
0.6102			15.50	133.00	83.00
0.6299			16.00	133.00	83.00
0.6496			16.50	143.00	93.00
0.6693			17.00	143.00	93.00
0.6890			17.50	143.00	93.00
0.7087			18.00	143.00	93.00
0.7283			18.50	153.00	101.00
0.7480			19.00	153.00	101.00
0.7677			19.50	153.00	101.00
0.7874			20.00	153.00	101.00

Looking for a 3-flute drill for stainless steel, alloyed steel, and aerospace alloys?

Application alternatives:



Series 1452 - GS 200 U three-flute high-precision carbide drill, 150° point, 5xD drilling depth, external coolant, bright finish, dia. from 3.0 - 20.0mm

Series 609 - GS 200 U three-flute high-precision carbide drill, 150° point, 5xD drilling depth, external coolant, TiN coated, dia. from 3.0 - 20.0mm

Shank Diameter information, Series 5518:

from diameter	to diameter	shank diameter =
3.0 mm	6.0 mm	6.0 mm
6.1	8.0	8.0
8.1	10.0	10.0
10.1	12.0	12.0

from diameter	to diameter	shank diameter =
12.1	14.0	14.0
14.1	16.0	16.0
16.1	18.0	18.0
18.1	20.0	20.0

NC Spot Drills - Series 723, 724, 546

· Carbide, standard length, straight shank, bright finish

Order Code	dec.	fract.	mm	l1	l2	Series	723	724	546
						Point angle	90°	120°	142°
4.00	0.1575		4.00	55.0	12.0				•
5.00	0.1969		5.00	62.0	14.0	•	•	•	•
6.00	0.2362		6.00	66.0	16.0	•	•	•	•
6.35	0.2500	1/4	6.35	70.0	17.0	•	•	•	•
8.00	0.3150		8.00	79.0	21.0	•	•	•	•
9.52	0.3748	3/8	9.52	89.0	25.0	•	•	•	•
10.00	0.3937		10.00	89.0	25.0	•	•	•	•
12.00	0.4724		12.00	102.0	30.0	•	•	•	•
12.70	0.5000	1/2	12.70	102.0	30.0	•	•	•	•
15.87	0.6248	5/8	15.87	115.0	37.5	•	•	•	•
16.00	0.6299		16.00	115.0	37.5	•	•	•	•
19.05	0.7500	3/4	19.05	131.0	45.0	•	•	•	•
20.00	0.7874		20.00	131.0	45.0	•	•	•	•

Technical Information:

For tips on spot and pilot hole drilling, operating speeds and feeds for Guhring drills and much more visit www.guhring.com and click on the Technical tab.

To order: Series no. + order code, example: 724 9.52



Cobalt Cut Taps - Plug

- 2B class of fit - eliminate the guesswork of finding the right H limit
- ANSI shank and overall length
- Precision ground for perfect threads every time
- Premium cobalt for longer tool life
- Applications: Steel, carbon steel, structural steel, aluminum, brass, bronze
- MolyGlide® non-stick coating is recommended for soft or gummy materials such as aluminum, brass, bronze and some mild steels

UNC/UNF

Chamfer Lead



B · 3.5 - 5

ANSI length - ANSI shank

Series 3901 - Cobalt, UNC, spiral point, bright finish

Series 3961 - Cobalt, UNC, spiral point, MolyGlide® coated



Size	No. Flutes	Shank dia. inch	Square Size inch	Overall Length inch	2B Approx. Limits	Series 3901 Bright	Series 3961 MolyGlide™	Order No.
4-40	3	0.141	0.110	1.882	H2/H3	●	●	2.845
5-40	3	0.141	0.110	1.941	H2/H3	●	●	3.175
6-32	3	0.141	0.110	2.000	H3/H4	●	●	3.505
8-32	3	0.168	0.131	2.130	H3/H4	●	●	4.166
10-24	3	0.194	0.152	2.382	H3/H4	●	●	4.826
12-24	3	0.220	0.165	2.382	H3/H4	●	●	5.486
1/4-20	3	0.255	0.191	2.500	H4/H5	●	●	6.350
5/16-18	3	0.318	0.238	2.720	H4/H5	●	●	7.938
3/8-16	3	0.381	0.286	2.941	H5/H6	●	●	9.525
7/16-14	3	0.323	0.242	3.157	H5/H6	●	●	11.113
1/2-13	3	0.367	0.275	3.381	H5/H6	●	●	12.700
9/16-12	3	0.429	0.322	3.591	H5/H6	●	●	14.288
5/8-11	3	0.480	0.360	3.811	H5/H6	●	●	15.875
3/4-10	4	0.590	0.442	4.252	H5/H6	●	●	19.050
7/8-9	4	0.697	0.523	4.689	H6/H7	●	●	22.225
1-8	4	0.800	0.600	5.130	H6/H7	●	●	25.400

ANSI length - ANSI shank

Series 3902 - Cobalt, UNF, spiral point, bright finish

Series 3962 - Cobalt, UNF, spiral point, MolyGlide® coated



Size	No. Flutes	Shank dia. inch	Square Size inch	Overall Length inch	2B Approx. Limits	Series 3902 Bright	Series 3962 MolyGlide™	Order No.
4-48	3	0.141	0.110	1.882	H2/H3	●	●	2.845
5-44	3	0.141	0.110	1.941	H2/H3	●	●	3.175
6-40	3	0.141	0.110	2.000	H2/H3	●	●	3.505
8-36	3	0.168	0.131	2.130	H2/H3	●	●	4.166
10-32	3	0.194	0.152	2.382	H3/H4	●	●	4.826
12-28	3	0.220	0.165	2.382	H3/H4	●	●	5.486
1/4-28	3	0.255	0.191	2.500	H3/H4	●	●	6.350
5/16-24	3	0.318	0.238	2.720	H3/H4	●	●	7.938
3/8-24	3	0.381	0.286	2.941	H3/H4	●	●	9.525
7/16-20	3	0.323	0.242	3.157	H4/H5	●	●	11.113
1/2-20	3	0.367	0.275	3.381	H4/H5	●	●	12.700
9/16-18	3	0.429	0.322	3.591	H4/H5	●	●	14.288
5/8-18	3	0.480	0.360	3.811	H4/H5	●	●	15.875
3/4-16	4	0.590	0.442	4.252	H5/H6	●	●	19.050
7/8-14	4	0.697	0.523	4.689	H6/H7	●	●	22.225
1-12	4	0.800	0.600	5.130	H6/H7	●	●	25.400



Detailed information and additional tap options can be found in our full-line tap catalog. Product information is also available on our website www.guhring.com on the Products & Services tab.

Cobalt Cut Taps - Plug

· 6H class of fit, ANSI shank and overall length



ANSI length - ANSI shank

Series 3900 - Cobalt, Metric, spiral point, bright finish

Series 3960 - Cobalt, Metric, spiral point, MolyGlide® coated



Metric

Chamfer Lead



B · 3.5 - 5

Size	No. Flutes	Shank dia. inch	Square Size inch	Overall Length inch	2B Approx. Limits	Series 3900 Bright	Series 3960 MolyGlide™	Order No.
M2 X 0.40	3	0.141	0.110	1.752	D2/D3	●	●	2.000
M3 X 0.50	3	0.141	0.110	1.941	D2/D3	●	●	3.000
M4 X 0.70	3	0.168	0.131	2.130	D3/D4	●	●	4.000
M5 X 0.80	3	0.194	0.152	2.382	D3/D4	●	●	5.000
M6 X 1.00	3	0.255	0.191	2.500	D4/D5	●	●	6.000
M8 X 1.25	3	0.318	0.238	2.720	D4/D5	●	●	8.000
M10 X 1.50	3	0.381	0.286	2.941	D4/D5	●	●	10.000
M12 X 1.75	3	0.367	0.275	3.381	D5/D6	●	●	12.000
M14 X 2.00	3	0.429	0.322	3.591	D5/D6	●	●	14.000
M16 X 2.00	3	0.480	0.360	3.811	D6/D7	●	●	16.000
M18 X 2.50	4	0.542	0.406	4.031	D6/D7	●	●	18.000
M20 X 2.50	4	0.652	0.489	4.469	D6/D7	●	●	20.000

Semi-bottoming Cobalt Cut Taps

· 6H class of fit, ANSI shank and overall length

ANSI length - ANSI shank

Series 3903 - Cobalt, Metric, 40° helix, bright finish

Series 3963 - Cobalt, Metric, 40° helix, MolyGlide® coated



Metric

Chamfer Lead



C · 2-3

Size	No. Flutes	Shank dia. inch	Square Size inch	Overall Length inch	2B Approx. Limits	Series 3903 Bright	Series 3963 MolyGlide™	Order No.
M2 X 0.40	3	0.141	0.110	1.752	D2/D3	●	●	2.000
M3 X 0.50	3	0.141	0.110	1.941	D2/D3	●	●	3.000
M4 X 0.70	3	0.168	0.131	2.130	D3/D4	●	●	4.000
M5 X 0.80	3	0.194	0.152	2.382	D3/D4	●	●	5.000
M6 X 1.00	3	0.255	0.191	2.500	D4/D5	●	●	6.000
M8 X 1.25	3	0.318	0.238	2.720	D4/D5	●	●	8.000
M10 X 1.50	3	0.381	0.286	2.941	D4/D5	●	●	10.000
M12 X 1.75	3	0.367	0.275	3.381	D5/D6	●	●	12.000
M14 X 2.00	3	0.429	0.322	3.591	D5/D6	●	●	14.000
M16 X 2.00	3	0.480	0.360	3.811	D6/D7	●	●	16.000
M18 X 2.50	4	0.542	0.406	4.031	D6/D7	●	●	18.000
M20 X 2.50	4	0.652	0.489	4.469	D6/D7	●	●	20.000

What's the correct drill size for my tap?

Guhring has an easy-to-use Tap Drill Calculator to help you determine the correct drill size for a given tapped hole size. The calculator can work in mm, inch or wire sizes, and returns both metric and inch drill diameter values.

Go to www.guhring.com, click on the Technical tab, and the Tap Drill Calculator is the first option listed on the left-hand menu.



Semi-bottoming Cobalt Cut Taps

- 2B class of fit - eliminate the guesswork of finding the right H limit
- ANSI shank and overall length
- Precision ground for perfect threads every time
- Premium cobalt for longer tool life
- Applications: Steel, carbon steel, structural steel, aluminum, brass, bronze
- MolyGlide® non-stick coating is recommended for soft or gummy materials such as aluminum, brass, bronze and some mild steels

UNC/UNF

Chamfer Lead



C · 2-3

ANSI length - ANSI shank

Series 3904 - Cobalt, UNC, 40° helix, bright finish

Series 3964 - Cobalt, UNC, 40° helix, MolyGlide® coated



Size	No. Flutes	Shank dia. inch	Square Size inch	Overall Length inch	2B Approx. Limits	Series 3904 Bright	Series 3964 MolyGlide™	Order No.
4-40	3	0.141	0.110	1.882	H2/H3	●	●	2.845
5-40	3	0.141	0.110	1.941	H2/H3	●	●	3.175
6-32	3	0.141	0.110	2.000	H3/H4	●	●	3.505
8-32	3	0.168	0.131	2.130	H3/H4	●	●	4.166
10-24	3	0.194	0.152	2.382	H3/H4	●	●	4.826
12-24	3	0.220	0.165	2.382	H3/H4	●	●	5.486
1/4-20	3	0.255	0.191	2.500	H4/H5	●	●	6.350
5/16-18	3	0.318	0.238	2.720	H4/H5	●	●	7.938
3/8-16	3	0.381	0.286	2.941	H5/H6	●	●	9.525
7/16-14	3	0.323	0.242	3.157	H5/H6	●	●	11.113
1/2-13	3	0.367	0.275	3.381	H5/H6	●	●	12.700
9/16-12	3	0.429	0.322	3.591	H5/H6	●	●	14.288
5/8-11	3	0.480	0.360	3.811	H5/H6	●	●	15.875
3/4-10	4	0.590	0.442	4.252	H5/H6	●	●	19.050
7/8-9	4	0.697	0.523	4.689	H6/H7	●	●	22.225
1-8	4	0.800	0.600	5.130	H6/H7	●	●	25.400

ANSI length - ANSI shank

Series 3905 - Cobalt, UNF, 40° helix, bright finish

Series 3965 - Cobalt, UNF, 40° helix, MolyGlide® coated



Size	No. Flutes	Shank dia. inch	Square Size inch	Overall Length inch	2B Approx. Limits	Series 3905 Bright	Series 3965 MolyGlide™	Order No.
4-48	3	0.141	0.110	1.882	H2/H3	●	●	2.845
5-44	3	0.141	0.110	1.941	H2/H3	●	●	3.175
6-40	3	0.141	0.110	2.000	H2/H3	●	●	3.505
8-36	3	0.168	0.131	2.130	H2/H3	●	●	4.166
10-32	3	0.194	0.152	2.382	H3/H4	●	●	4.826
12-28	3	0.220	0.165	2.382	H3/H4	●	●	5.486
1/4-28	3	0.255	0.191	2.500	H3/H4	●	●	6.350
5/16-24	3	0.318	0.238	2.720	H3/H4	●	●	7.938
3/8-24	3	0.381	0.286	2.941	H3/H4	●	●	9.525
7/16-20	3	0.323	0.242	3.157	H4/H5	●	●	11.113
1/2-20	3	0.367	0.275	3.381	H4/H5	●	●	12.700
9/16-18	3	0.429	0.322	3.591	H4/H5	●	●	14.288
5/8-18	3	0.480	0.360	3.811	H4/H5	●	●	15.875
3/4-16	4	0.590	0.442	4.252	H5/H6	●	●	19.050
7/8-14	4	0.697	0.523	4.689	H6/H7	●	●	22.225
1-12	4	0.800	0.600	5.130	H6/H7	●	●	25.400

RF 100 U Variable Helix End Mills



- An excellent choice for the job shop environment
- Variable helix dampens vibration and delivers improved surface finish quality
- 35°/38° variable helix design
- Sub-micro grain carbide for added tool life
- FIREX® coating provides outstanding heat and wear resistance
- Low radial rake and radial relief for cutting edge strength
- Applications: Steel, alloyed steel, cast iron, brass, aerospace alloys

Series 3113 / 3099 - Stub length (Inch)



Cut Diameter	Shank Diameter	Length of Cut	OAL	No. Flutes	Series 3113 round shk	Series 3099 shk flats	Order Code
3/16	3/16	3/8	2	4	●		4.760
1/4	1/4	1/2	2	4	●		6.350
5/16	5/16	1/2	2	4	●		7.940
3/8	3/8	5/8	2	4	●	●	9.520
1/2	1/2	5/8	2 1/2	4	●	●	12.700
5/8	5/8	3/4	3	4	●	●	15.870
3/4	3/4	1	3	4	●	●	19.050
1	1	1	3	4	●	●	25.400

Series 3731 - Stub length (Metric)



Cut Diameter mm	Shank Diameter mm	Length of Cut mm	OAL mm	No. Flutes	Series 3731 shk flats	Order Code
6.000	6.000	10.00	54.00	4	○	6.000
8.000	8.000	12.00	58.00	4	○	8.000
10.000	10.000	14.00	66.00	4	○	10.000
12.000	12.000	16.00	73.00	4	○	12.000
14.000	14.000	18.00	75.00	4	○	14.000
16.000	16.000	22.00	82.00	4	○	16.000
18.000	18.000	24.00	84.00	4	○	18.000
20.000	20.000	26.00	92.00	4	○	20.000

Series 3114 / 3100 - Standard length (Inch)



Cut Diameter	Shank Diameter	Length of Cut	OAL	No. Flutes	Series 3114 round shk	Series 3100 shk flats	Order Code
3/16	3/16	5/8	2	4	●		4.760
1/4	1/4	3/4	2 1/2	4	●		6.350
5/16	5/16	13/16	2 1/2	4	●		7.940
3/8	3/8	1	2 1/2	4	●	●	9.520
7/16	7/16	1	2 3/4	4	●		11.110
1/2	1/2	1	3	4	●	●	12.700
5/8	5/8	1 1/4	3 1/2	4	●	●	15.870
3/4	3/4	1 1/2	4	4	●	●	19.050
1	1	1 1/2	4	4	●	●	25.400

Series 3736 / 3732 - Standard length (Metric)



Cut Diameter mm	Shank Diameter mm	Length of Cut mm	OAL mm	No. Flutes	Series 3736 round shk	Series 3732 shk flats	Order Code
4.000	6.000	11.00	57.00	4	●	○	4.000
5.000	6.000	13.00	57.00	4	●	○	5.000
6.000	6.000	13.00	57.00	4	●	○	6.000
8.000	8.000	19.00	63.00	4	●	○	8.000
10.000	10.000	22.00	72.00	4	●	○	10.000
12.000	12.000	26.00	83.00	4	●	○	12.000
14.000	14.000	26.00	83.00	4	●	○	14.000
16.000	16.000	32.00	92.00	4	●	○	16.000
18.000	18.000	32.00	92.00	4	●	○	18.000
20.000	20.000	38.00	104.00	4	●	○	20.000
25.000	25.000	45.00	121.00	4	●	○	25.000



Detailed information and additional end mill options can be found in our 2010 full-line end mill catalog. Product information is also available on our website www.guhring.com on the Products & Services tab.

● = stocked in USA ○ = stocked internationally

RF 100 U Variable Helix End Mills

Series 3837 / 3838 - Long length with neck clearance (Metric)



Cut Dia = Shank dia (mm)	Shank Diameter mm	Neck dia. mm	Length of Cut mm	OAL mm	Neck length mm	No. Flutes	Series 3837 round shk	Series 3838 shk flats	Order Code
6.000	6.000	5.500	13.00	65.00	29.00	4	●	○	6.000
8.000	8.000	7.500	19.00	75.00	39.00	4	●	○	8.000
10.000	10.000	9.200	22.00	80.00	40.00	4	●	○	10.000
12.000	12.000	11.200	26.00	93.00	48.00	4	●	○	12.000
16.000	16.000	15.000	32.00	108.00	60.00	4	●	○	16.000
20.000	20.000	19.000	38.00	126.00	76.00	4	●	○	20.000

Series 3839 / 3871 - Long length with neck clearance (Metric)



Cut Dia = Shank dia (mm)	Shank Diameter mm	Neck dia. mm	Length of Cut mm	OAL mm	Neck length mm	No. Flutes	Series 3839 round shk	Series 3871 shk flats	Order Code
6.000	6.000	5.500	18.00	65.00	29.00	4	●	○	6.000
8.000	8.000	7.500	24.00	75.00	39.00	4	●	○	8.000
10.000	10.000	9.200	30.00	80.00	40.00	4	●	○	10.000
12.000	12.000	11.200	36.00	93.00	48.00	4	●	○	12.000
16.000	16.000	15.000	48.00	108.00	60.00	4	●	○	16.000
20.000	20.000	19.000	60.00	126.00	76.00	4	●	○	20.000

Series 3627 - Extra length with neck clearance (Metric)



Cut Diameter mm	Shank Diameter mm	Length of Cut mm	OAL mm	No. Flutes	Series 3627 round shk	Order Code
10.000	10.000	40.00	100.00	4	●	10.000
12.000	12.000	45.00	150.00	4	●	12.000
14.000	14.000	45.00	150.00	4	●	14.000
16.000	16.000	65.00	150.00	4	●	16.000
18.000	18.000	65.00	150.00	4	●	18.000
20.000	20.000	65.00	150.00	4	●	20.000
25.000	25.000	75.00	150.00	4	●	25.000

Series 3893 / 3894 - 3-flute end mill Standard length, stub flute length w/neck clearance (Metric)



Cut Diameter (mm)	Shank Diameter mm	Neck dia. mm	Length of Cut mm	OAL mm	Neck length mm	No. Flutes	Series 3893 round shk	Series 3894 shk flats	Order Code
3.000	6.000	2.700	4.00	57.00	15.00	3	●	○	3.000
4.000	6.000	3.700	5.00	57.00	18.00	3	●	○	4.000
5.000	6.000	4.500	6.00	57.00	18.00	3	●	○	5.000
6.000	6.000	5.500	7.00	57.00	21.00	3	●	○	6.000
8.000	8.000	7.500	9.00	63.00	27.00	3	●	○	8.000
10.000	10.000	9.200	11.00	72.00	32.00	3	●	○	10.000
12.000	12.000	11.200	12.00	83.00	38.00	3	●	○	12.000
16.000	16.000	15.000	16.00	92.00	44.00	3	●	○	16.000

Series 3891 / 3892 - 3-flute end mill Standard length with neck clearance (Metric)



Cut Diameter (mm)	Shank Diameter mm	Neck dia. mm	Length of Cut mm	OAL mm	Neck length mm	No. Flutes	Series 3891 round shk	Series 3892 shk flats	Order Code
3.000	6.000	2.700	8.00	57.00	15.00	3	●	○	3.000
4.000	6.000	3.700	11.00	57.00	18.00	3	●	○	4.000
5.000	6.000	4.500	13.00	57.00	18.00	3	●	○	5.000
6.000	6.000	5.500	13.00	57.00	21.00	3	●	○	6.000
8.000	8.000	7.500	19.00	63.00	27.00	3	●	○	8.000
10.000	10.000	9.200	22.00	72.00	32.00	3	●	○	10.000
12.000	12.000	11.200	26.00	83.00	38.00	3	●	○	12.000
16.000	16.000	15.000	32.00	92.00	44.00	3	●	○	16.000
20.000	20.000	19.000	38.00	104.00	54.00	3	●	○	20.000

RF 100 U Variable Helix End Mills



Series 3079 -
Standard length with corner radius (inch)

Cut Diameter	Shank Diameter	Length of Cut	OAL	Radius (in.)	No. Flutes	Series 3079 shk flats over 1/2"	Order Code
1/4	1/4	3/4	2 1/2	0.015	4	●	6.352
1/4	1/4	3/4	2 1/2	0.031	4	●	6.354
5/16	5/16	13/16	2 1/2	0.031	4	●	7.944
3/8	3/8	1	2 1/2	0.031	4	●	9.524
7/16	7/16	1	2 3/4	0.031	4	●	11.114
1/2	1/2	1 1/4	3 1/2	0.031	4	●	12.704
1/2	1/2	1 1/4	3 1/2	0.040	4	●	12.705
1/2	1/2	1 1/4	3 1/2	0.062	4	●	12.706
1/2	1/2	1 1/4	3 1/2	0.090	4	●	12.707
5/8	5/8	1 1/4	3 1/2	0.031	4	●	15.874
5/8	5/8	1 1/4	3 1/2	0.062	4	●	15.876
3/4	3/4	1 1/2	4	0.062	4	●	19.056
3/4	3/4	1 1/2	4	0.090	4	●	19.057
3/4	3/4	1 1/2	4	0.125	4	●	19.059
1	1	1 1/2	4	0.062	4	●	25.406
1	1	1 1/2	4	0.090	4	●	25.407
1	1	1 1/2	4	0.125	4	●	25.409



Series 3872 / 3873 -
Standard length with corner radius and neck clearance (Metric)

Cut Dia = Shank Dia	Neck Diameter	Length of Cut	OAL	Neck Length	Radius (in.)	No. Flutes	Series 3872 round shank	Series 3873 shank flats	Order Code
6.000	5.500	13.00	57.00	21.00	0.5	4	○	○	6.005
6.000	5.500	13.00	57.00	21.00	1.0	4	○	○	6.010
6.000	5.500	13.00	57.00	21.00	2.0	4	○	○	6.020
8.000	7.500	19.00	63.00	27.00	0.5	4	○	○	8.005
8.000	7.500	19.00	63.00	27.00	1.0	4	○	○	8.010
8.000	7.500	19.00	63.00	27.00	2.0	4	○	○	8.020
10.000	9.200	22.00	72.00	32.00	0.5	4	○	○	10.005
10.000	9.200	22.00	72.00	32.00	1.0	4	○	○	10.010
10.000	9.200	22.00	72.00	32.00	2.0	4	○	○	10.020
12.000	11.200	26.00	83.00	38.00	0.5	4	○	○	12.005
12.000	11.200	26.00	83.00	38.00	1.0	4	○	○	12.010
12.000	11.200	26.00	83.00	38.00	2.0	4	○	○	12.020
16.000	15.000	32.00	92.00	44.00	0.5	4	○	○	16.005
16.000	15.000	32.00	92.00	44.00	1.0	4	○	○	16.010
16.000	15.000	32.00	92.00	44.00	2.0	4	○	○	16.020
16.000	15.000	32.00	92.00	44.00	3.0	4	○	○	16.030
20.000	19.000	38.00	104.00	54.00	0.5	4	○	○	20.005
20.000	19.000	38.00	104.00	54.00	1.0	4	○	○	20.010
20.000	19.000	38.00	104.00	54.00	2.0	4	○	○	20.020
20.000	19.000	38.00	104.00	54.00	3.0	4	○	○	20.030
25.000	23.500	45.00	121.00	65.00	2.0	4	○	○	25.020
25.000	23.500	45.00	121.00	65.00	3.0	4	○	○	25.030

To order: Series no. + order code, example: 3079 6.352

Free toolfinder software

Find the best-suited Guhring cutting tools for your application -- quickly and easily -- with Guhring Navigator. Go to www.guhring.com and click on the icon to test drive this software.





✓ **Gühring Select Drills:**

#515 PM Cobalt 3xD GT 500 DZ parabolic drills
#530 PM Cobalt 5xD GT 500 DZ parabolic drills
#730 gen. purpose, stub length, carbide, bright finish
#732 gen. purpose, jobber length, carbide, bright finish
#2463 gen. purpose, stub length, carbide, FIREX® coated
#2464 gen. purpose, jobber length, carbide, FIREX® coat
#5510 RT100U, coolant fed, 3xD, carbide, FIREX® coated
#5511 RT100U, coolant fed, 5xD, carbide, FIREX® coated
#5512 RT100U, coolant fed, 7xD, carbide, FIREX® coated
#5525 RT100U, coolant fed, 12xD, carbide, FIREX® coated
#5514 RT100U, high penetration, 3xD, carbide, FIREX®
#5515 RT100U, high penetration, 5xD, carbide, FIREX®
#5518 GS200G, three flute, 5xD, carbide, bright finish
#546 142° NC spot drill, carbide, bright finish
#723 90° NC spot drill, carbide, bright finish
#724 120° NC spot drill, carbide, bright finish

✓ **Gühring Select Variable Helix End Mills:**

#3079 RF100 U, std. length, corner radius, FIREX® coat
#3099 RF100 U, stub length, with flat, FIREX® coated
#3100 RF100 U, std. length, with flat, FIREX® coat
#3113 RF100 U, stub length, FIREX® coated
#3114 RF100 U, standard length, FIREX® coated
#3627 RF100 U, long length, metric, FIREX® coated
#3731 RF100 U, stub length, w/ flat, metric, FIREX® coat
#3732 RF100 U, std. length, w/ flat, metric, FIREX® coat
#3736 RF100 U, std. length, metric, FIREX® coated
#3837 RF100 U, long lgth w/neck clearance, metric
#3838 RF100 U, long lgth w/neck clearance, metric
#3839 RF100 U, long length, metric, FIREX® coated
#3871 RF100 U, long length, metric, FIREX® coated
#3872 RF100 U, std. lgth w/corner radius, metric, FIREX®
#3873 RF100 U, std. lgth w/corner radius, metric, FIREX®
#3891 RF100 U, 3-flute, std. lgth, metric, FIREX® coat
#3892 RF100 U, 3-flute, std. lgth, metric, FIREX® coat
#3893 RF100 U, 3-flute, std. lgth, stub flute lgth, FIREX®
#3894 RF100 U, 3-flute, std. lgth, stub flute lgth, FIREX®

✓ **Gühring Select Cobalt Gen. Purpose Taps:**

#3900 metric, plug tap, yellow ring, bright finish
#3901 UNC, plug tap, yellow ring, bright finish
#3902 UNF, plug tap, yellow ring, bright finish
#3903 metric, semi-btm tap, yellow ring, bright
#3904 UNC, semi-btm tap, yellow ring, bright
#3905 UNF, semi-btm tap, yellow ring, bright
#3960 metric, plug tap, yellow ring, MolyGlide®
#3961 UNC, plug tap, yellow ring, MolyGlide®
#3962 UNF, plug tap, yellow ring, MolyGlide®
#3963 metric, semi-btm tap, yellow ring, MolyGlide®
#3964 UNC, semi-btm tap, yellow ring, MolyGlide®
#3965 UNF, semi-btm tap, yellow ring, MolyGlide®

GUHRING
The Tool Company

Gühring, Inc.
P.O. Box 643, Brookfield, WI 53008-0643

Shipping Address
1445 Commerce Avenue
Brookfield, WI 53045
Tel (262) 784-6730 (800) 776-6170
Fax (262) 784-9096

www.guhring.com

West Coast Distribution Center
17902 Georgetown Lane
Huntington Beach, CA 92647

Gühring Corporation
20 Steckle Place, Unit #14
Kitchener, ON N2E 2C3
Tel (519) 748-9664 (800) 463-5555
Fax (519) 748-2954