

GUHRING

- Unique price-performance ratio
- Available single and in drill sets in cases



TiN-tip coated HSS jobber drills

SUPER
PRICE

SUPER
QUALITY

SUPER
AVAILABILITY

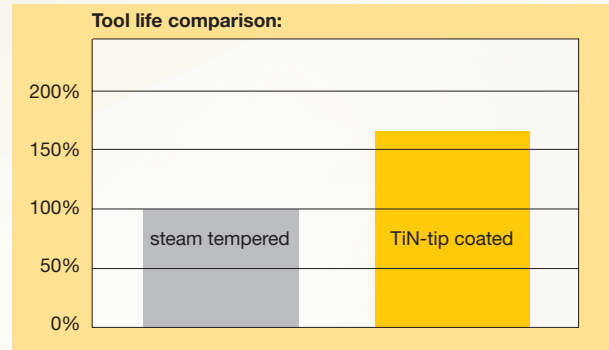


TiN-tip coated HSS jobber drills at unique price-performance ratio

- The TiN-coating at the tip of the tool reduces tool flank and crater wear and, therefore, increases performance of the HSS drills.
- The bright flute surface minimises friction during chip evacuation and improves the machining of materials where the chips have a tendency to jamming
- The point geometry and web thinning offer optimised spotting characteristics, precise centring and an accurate hole tolerance.

Especially suitable for the machining of:

- steel and cast steel (alloyed and unalloyed)
- grey cast iron, malleable cast iron, spheroidal graphite iron
- sintered iron and graphite



Jobber drills

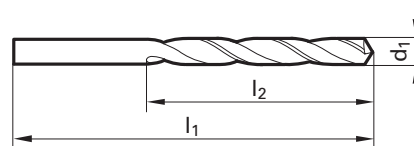
HSS
DIN 338
N
5xD
118°
h8

Tool material **HSS**

Surface **S**

Type **N**

P	•	• TiN-tip coated
M		• Relieved cone
K	•	• Web thinned ≥ 1.0 mm
N	•	
S		
H		



Guhring no. 9651				Guhring no. 9651			
Discount group 159				Discount group 159			
Cutting direction (R)				Cutting direction (R)			
d1		l1	l2	d1		l1	l2
mm	inch	mm	mm	mm	inch	mm	mm
1,00		34,00	12,00	2,40		57,00	30,00
1,10		36,00	14,00	2,50		57,00	30,00
1,19	3/64	38,00	16,00	2,60		57,00	30,00
1,20		38,00	16,00	2,70		61,00	33,00
1,30		38,00	16,00	2,78		61,00	33,00
1,40		40,00	18,00	2,80		61,00	33,00
1,50		40,00	18,00	2,90		61,00	33,00
1,59	1/16	43,00	20,00	3,00		61,00	33,00
1,60		43,00	20,00	3,10		65,00	36,00
1,70		43,00	20,00	3,17	1/8	65,00	36,00
1,80		46,00	22,00	3,20		65,00	36,00
1,90		46,00	22,00	3,30		65,00	36,00
1,98	5/64	49,00	24,00	3,40		70,00	39,00
2,00		49,00	24,00	3,50		70,00	39,00
2,10		49,00	24,00	3,57	9/64	70,00	39,00
2,20		53,00	27,00	3,60		70,00	39,00
2,30		53,00	27,00	3,70		70,00	39,00
2,38	3/32	57,00	30,00	3,80		75,00	43,00



Guhring no.				9651	Guhring no.				9651
Discount group				159	Discount group				159
Cutting direction				(R)	Cutting direction				(R)
d1		l1	l2	Availability	d1		l1	l2	Availability
mm	inch	mm	mm		mm	inch	mm	mm	
3,90		75,00	43,00	●	9,60		133,00	87,00	●
3,97	5/32	75,00	43,00	●	9,70		133,00	87,00	●
4,00		75,00	43,00	●	9,80		133,00	87,00	●
4,10		75,00	43,00	●	9,90		133,00	87,00	●
4,20		75,00	43,00	●	9,92	25/64	133,00	87,00	●
4,30		80,00	47,00	●	10,00		133,00	87,00	●
4,37	11/64	80,00	47,00	●	10,10		133,00	87,00	●
4,40		80,00	47,00	●	10,20		133,00	87,00	●
4,50		80,00	47,00	●	10,30		133,00	87,00	●
4,60		80,00	47,00	●	10,32	13/32	133,00	87,00	●
4,70		80,00	47,00	●	10,40		133,00	87,00	●
4,76	3/16	86,00	52,00	●	10,50		133,00	87,00	●
4,80		86,00	52,00	●	10,60		133,00	87,00	●
4,90		86,00	52,00	●	10,70		142,00	94,00	●
5,00		86,00	52,00	●	10,72	27/64	142,00	94,00	●
5,10		86,00	52,00	●	10,80		142,00	94,00	●
5,16	13/64	86,00	52,00	●	10,90		142,00	94,00	●
5,20		86,00	52,00	●	11,00		142,00	94,00	●
5,30		86,00	52,00	●	11,10		142,00	94,00	●
5,40		93,00	57,00	●	11,11	7/16	142,00	94,00	●
5,50		93,00	57,00	●	11,20		142,00	94,00	●
5,56	7/32	93,00	57,00	●	11,30		142,00	94,00	●
5,60		93,00	57,00	●	11,40		142,00	94,00	●
5,70		93,00	57,00	●	11,50		142,00	94,00	●
5,80		93,00	57,00	●	11,51	29/64	142,00	94,00	●
5,90		93,00	57,00	●	11,60		142,00	94,00	●
5,95	15/64	93,00	57,00	●	11,70		142,00	94,00	●
6,00		93,00	57,00	●	11,80		142,00	94,00	●
6,10		101,00	63,00	●	11,90		151,00	101,00	●
6,20		101,00	63,00	●	11,91	15/32	151,00	101,00	●
6,30		101,00	63,00	●	12,00		151,00	101,00	●
6,35	1/4	101,00	63,00	●	12,10		151,00	101,00	●
6,40		101,00	63,00	●	12,20		151,00	101,00	●
6,50		101,00	63,00	●	12,30	31/64	151,00	101,00	●
6,60		101,00	63,00	●	12,40		151,00	101,00	●
6,70		101,00	63,00	●	12,50		151,00	101,00	●
6,75	17/64	109,00	69,00	●	12,60		151,00	101,00	●
6,80		109,00	69,00	●	12,70	1/2	151,00	101,00	●
6,90		109,00	69,00	●	12,80		151,00	101,00	●
7,00		109,00	69,00	●	12,90		151,00	101,00	●
7,10		109,00	69,00	●	13,00		151,00	101,00	●
7,14	9/32	109,00	69,00	●	13,10	33/64	151,00	101,00	●
7,20		109,00	69,00	●	13,20		151,00	101,00	●
7,30		109,00	69,00	●	13,25		160,00	108,00	●
7,40		109,00	69,00	●	13,30		160,00	108,00	●
7,50		109,00	69,00	●	13,40		160,00	108,00	●
7,54	19/64	117,00	75,00	●	13,49	17/32	160,00	108,00	●
7,60		117,00	75,00	●	13,50		160,00	108,00	●
7,70		117,00	75,00	●	13,60		160,00	108,00	●
7,80		117,00	75,00	●	13,70		160,00	108,00	●
7,90		117,00	75,00	●	13,75		160,00	108,00	●
7,94	5/16	117,00	75,00	●	13,80		160,00	108,00	●
8,00		117,00	75,00	●	13,89	35/64	160,00	108,00	●
8,10		117,00	75,00	●	13,90		160,00	108,00	●
8,20		117,00	75,00	●	14,00		160,00	108,00	●
8,30		117,00	75,00	●	14,25		169,00	114,00	●
8,33	21/64	117,00	75,00	●	14,29	9/16	169,00	114,00	●
8,40		117,00	75,00	●	14,50		169,00	114,00	●
8,50		117,00	75,00	●	14,68	37/64	169,00	114,00	●
8,60		125,00	81,00	●	14,75		169,00	114,00	●
8,70		125,00	81,00	●	15,00		169,00	114,00	●
8,73		125,00	81,00	●	15,08	19/32	178,00	120,00	●
8,80		125,00	81,00	●	15,25		178,00	120,00	●
8,90		125,00	81,00	●	15,48	39/64	178,00	120,00	●
9,00		125,00	81,00	●	15,50		178,00	120,00	●
9,10		125,00	81,00	●	15,75		178,00	120,00	●
9,13	23/64	125,00	81,00	●	16,00		178,00	120,00	●
9,20		125,00	81,00	●					
9,30		125,00	81,00	●					
9,40		125,00	81,00	●					
9,50		125,00	81,00	●					
9,52	3/8	133,00	87,00	●					

Straight shank twist drills

Jobber drill sets in cases



Tool material **HSS**

Surface **S**

Type **N**

- | | | |
|----------|---|-----------------------------|
| P | • | • TiN-tip coated |
| M | | • Relieved cone |
| K | • | • Web thinned ≥ 1.0 mm |
| N | • | |
| S | | |
| H | | |



Guhring no.

Discount group

Cutting direction

Ø range mm	in increments of mm	Jobber drills pieces	Set in case Code no.
1,0 - 5,9	0,1	50	6,015
6,0 - 10,0	0,1	41	6,016
1,0 - 10,0	0,5	19	6,013
1,0 - 10,5	0,5	24*	6,018
1,0 - 13,0	0,5	25	6,014

* incl. Ø 3.3/4.2/6.8/10.2 mm

234

159



Availability



GUHRING

Guhring KG

P.O. Box 100247 • 72423 Albstadt
Herderstrasse 50-54 • 72458 Albstadt

Tel. +49 74 31 17-0
Fax +49 74 31 17-21279

info@guehring.de
www.guehring.de