

Ratio drills

Tool illustration						Tool material	Guhring no.
Standard	Type	Surface	Drilling depth	Shank design	Diameter range		

Ratio drills without oil feed

	Solid carbide	1184					
DIN 6537 K	RT 100 U	S	3 x D	HE	3,000 - 20,000		
	Solid carbide	1673					
DIN 6537 K	RT 100 U	S	3 x D	HA	3,000 - 20,000		
	Solid carbide	2472					
DIN 6537 K	RT 100 U	F	3 x D	HE	3,000 - 20,000		
	Solid carbide	2480					
DIN 6537 K	RT 100 U	F	3 x D	HA	3,000 - 20,000		
	Solid carbide	1659					
DIN 6537 K	RT 100 F	S	3 x D	HA	4,600 - 13,000		
	Solid carbide	2475					
DIN 6537 K	RT 100 F	F	3 x D	HA	3,700 - 13,000		
	Solid carbide	2717					
DIN 6537 L	RT 100 U	S	5 x D	HA	3,000 - 16,000		
	Solid carbide	2718					
DIN 6537 L	RT 100 U	S	5 x D	HE	3,000 - 16,000		
	Solid carbide	2719					
DIN 6537 L	RT 100 U	F	5 x D	HE	3,000 - 20,000		
	Solid carbide	2996					
DIN 6537 L	RT 100 U	F	5 x D	HA	3,000 - 20,000		
	Solid carbide	2712					
DIN 6537 L	RT 100 F	F	5 x D	HA	3,000 - 16,000		
	Solid carbide	1242					
DIN 6539	RT 100 U	S	3 x D	DZ	3,000 - 16,000		
	Solid carbide	2473					
DIN 6539	RT 100 U	F	3 x D	DZ	3,000 - 16,000		
	Solid carbide	1702					
DIN 6539	RT 100 F	S	3 x D	DZ	3,000 - 15,000		

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Ratio drills without oil feed

	Solid carbide	1798					
DIN 6539	RT 100 G	○	3 x D	DZ	3,000 - 16,000		
	Solid carbide	1243					
Guhring std.	RT 100 U	S	5 x D	DZ	5,000 - 16,000		
	Solid carbide	2474					
Guhring std.	RT 100 U	F	5 x D	DZ	5,000 - 16,000		
	Solid carbide	1799					
Guhring std.	RT 100 G	○	5 x D	DZ	5,000 - 15,000		

Ratio drills with oil feed

	Solid carbide	1181					
DIN 6537 K	RT 100 U	S	3 x D	HE	3,000 - 20,000		
	Solid carbide	1661					
DIN 6537 K	RT 100 U	S	3 x D	HA	5,000 - 21,000		
	Solid carbide	2469					
DIN 6537 K	RT 100 U	F	3 x D	HE	3,000 - 20,000		
	Solid carbide	2477					
DIN 6537 K	RT 100 U	F	3 x D	HA	3,000 - 20,000		
	Solid carbide	1180					
DIN 6537 K	RT 100 F	S	3 x D	HE	3,300 - 25,000		
	Solid carbide	1660					
DIN 6537 K	RT 100 F	S	3 x D	HA	3,100 - 22,000		
	Solid carbide	2468					
DIN 6537 K	RT 100 F	F	3 x D	HE	3,000 - 20,000		
	Solid carbide	1183					
DIN 6537 L	RT 100 U	S	5 x D	HE	3,300 - 20,000		
	Solid carbide	1663					
DIN 6537 L	RT 100 U	S	5 x D	HA	3,000 - 19,500		

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

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Ratio drills with oil feed

	Solid carbide	2471			
DIN 6537 L	RT 100 U	F	5 x D	HE	3,000 - 20,000
	Solid carbide	2479			
DIN 6537 L	RT 100 U	F	5 x D	HA	3,000 - 20,000
	Solid carbide	1182			
DIN 6537 L	RT 100 F	S	5 x D	HE	3,000 - 25,000
	Solid carbide	1662			
DIN 6537 L	RT 100 F	S	5 x D	HA	3,000 - 24,500
	Solid carbide	2470			
DIN 6537 L	RT 100 F	F	5 x D	HE	3,000 - 20,000
	Solid carbide	2478			
DIN 6537 L	RT 100 F	F	5 x D	HA	3,000 - 20,000
	Solid carbide	6501			
DIN 6537 L	RT 100 R	F	5 x D	HA	3,000 - 20,000
	Solid carbide	2711			
Guhring std.	RT 100 U	S	7 x D	HA	3,000 - 19,500
	Solid carbide	4044			
Guhring std.	RT 100 U	F	7 x D	HA	3,000 - 20,000
	Solid carbide	4045			
Guhring std.	RT 100 U	F	7 x D	HE	3,000 - 20,000
	Solid carbide	6502			
Guhring std.	RT 100 R	F	7 x D	HA	4,000 - 20,000
	Solid carbide	768			
Guhring std.	RT 150 GG	○	4 x D	HA	3,000 - 20,000
	Solid carbide	6068			
Guhring std.	RT 150 GG	○	4 x D	HA	3,000 - 20,000
	Solid carbide	769			
Guhring std.	RT 150 GG	○	7 x D	HA	3,000 - 20,000

Ratio drills with oil feed

	Solid carbide	6069			
Guhring std.	RT 150 GG	○	7 x D	HA	3,000 - 20,000
	Solid carbide	770			
Guhring std.	RT 150 GG	○	10 x D	HA	3,000 - 20,000
	Solid carbide	6070			
Guhring std.	RT 150 GG	○	10 x D	HA	3,000 - 20,000
	Solid carbide	773			
Guhring std.	RT 150 GN	○	15 x D	HA	5,000 - 14,000
	Solid carbide	6511			
Guhring std.	RT 100 T	A	20 x D	HA	3,000 - 14,000
	Solid carbide	6512			
Guhring std.	RT 100 T	A	25 x D	HA	3,000 - 12,000
	Solid carbide	6513			
Guhring std.	RT 100 T	A	30 x D	HA	3,000 - 10,000
	Solid carbide	6514			
Guhring std.	RT 100 T	A	40 x D	HA	3,000 - 8,000
	Carbide	1171			
DIN 6538 K	RT 80 U	S	3 x D	HE	9,500 - 25,500
	Carbide	1172			
DIN 6538 M	RT 80 U	S	5 x D	HE	9,500 - 25,500
	Carbide	1173			
DIN 6538 L	RT 80 U	S	7 x D	HE	9,500 - 25,000

3-flute Ratio drills









	Solid carbide	2713			
DIN 6537 L	FT 200 G	○	5 x D	HA	3,000 - 20,000
	Solid carbide	2939			
DIN 6537 L	FT 200 G	F	5 x D	HA	5,000 - 18,500

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

Ratio drills




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3-flute Ratio drills

					Solid carbide	731
DIN 6539	GS 200 U	○	5 x D	DZ	3,000 - 20,000	
					Solid carbide	611
DIN 6539	GS 200 U	Ⓢ	5 x D	DZ	3,000 - 19,500	
					Solid carbide	1021
DIN 6539	GS 200 U	○	5 x D	DZ	3,700 - 17,000	
					Solid carbide	745
DIN 6539	GS 200 G	○	3 x D	DZ	3,570 - 19,500	
					Solid carbide	1020
DIN 6539	GS 200 G	○	3 x D	DZ	3,600 - 20,000	
					Solid carbide	1024
DIN 6539	GS 200 G	○	5 x D	DZ	4,100 - 19,500	
					Solid carbide	1025
DIN 6539	GS 200 G	○	5 x D	DZ	3,000 - 24,000	
					Solid carbide	1027
DIN 6539	GS 200 F	Ⓢ	5 x D	DZ	3,000 - 18,500	

Tool illustration					Tool material	Guhring no.
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3-flute stepped Ratio drills

					Solid carbide	1033
Guhring std.	GS 200 U	○		DZ	4,000 - 20,000	
					Solid carbide	1032
Guhring std.	GS 200 G	○		DZ	3,400 - 20,000	
					Solid carbide	1034
Guhring std.	GS 200 G	Ⓢ		DZ	3,100 - 20,000	

○ bright
Ⓐ AlTiN

● steam tempered
Ⓒ TiCN

◐ nitrided lands
Ⓕ FIRE

● nitrided
Ⓗ AlCrN

● golden brown
Ⓢ TiN

Ⓐ TiAlN
Ⓜ MolyGlide