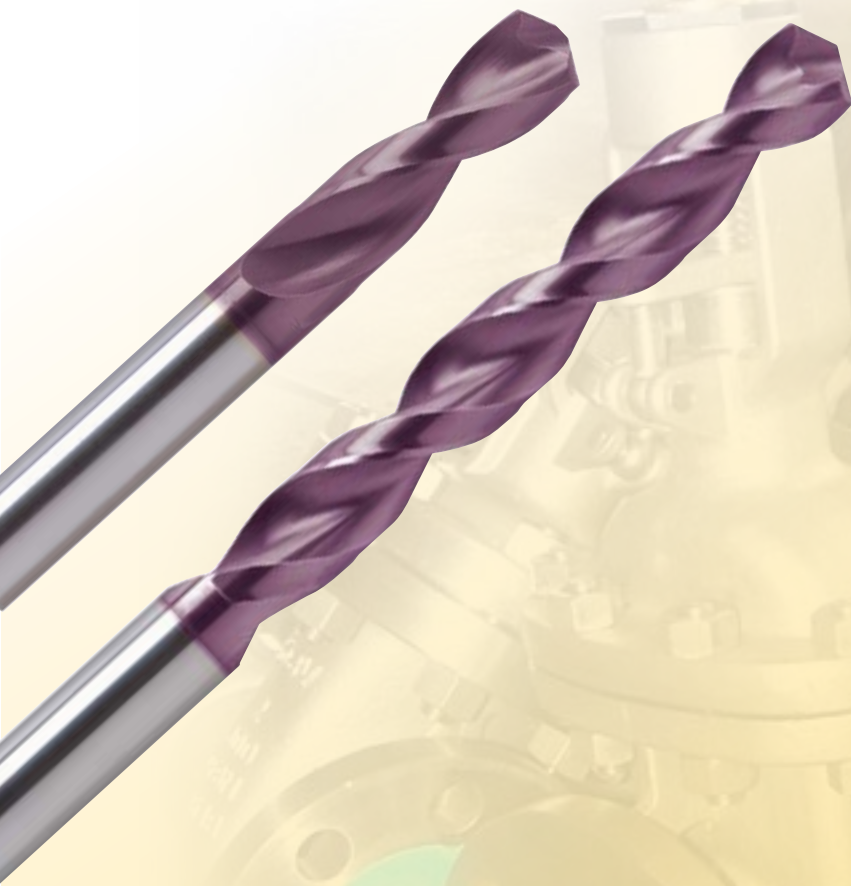


GUHRING

The Tool Company

GT 500 DZ Parabolic Flute Powdered Metal Cobalt Drills



- * FIREX[®] coated for heat and wear resistance*
- * Parabolic flute profile promotes chip flow*
- * Tough premium PM cobalt substrate*
- * Over 175 new stocked sizes*



GT 500 DZ Powdered Metal Cobalt Drills

Series 515 (3xD), Series 530 (5xD)





Specialized Type B 130° cone relief point geometry
Designed for machining tough materials

Open GT 500 parabolic flute profile
Provides more room for chip evacuation, eliminates need for pecking

Powdered metal cobalt substrate
Bridges the gap between cost-effective HSS and high-performance carbide

FIREX® coated for maximum heat and abrasion resistance
Multilayer PVD coating extends tool life and maximizes performance

Well-suited to run in:

-  Universal Steels
-  Stainless Steels
-  Hardened Materials
-  Cast Iron

Dec. inch	Diameter			Series 515		Series 530	
	Fract. inch	Wire / letter	mm	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

Dec. inch	Diameter			Series 515		Series 530	
	Fract. inch	Wire / letter	mm	Overall Length	Flute Length	Overall Length	Flute Length
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
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

Dec. inch	Diameter		Series 515		Series 530		
	Fract. inch	Wire / letter	mm	Overall Length	Flute Length	Overall Length	Flute Length
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
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

Dec. inch	Diameter		Series 515		Series 530		
	Fract. inch	Wire / letter	mm	Overall Length	Flute Length	Overall Length	Flute Length
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		
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			9.130	84.00	40.00	125.00	81.00
0.3622	23/64		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	142.00	94.00
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

Items in RED are NEW sizes

Cutting dia. = shank dia.



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.

Drill Operating Parameters

Series # 515, 530

Material group	Hardness	SFM	Feed Rate - IPR									
			1/16 in. 1.590 mm	1/8 in. 3.170 mm	1/4 in. 6.350 mm	3/8 in. 9.520 mm	1/2 in. 12.700 mm	5/8 in. 15.870 mm	3/4 in. 19.050 mm	1 in. 25.400 mm	1 1/4 in. 31.750 mm	1 1/2 in. 38.100 mm
Common structural steels	≤100 Bhn	160	0.0017	0.0050	0.0080	0.0100	0.0125	0.0125	*	*	*	*
	>100-260 Bhn	130	0.0015	0.0040	0.0065	0.0080	0.0100	0.0100	*	*	*	*
Free-cutting steels	≤24 Rc	195	0.0017	0.0050	0.0080	0.0100	0.0125	0.0125	*	*	*	*
	>24-30 Rc	160	0.0017	0.0050	0.0080	0.0100	0.0125	0.0125	*	*	*	*
Unalloyed heat-treatable steels	≤16 Rc	130	0.0017	0.0050	0.0080	0.0100	0.0125	0.0125	*	*	*	*
	16-24 Rc	130	0.0017	0.0050	0.0080	0.0100	0.0125	0.0125	*	*	*	*
	24-30 Rc	100	0.0015	0.0040	0.0065	0.0080	0.0100	0.0100	*	*	*	*
Alloyed heat-treatable steels	24-30 Rc	100	0.0012	0.0030	0.0050	0.0065	0.0080	0.0080	*	*	*	*
	>30-38 Rc	100	0.0012	0.0030	0.0050	0.0065	0.0080	0.0080	*	*	*	*
Unalloyed case hardened steels	≤230 Bhn	130	0.0010	0.0025	0.0040	0.0050	0.0065	0.0065	*	*	*	*
Alloyed case hardened steels	24-30 Rc	80	0.0012	0.0030	0.0050	0.0065	0.0080	0.0080	*	*	*	*
	>30-38 Rc	65	0.0010	0.0025	0.0040	0.0050	0.0065	0.0065	*	*	*	*
Nitriding steels	>24-30 Rc	65	0.0012	0.0030	0.0050	0.0065	0.0080	0.0080	*	*	*	*
	>30-38 Rc	65	0.0010	0.0025	0.0040	0.0050	0.0065	0.0065	*	*	*	*
Tool steels	≤24 Rc	80	0.0012	0.0030	0.0050	0.0065	0.0080	0.0080	*	*	*	*
	>24-30 Rc	65	0.0010	0.0025	0.0040	0.0050	0.0065	0.0065	*	*	*	*
High speed steels	≥14-30 Rc	65	0.0010	0.0025	0.0040	0.0050	0.0065	0.0065	*	*	*	*
Spring steels	≤330 Bhn	35	0.0007	0.0020	0.0030	0.0040	0.0050	0.0050	*	*	*	*
Stainless steels, sulphured	≤24 Rc	65	0.0012	0.0030	0.0050	0.0065	0.0080	0.0080	*	*	*	*
	austenitic	≤24 Rc	45	0.0010	0.0025	0.0040	0.0050	0.0065	0.0065	*	*	*
	martensitic	≤24 Rc	65	0.0010	0.0025	0.0040	0.0050	0.0065	0.0065	*	*	*
Hardened steels	≤40-48 Rc	*	*	*	*	*	*	*	*	*	*	*
	>48-60 Rc	*	*	*	*	*	*	*	*	*	*	*
Special alloys	≤38 Rc	40	0.0007	0.0020	0.0030	0.0040	0.0050	0.0050	*	*	*	*
Cast iron	≤240 Bhn	145	0.0017	0.0050	0.0080	0.0100	0.0125	0.0125	*	*	*	*
	>300 Bhn	115	0.0017	0.0050	0.0080	0.0100	0.0125	0.0125	*	*	*	*
Spheroidal graphite iron and malleable cast iron	≤240 Bhn	130	0.0017	0.0050	0.0080	0.0100	0.0125	0.0125	*	*	*	*
	>300 Bhn	100	0.0017	0.0050	0.0080	0.0100	0.0125	0.0125	*	*	*	*
Chilled cast iron	≤350 Bhn	*	*	*	*	*	*	*	*	*	*	*
Ti and Ti-alloys	≤24 Rc	*	*	*	*	*	*	*	*	*	*	*
	>24-38 Rc	*	*	*	*	*	*	*	*	*	*	*
Aluminium and Al-alloys	≤120 Bhn	*	*	*	*	*	*	*	*	*	*	*
	Al wrought alloys	≤150 Bhn	*	*	*	*	*	*	*	*	*	*
Al cast alloys ≤ 10 % Si	≤200 Bhn	295	0.0020	0.0065	0.0100	0.0125	0.0160	0.0160	*	*	*	*
	> 10 % Si	260	0.0017	0.0050	0.0080	0.0100	0.0125	0.0125	*	*	*	*
Magnesium alloys	≤150 Bhn	260	0.0017	0.0050	0.0080	0.0100	0.0125	0.0125	*	*	*	*
Copper, low-alloyed	≤120 Bhn	*	*	*	*	*	*	*	*	*	*	*
Brass, short-chipping	≤200 Bhn	*	*	*	*	*	*	*	*	*	*	*
	long-chipping	≤200 Bhn	*	*	*	*	*	*	*	*	*	*
Bronze, short-chipping	≤200 Bhn	*	*	*	*	*	*	*	*	*	*	*
	>200-260 Bhn	*	*	*	*	*	*	*	*	*	*	*
Bronze, long-chipping	≤24 Rc	*	*	*	*	*	*	*	*	*	*	*
	>24-30 Rc	*	*	*	*	*	*	*	*	*	*	*
Duroplastics	-	*	*	*	*	*	*	*	*	*	*	*
Thermoplastics	-	*	*	*	*	*	*	*	*	*	*	*
Reinforced plastics - Kevlar	-	*	*	*	*	*	*	*	*	*	*	*
Reinforced plastics - GFK / CFK	-	*	*	*	*	*	*	*	*	*	*	*

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