

powertap

UNIVERSAL TAPS

MADE BY

GUHRING

**GOLD FOR
WINNERS
New: ISO 529
Powertaps**

TOP OF
FORM
UNIV
pow
perfect
choice
PROC
PERFE
UNIV
pow
Power

TR
RS
AF
ul
eal
life
BLE
ORM
AL
il
VE

PERFECT CHOICE
FOR MANY MATERIALS
**POWER
PRICE**
UNIV
VER
UNIVERSAL TAPS SAL
ALUNC Power
VERSAL TAPS
SAL perfect thread form
APS powerful UNF

Available from:



High-tensile
steels

Stainless and
acid-resistant
steels

Aluminium
and aluminium
alloys

General
steels

Cast
materials

POWERTAP – ABSOLUTELY PERFECT

A PowerTap is always **the right choice!** It is a true **universal tap** covering a **broad range of applications**.
Count on **Guhring's golden power!**

*power***tap**



GOLD FOR MAXIMUM POWER

Everything is just right with Guhring's new PowerTaps: Performance, quality, price and universal application range. Guhring's PowerTap program includes powerful taps for the most common threads. State-of-the-art manufacturing technology guarantees highest quality "Made in Germany" at unmatched low prices. In addition, the special geometry of Guhring PowerTaps makes them genuine all-rounders in close to all materials.

The golden ring indicates: With a Guhring PowerTap you are spot-on!

by **GUHRING**

MORE POWER FOR YOUR PRODUCTION

PowerTap – top quality from Germany at a power price

YOUR ADVANTAGES:

- » UNMATCHABLE PRICE-PERFORMANCE RATIO
- » MAXIMUM STOCK AVAILABILITY
- » SUPER QUALITY
- » SHORT DELIVERY TIMES
- » PERFECT THREADS
- » MAXIMUM PROCESS RELIABILITY

Optimised geometries for maximum performance!



Completely precision ground on specially developed machines!



Finest quality steels as tool material!



More power for your production!



In Treuen/Saxony Guhring has built for you: **4000 m² facility with state-of-the-art manufacturing technology!**



Now even easier
and
quicker
to the perfect
Powertap.



Tool material			HSS-E	HSS-E	HSS-E-PM	HSS-E	HSS-E-PM	HSS-E	HSS-E-PM	HSS-E
Type/form			NR40/C	NR40/C	NR40/C	NR40/E	NR50/C	N/B	N/B	N/C
Surface finish										
Cooling										
Thread type	Tolerance zone	Dim. to DIN 2184-1	Guhring no. Ø-range Prices on page							
M	ISO 2 6H	DIN 371	5734 M3 – M10	5737 M2 – M10		5721 M3 – M10	5722 M3 – M10	5733 M3 – M10	5736 M2 – M10	
M	ISO 3 6G	DIN 371	5720 M3 – M10					5719 M3 – M10		
M	6HX	Guhring standard (long reach)		5718 M3 – M20						
M	ISO 2 6H	DIN 376	5717 M3 – M20				5722 M12 – M20	5716 M3 – M20	5736 M12 – M20	
M	6HX	DIN 376		5738 M3 – M24						
M	ISO 2 6H	ISO 529	4036 M3 – M20					4034 M3 – M20		4035 M3 – M20
MF	ISO 2 6H	DIN 374	5724 M4x0.5 – M20x1.5		5740 M8x1 – M24x2			5723 M4x0.5 – M20x1.5	5739 M8x1 – M24x2	
UNC	2B	~ DIN 371	5726 Nr. 4-40 – 3/8 - 16					5725 Nr. 4-40 – 3/8 - 16		
UNC	2B	~ DIN 376	5726 7/16 - 14 – 3/4 - 10					5725 7/16 - 14 – 3/4 - 10		
UNF	2B	~ DIN 374	5728 Nr. 4-48 – 5/8 - 18					5727 Nr. 4-48 – 5/8 - 18		
G BSP-taps	–	DIN 5156	5732 G 1/8 – G 1					5731 G 1/8 – G 1		

Shank designs

DIN 371

DIN 376 / DIN 374 / DIN 5156



d₁ 0,9 ... 2,6 mm



d₁ > 2,6 ... 10 mm

Typee clarification

NR40= Type N, RH spiral 40°
NR50= Type N, RH spiral 50°



blind holes



steam tempered



through holes



TiN-coated

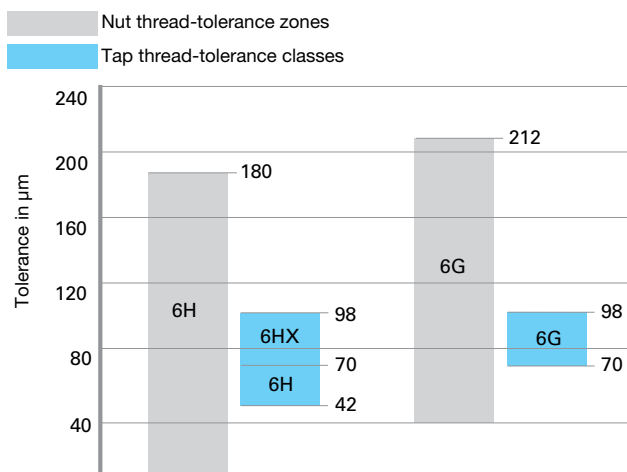


external cooling

			HSS-E	HSS-E	HSS-E	HSS-E	HSS-E-PM	HSS-E-PM	HSS-E-PM	HSS-E
			NR40/C	NR40/E	N/B	NR40/C	NR40/C	NR50/C	N/B	N/C
										
										
Thread			Ø-range on page							
M			8/10/11/16	13	17-19/21	9/12/15		14	20	22
MF			24		26		25		27	
UNC			28		29					
UNF			30		31					
BSP			32		33					
Material / ISO Material		Hardness N/mm ²	Recommended cutting speed v _c m/min							
P	Struct./free-cut./unall. heat-treat./case hard. steels	≤ 800	10	10	12	12	12	15	20	6
	Free-cutting steels, unall. case hard. steels, nitr. steels	800 - 1 000	8	8	10	10	10	12	15	x
	Alloyed heat-treatable, tool and high speed steels	800 - 1200	6	6	8	8	8	10	12	x
M	Stainless steel - easy to machine / sulphured	≤ 0750	6	6	8	8	8	10	12	x
	Stainless steel - moderately difficult to machine	750 - 950	6	6	8	8	8	10	12	x
K	Cast iron, grey cast iron, spher. graph./mall. cast iron		12	12	15	15	15	20	25	10
N	Aluminium, Al-wrought alloys, Al-alloys	≤ 6% Si	12	12	15	x	x	x	x	x
	Aluminium-cast alloys	≥ 6% Si	8	8	10	15	15	20	25	10
S	Titan, Ti-alloys		2	2	4	2	2	4	6	x
	Ni-alloys		x	x	x	x	x	2	4	x
H	Hardened steels	45 - 55 HRC	x	x	x	x	x	x	x	x
	Hardened steels	55 - 62 HRC	x	x	x	x	x	x	x	x

Available in all essential tolerances

Tolerance zone / tolerance class allocation



DIN EN 22857	
Application class of tap	
Class 2 ISO 2	Class 3 ISO 3
Tolerance zone of internal thread to be cut	
6H	6G
DIN 802 part 1 (withdrawn)	
Tolerance class of tap	
6H	6G

6H:

The tolerance zone 6H corresponds with the standard tolerance for taps to DIN EN 22857.

6HX:

The additional letter "X" (6HX) indicates taps produced with deviating tolerance to standard. These deviations are based upon the company standard. Taps produced to tolerance 6HX are, for example, selected for abrasive or tough materials.

6G:

The tolerance zone 6G corresponds with an over-size condition tolerance for taps to DIN EN 22857 and is applied for components that are, for example, surface treated.



blind holes

● steam tempered

☒ external cooling

Guhring no.

5734

Standard

DIN 2184-1

Standard

DIN 371

Tool material

HSS-E

Type

N R40

Form

C

Tolerance

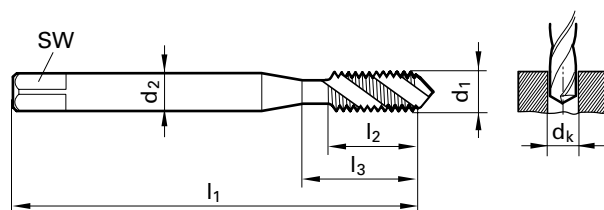
ISO 2 / 6H

Cutting direction

right-hand

Discount group

35



d1	P	d2	SW	dk	l1	l2	l3	Code no.
	mm	mm		mm	mm	mm	mm	
M 3	0.50	3.500	2.70	2.500	56.00	6.00	18.00	3.000
M 4	0.70	4.500	3.40	3.300	63.00	7.50	21.00	4.000
M 5	0.80	6.000	4.90	4.200	70.00	8.50	25.00	5.000
M 6	1.00	6.000	4.90	5.000	80.00	11.00	30.00	6.000
M 8	1.25	8.000	6.20	6.800	90.00	14.00	35.00	8.000
M10	1.50	10.000	8.00	8.500	100.00	16.00	39.00	10.000

Price per item in £

10.66

10.66

11.19

11.51

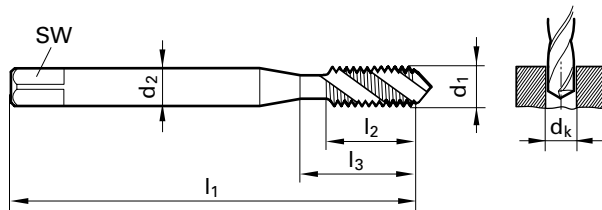
13.51

15.62

Table of application

ISO	P			M		K	N		S		H	
Material	Steel			Stainless steel		Cast iron	Aluminium		Special alloys		Hardened steel	
Properties	<800	<1000	<1200	<750	<950	GG	<6% Si	>6% Si	Ti	Ni	45-55 HRC	55-62 HRC
v _c m/min	10	8	6	6	6	12	12	8	2	x	x	x

 blind holes  TiN-coated  external cooling	Guhring no.	5737
	Standard	DIN 2184-1
	Standard	DIN 371
	Tool material	HSS-E
	Type	N R40
	Form	C
	Tolerance	ISO 2 / 6H
	Cutting direction	right-hand
	Discount group	35



d1	P	d2	SW	dk	l1	l2	l3	Code no.
	mm	mm		mm	mm	mm	mm	
M 2	0.40	2.800	2.10	1.600	45.00	4.50	13.50	2.000
M 3	0.50	3.500	2.70	2.500	56.00	6.00	18.00	3.000
M 4	0.70	4.500	3.40	3.300	63.00	7.50	21.00	4.000
M 5	0.80	6.000	4.90	4.200	70.00	8.50	25.00	5.000
M 6	1.00	6.000	4.90	5.000	80.00	11.00	30.00	6.000
M 8	1.25	8.000	6.20	6.800	90.00	14.00	35.00	8.000
M10	1.50	10.000	8.00	8.500	100.00	16.00	39.00	10.000

Price per item in £

11.72

13.51

14.46

14.68

18.37

19.84

25.34

Table of application

ISO	P			M		K	N		S		H	
Material	Steel			Stainless steel		Cast iron	Aluminium		Special alloys		Hardened steel	
Properties	<800	<1000	<1200	<750	<950	GG	<6% Si	>6% Si	Ti	Ni	45-55 HRC	55-62 HRC
v _c m/min	12	10	8	8	8	15	x	10	2	x	x	x



blind holes

● steam tempered

☒ external cooling

Guhring no.

5717

Standard

DIN 2184-1

Standard

DIN 376

Tool material

HSS-E

Type

N R40

Form

C

Tolerance

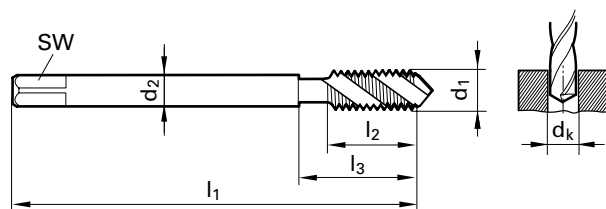
ISO 2 / 6H

Cutting direction

right-hand

Discount group

35



d1	P	d2	SW	dk	l1	l2	l3	Code no.
	mm	mm		mm	mm	mm	mm	
M 3	0.50	2.200		2.500	56.00	6.00	18.00	3.000
M 4	0.70	2.800	2.10	3.300	63.00	7.50	21.00	4.000
M 5	0.80	3.500	2.70	4.200	70.00	8.50	25.00	5.000
M 6	1.00	4.500	3.40	5.000	80.00	11.00	30.00	6.000
M 8	1.25	6.000	4.90	6.800	90.00	14.00	35.00	8.000
M10	1.50	7.000	5.50	8.500	100.00	16.00	39.00	10.000
M12	1.75	9.000	7.00	10.200	110.00	18.50	49.00	12.000
M16	2.00	12.000	9.00	14.000	110.00	20.00	54.00	16.000
M20	2.50	16.000	12.00	17.500	140.00	25.00	62.00	20.000

Price per item in £

12.99

11.72

11.51

11.40

11.93

16.15

17.85

26.08

39.28

Table of application

ISO	P			M		K	N		S		H	
Material	Steel			Stainless steel		Cast iron	Aluminium		Special alloys		Hardened steel	
Properties	<800	<1000	<1200	<750	<950	GG	<6% Si	>6% Si	Ti	Ni	45-55 HRC	55-62 HRC
v _c m/min	10	8	6	6	6	12	12	8	2	x	x	x



blind holes



steam tempered



external cooling

Guhring no.

5720

Standard

DIN 2184-1

Standard

DIN 371

Tool material

HSS-E

Type

N R40

Form

C

Tolerance

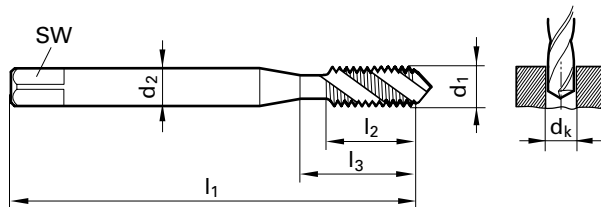
ISO 3 / 6G

Cutting direction

right-hand

Discount group

35



d1	P	d2	SW	dk	l1	l2	l3	Code no.
	mm	mm		mm	mm	mm	mm	
M 3	0.50	3.500	2.70	2.500	56.00	6.00	18.00	3.000
M 4	0.70	4.500	3.40	3.300	63.00	7.50	21.00	4.000
M 5	0.80	6.000	4.90	4.200	70.00	8.50	25.00	5.000
M 6	1.00	6.000	4.90	5.000	80.00	11.00	30.00	6.000
M 8	1.25	8.000	6.20	6.800	90.00	14.00	35.00	8.000
M10	1.50	10.000	8.00	8.500	100.00	16.00	39.00	10.000

Price per item in £

12.35

11.19

12.67

12.03

14.36

18.79

for blind holes



11

Table of application

ISO	P			M		K	N		S		H	
Material	Steel			Stainless steel		Cast iron	Aluminium		Special alloys		Hardened steel	
Properties	<800	<1000	<1200	<750	<950	GG	<6% Si	>6% Si	Ti	Ni	45-55 HRC	55-62 HRC
v _c m/min	10	8	6	6	6	12	12	8	2	x	x	x



blind holes



TiN-coated



external cooling

Guhring no.

5738

Standard

DIN 2184-1

Standard

DIN 376

Tool material

HSS-E

Type

N R40

Form

C

Tolerance

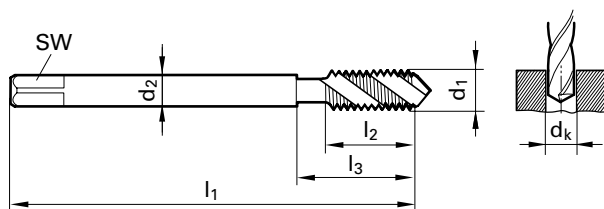
6HX

Cutting direction

right-hand

Discount group

35



d1	P	d2	SW	dk	l1	l2	l3	Code no.
	mm	mm		mm	mm	mm	mm	
M 3	0.50	2.200		2.500	56.00	6.00	18.00	3.000
M 4	0.70	2.800	2.10	3.300	63.00	7.50	21.00	4.000
M 5	0.80	3.500	2.70	4.200	70.00	8.50	25.00	5.000
M 6	1.00	4.500	3.40	5.000	80.00	11.00	30.00	6.000
M 8	1.25	6.000	4.90	6.800	90.00	14.00	35.00	8.000
M10	1.50	7.000	5.50	8.500	100.00	16.00	39.00	10.000
M12	1.75	9.000	7.00	10.20	110.00	18.50	49.00	12.000
M14	2.00	11.000	9.00	12.00	110.00	20.00	53.00	14.000
M16	2.00	12.000	9.00	14.00	110.00	20.00	54.00	16.000
M20	2.50	16.000	12.00	17.50	140.00	25.00	62.00	20.000
M24	3.00	18.000	14.50	21.00	160.00	30.00	73.00	24.000

Price per item in £

22.81

22.81

21.65

21.65

21.65

27.23

30.51

45.50

42.23

62.50

88.16

Table of application

ISO	P			M		K	N		S		H	
Material	Steel			Stainless steel		Cast iron	Aluminium		Special alloys		Hardened steel	
Properties	<800	<1000	<1200	<750	<950	GG	<6% Si	>6% Si	Ti	Ni	45-55 HRC	55-62 HRC
v _c m/min	12	10	8	8	8	15	x	10	2	x	x	x



blind holes



steam tempered



external cooling

Guhring no.

5721

Standard

DIN 2184-1

Standard

DIN 371

Tool material

HSS-E

Type

N R40

Form

E

Tolerance

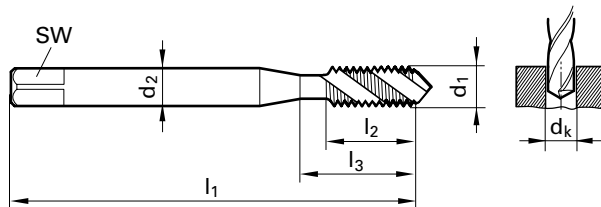
ISO 2 / 6H

Cutting direction

right-hand

Discount group

35



d1	P	d2	SW	dk	l1	l2	l3	Code no.
	mm	mm		mm	mm	mm	mm	
M 3	0.50	3.500	2.70	2.500	56.00	6.00	18.00	3.000
M 4	0.70	4.500	3.40	3.300	63.00	7.50	21.00	4.000
M 5	0.80	6.000	4.90	4.200	70.00	8.50	25.00	5.000
M 6	1.00	6.000	4.90	5.000	80.00	11.00	30.00	6.000
M 8	1.25	8.000	6.20	6.800	90.00	14.00	35.00	8.000
M10	1.50	10.000	8.00	8.500	100.00	16.00	39.00	10.000

Price per item in £

11.19

12.35

11.19

11.40

13.83

17.95

Table of application

ISO	P			M		K	N		S		H	
Material	Steel			Stainless steel		Cast iron	Aluminium		Special alloys		Hardened steel	
Properties	<800	<1000	<1200	<750	<950	GG	<6% Si	>6% Si	Ti	Ni	45-55 HRC	55-62 HRC
v _c m/min	10	8	6	6	6	12	12	8	2	x	x	x





blind holes



TiN-coated



external cooling

Guhring no.

5722

Standard

DIN 2184-1

Standard

DIN 371 / DIN 376

Tool material

HSS-E-PM

Type

N R50

Form

C

Tolerance

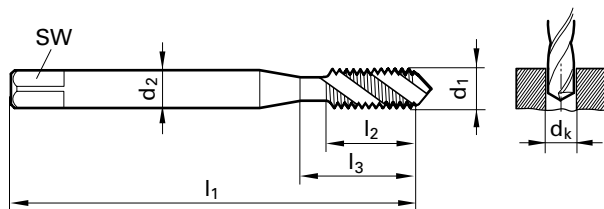
ISO 2 / 6H

Cutting direction

right-hand

Discount group

35



d1	P	d2	SW	dk	l1	l2	l3	Code no.
	mm	mm		mm	mm	mm	mm	
M 3	0.50	3.500	2.70	2.500	56.00	6.00	18.00	3.000
M 4	0.70	4.500	3.40	3.300	63.00	7.50	21.00	4.000
M 5	0.80	6.000	4.90	4.200	70.00	8.50	25.00	5.000
M 6	1.00	6.000	4.90	5.000	80.00	11.00	30.00	6.000
M 8	1.25	8.000	6.20	6.800	90.00	14.00	35.00	8.000
M 10	1.50	10.000	8.00	8.500	100.00	16.00	39.00	10.000
M 12	1.75	9.000	7.00	10.200	110.00	18.50	49.00	12.000
M 14	2.00	11.000	9.00	12.000	110.00	20.00	53.00	14.000
M 16	2.00	12.000	9.00	14.000	110.00	20.00	54.00	16.000
M 20	2.50	16.000	12.00	17.500	140.00	25.00	62.00	20.000

Price per item in £

17.95

17.95

19.11

22.39

26.81

33.47

39.28

57.23

56.91

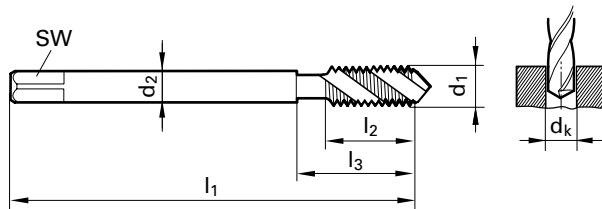
65.46

Table of application

ISO	P			M		K	N		S		H	
Material	Steel			Stainless steel		Cast iron	Aluminium		Special alloys		Hardened steel	
Properties	<800	<1000	<1200	<750	<950	GG	<6% Si	>6% Si	Ti	Ni	45-55 HRC	55-62 HRC
v _c m/min	15	12	10	10	10	20	x	20	4	2	x	x

 blind holes  TiN-coated  external cooling	Guhring no.	5718
	Standard	
	Standard	Guhring standard
	Tool material	HSS-E
	Type	N R40
	Form	C
	Tolerance	6HX
	Cutting direction	right-hand
	Discount group	35

**EXTRA
LENGTH TAP**



d1	P	d2	SW	dk	l1	l2	l3	Code no.
	mm	mm		mm	mm	mm	mm	
M 3	0.50	3.500	2.70	2.500	112.00	6.00	18.00	3.000
M 4	0.70	2.800	2.10	3.300	112.00	7.50	77.00	4.000
M 5	0.80	3.500	2.70	4.200	125.00	8.50	90.00	5.000
M 6	1.00	4.500	3.40	5.000	125.00	11.00	90.00	6.000
M 8	1.25	6.000	4.90	6.800	140.00	14.00	97.00	8.000
M 10	1.50	7.000	5.50	8.500	160.00	16.00	117.00	10.000
M 12	1.75	9.000	7.00	10.200	180.00	18.50	133.00	12.000
M 16	2.00	12.000	9.00	14.000	220.00	20.00	168.00	16.000
M 20	2.50	16.000	12.00	17.500	280.00	25.00	225.00	20.000

Price per item in £

38.22

34.10

33.78

33.78

34.94

42.23

48.78

67.25

99.88

Table of application

ISO	P			M		K	N		S		H	
Material	Steel			Stainless steel		Cast iron	Aluminium		Special alloys		Hardened steel	
Properties	<800	<1000	<1200	<750	<950	GG	<6% Si	>6% Si	Ti	Ni	45-55 HRC	55-62 HRC
v _c m/min	12	10	8	8	8	15	x	10	2	x	x	x





blind holes



steam tempered



external cooling

Guhring no.

4036

Standard

ISO 529

Standard

-

Tool material

HSS-E

Type

N R40

Form

C

Tolerance

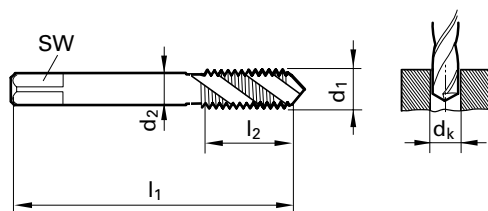
ISO 2 / 6H

Cutting direction

right-hand

Discount group

35



d1	P	d2	SW	dk	l1	l2	Code no.
	mm	mm		mm	mm	mm	
M 3	0.50	3.15	2.50	2.50	48.00	10.00	3.000
M 4	0.70	4.00	3.15	3.30	53.00	12.00	4.000
M 5	0.80	5.00	4.00	4.20	58.00	16.00	5.000
M 6	1.00	6.30	5.00	5.00	66.00	18.00	6.000
M 8	1.25	8.00	6.30	6.80	72.00	22.00	8.000
M10	1.50	10.00	8.00	8.50	80.00	22.00	10.000
M 12	1.75	9.00	7.10	10.20	89.00	24.00	12.000
M 14	2.00	11.20	9.00	12.00	95.00	26.00	14.000
M 16	2.00	12.50	10.00	14.00	102.00	32.00	16.000
M 18	2.50	14.00	11.20	15.50	112.00	32.00	18.000
M 20	2.50	14.00	11.20	17.50	112.00	32.00	20.000

Price per item in £

8.40

7.70

8.30

8.30

9.30

11.00

15.50

21.50

24.00

35.00

39.00

Table of application

ISO	P			M		K	N		S		H	
Material	Steel			Stainless steel		Cast iron	Aluminium		Special alloys		Hardened steel	
Properties	<800	<1000	<1200	<750	<950	GG	<6% Si	>6% Si	Ti	Ni	45-55 HRC	55-62 HRC
v _c m/min	10	8	6	6	6	12	12	8	2	x	x	x



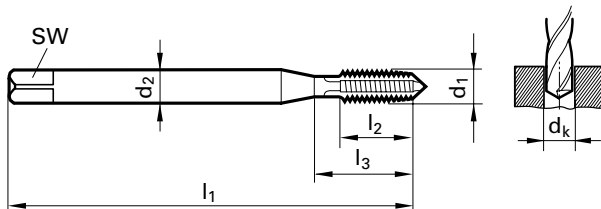
through holes



steam tempered



external cooling

Guhring no.**5733****Standard****DIN 2184-1****Standard****DIN 371****Tool material****HSS-E****Type****N****Form****B****Tolerance****ISO 2 / 6H****Cutting direction****right-hand****Discount group****35**

d1	P	d2	SW	dk	l1	l2	l3	Code no.
	mm	mm		mm	mm	mm	mm	
M 3	0.50	3.500	2.70	2.500	56.00	10.00	18.00	3.000
M 4	0.70	4.500	3.40	3.300	63.00	12.00	21.00	4.000
M 5	0.80	6.000	4.90	4.200	70.00	14.00	25.00	5.000
M 6	1.00	6.000	4.90	5.000	80.00	16.00	30.00	6.000
M 8	1.25	8.000	6.20	6.800	90.00	17.00	35.00	8.000
M10	1.50	10.000	8.00	8.500	100.00	20.00	39.00	10.000

Price per item in £

8.13**8.23****8.23****8.34****9.72****11.61**

for through holes

17

Table of application

ISO	P			M		K	N		S		H	
Material	Steel			Stainless steel		Cast iron	Aluminium		Special alloys		Hardened steel	
Properties	<800	<1000	<1200	<750	<950	GG	<6% Si	>6% Si	Ti	Ni	45-55 HRC	55-62 HRC
v _c m/min	12	10	8	8	8	15	15	10	4	x	x	x



through holes



steam tempered



external cooling

Guhring no.

5716

Standard

DIN 2184-1

Standard

DIN 376

Tool material

HSS-E

Type

N

Form

B

Tolerance

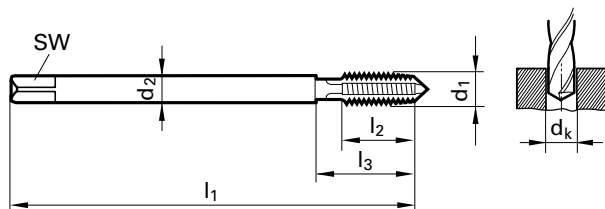
ISO 2 / 6H

Cutting direction

right-hand

Discount group

35



d1	P	d2	SW	dk	l1	l2	l3	Code no.
	mm	mm		mm	mm	mm	mm	
M 3	0.50	2.200		2.500	56.00	10.00	18.00	3.000
M 4	0.70	2.800	2.10	3.300	63.00	12.00	21.00	4.000
M 5	0.80	3.500	2.70	4.200	70.00	14.00	25.00	5.000
M 6	1.00	4.500	3.40	5.000	80.00	16.00	30.00	6.000
M 8	1.25	6.000	4.90	6.800	90.00	17.00	35.00	8.000
M10	1.50	7.000	5.50	8.500	100.00	20.00	39.00	10.000
M12	1.75	9.000	7.00	10.200	110.00	24.00	49.00	12.000
M14	2.00	11.000	9.00	12.000	110.00	26.00	53.00	14.000
M16	2.00	12.000	9.00	14.000	110.00	26.00	54.00	16.000
M20	2.50	16.000	12.00	17.500	140.00	32.00	62.00	20.000

Price per item in £

11.19

11.09

11.09

11.51

13.51

15.62

18.37

27.23

27.23

42.97

Table of application

ISO	P			M		K	N		S		H	
Material	Steel			Stainless steel		Cast iron	Aluminium		Special alloys		Hardened steel	
Properties	<800	<1000	<1200	<750	<950	GG	<6% Si	>6% Si	Ti	Ni	45-55 HRC	55-62 HRC
v _c m/min	12	10	8	8	8	15	15	10	4	x	x	x



through holes



steam tempered



external cooling

Guhring no.

5719

Standard

DIN 2184-1

Standard

DIN 371

Tool material

HSS-E

Type

N

Form

B

Tolerance

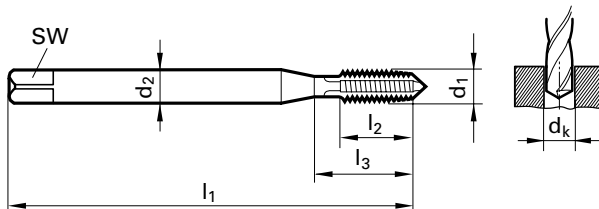
ISO 3 / 6G

Cutting direction

right-hand

Discount group

35



d1	P	d2	SW	dk	l1	l2	l3	Code no.
	mm	mm		mm	mm	mm	mm	
M 3	0.50	3.500	2.70	2.500	56.00	10.00	18.00	3.000
M 4	0.70	4.500	3.40	3.300	63.00	12.00	21.00	4.000
M 5	0.80	6.000	4.90	4.200	70.00	14.00	25.00	5.000
M 6	1.00	6.000	4.90	5.000	80.00	16.00	30.00	6.000
M 8	1.25	8.000	6.20	6.800	90.00	17.00	35.00	8.000
M10	1.50	10.000	8.00	8.500	100.00	20.00	39.00	10.000

Price per item in £

11.72

11.72

12.03

10.88

12.57

17.63

for through holes



19

Table of application

ISO	P			M		K	N		S		H	
Material	Steel			Stainless steel		Cast iron	Aluminium		Special alloys		Hardened steel	
Properties	<800	<1000	<1200	<750	<950	GG	<6% Si	>6% Si	Ti	Ni	45-55 HRC	55-62 HRC
v _c m/min	12	10	8	8	8	15	15	10	4	x	x	x



through holes



TiN-coated



external cooling

Guhring no.

5736

Standard

DIN 2184-1

Standard

DIN 371 / DIN 376

Tool material

HSS-E-PM

Type

N

Form

B

Tolerance

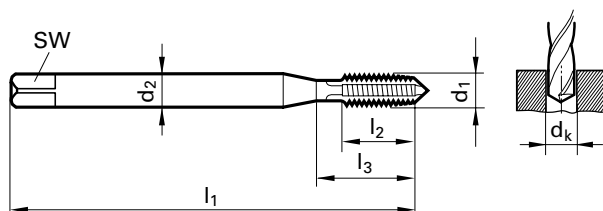
ISO 2 / 6H

Cutting direction

right-hand

Discount group

35



d1	P	d2	SW	dk	l1	l2	l3	Code no.
	mm	mm		mm	mm	mm	mm	
M 2	0.40	2.800	2.10	1.600	45.00	8.00	13.50	2.000
M 3	0.50	3.500	2.70	2.500	56.00	10.00	18.00	3.000
M 4	0.70	4.500	3.40	3.300	63.00	12.00	21.00	4.000
M 5	0.80	6.000	4.90	4.200	70.00	14.00	25.00	5.000
M 6	1.00	6.000	4.90	5.000	80.00	16.00	30.00	6.000
M 8	1.25	8.000	6.20	6.800	90.00	17.00	35.00	8.000
M 10	1.50	10.000	8.00	8.500	100.00	20.00	39.00	10.000
M 12	1.75	9.000	7.00	10.200	110.00	24.00	49.00	12.000
M 14	2.00	11.000	9.00	12.000	110.00	26.00	53.00	14.000
M 16	2.00	12.000	9.00	14.000	110.00	26.00	54.00	16.000
M 18	2.50	14.000	11.00	15.500	125.00	30.00	62.00	18.000
M 20	2.50	16.000	12.00	17.500	140.00	32.00	62.00	20.000

Price per item in £

12.67

15.84

14.46

16.15

19.11

21.65

28.72

33.78

51.41

47.83

83.72

85.94

Table of application

ISO	P			M		K	N		S		H	
Material	Steel			Stainless steel		Cast iron	Aluminium		Special alloys		Hardened steel	
Properties	<800	<1000	<1200	<750	<950	GG	<6% Si	>6% Si	Ti	Ni	45-55 HRC	55-62 HRC
v _c m/min	20	15	12	12	12	25	x	25	6	4	x	x



through holes

☐ steam tempered

☒ external cooling

Guhring no.

4034

Standard

ISO 529

Standard

-

Tool material

HSS-E

Type

N

Form

B

Tolerance

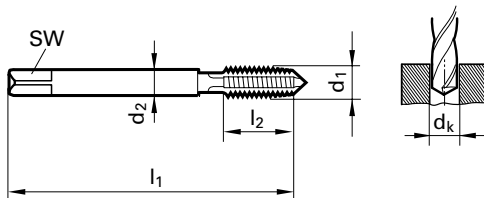
ISO 2 / 6H

Cutting direction

right-hand

Discount group

35



d1	P	d2	SW	dk	l1	l2	Code no.
	mm	mm		mm	mm	mm	
M 3	0.50	3.15	2.50	2.50	48.00	10.00	3.000
M 4	0.70	4.00	3.15	3.30	53.00	12.00	4.000
M 5	0.80	5.00	4.00	4.20	58.00	16.00	5.000
M 6	1.00	6.30	5.00	5.00	66.00	18.00	6.000
M 8	1.25	8.00	6.30	6.80	72.00	22.00	8.000
M10	1.50	10.00	8.00	8.50	80.00	22.00	10.000
M 12	1.75	9.00	7.10	10.20	89.00	24.00	12.000
M 14	2.00	11.20	9.00	12.00	95.00	26.00	14.000
M 16	2.00	12.50	10.00	14.00	102.00	32.00	16.000
M 18	2.50	14.00	11.20	15.50	112.00	32.00	18.000
M 20	2.50	14.00	11.20	17.50	112.00	32.00	20.000

Price per item in £

6.60

6.20

6.40

6.40

7.20

9.30

13.00

16.20

18.80

28.50

30.50

Table of application

ISO	P			M		K	N		S		H	
Material	Steel			Stainless steel		Cast iron	Aluminium		Special alloys		Hardened steel	
Properties	<800	<1000	<1200	<750	<950	GG	<6% Si	>6% Si	Ti	Ni	45-55 HRC	55-62 HRC
v _c m/min	12	10	8	8	8	15	15	10	4	x	x	x





through and
blind holes

○ bright finish

☒ external cooling

Guhring no.

4035

Standard

ISO 529

Standard

-

Tool material

HSS-E

Type

N

Form

C

Tolerance

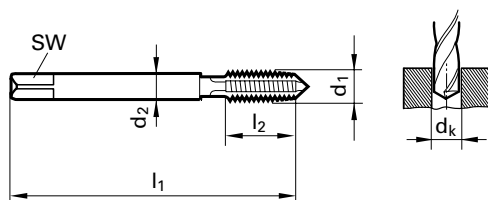
ISO 2 / 6H

Cutting direction

right-hand

Discount group

35



d1	P	d2	SW	dk	l1	l2	Code no.
	mm	mm		mm	mm	mm	
M 3	0.50	3.15	2.50	2.50	48.00	10.00	3.000
M 4	0.70	4.00	3.15	3.30	53.00	12.00	4.000
M 5	0.80	5.00	4.00	4.20	58.00	16.00	5.000
M 6	1.00	6.30	5.00	5.00	66.00	18.00	6.000
M 8	1.25	8.00	6.30	6.80	72.00	22.00	8.000
M10	1.50	10.00	8.00	8.50	80.00	22.00	10.000
M 12	1.75	9.00	7.10	10.20	89.00	24.00	12.000
M 14	2.00	11.20	9.00	12.00	95.00	26.00	14.000
M 16	2.00	12.50	10.00	14.00	102.00	32.00	16.000
M 18	2.50	14.00	11.20	15.50	112.00	32.00	18.000
M 20	2.50	14.00	11.20	17.50	112.00	32.00	20.000

Price per item in £

4.30

4.00

4.10

4.10

4.80

6.20

8.50

10.50

12.90

19.20

21.30

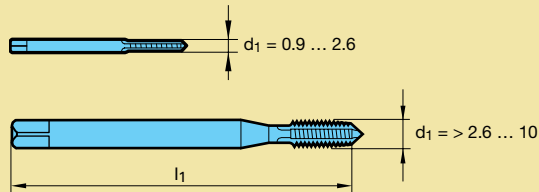
Table of application

ISO	P			M		K	N		S		H	
Material	Steel			Stainless steel		Cast iron	Aluminium		Special alloys		Hardened steel	
Properties	<800	<1000	<1200	<750	<950	GG	<6% Si	>6% Si	Ti	Ni	45-55 HRC	55-62 HRC
v _c m/min	6	x	x	x	x	10	x	10	x	x	x	x

Characteristic features of the individual standards

DIN 371

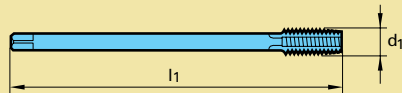
in the master standard
DIN 2184-1



Standard for machine taps with reinforced shank for standard ISO metric threads and ISO metric fine threads. Long design. Shank design in accordance with diameter ranges shown above (mm).

DIN 376

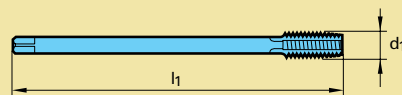
in the master standard
DIN 2184-1



Standard for machine taps with reduced shank for standard ISO metric threads. Long design. Diameter range $d_1 = 1.6 \dots 68$ mm ($\leq \text{Ø M3}$, shank without square)

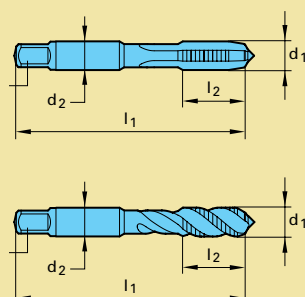
DIN 374

in the master standard
DIN 2184-1



Standard for machine taps with reduced shank for ISO metric fine threads. Long design. Diameter range $d_1 = 3 \dots 52$ mm

ISO 529





blind holes



steam tempered



external cooling

Guhring no.

5724

Standard

DIN 2184-1

Standard

DIN 374

Tool material

HSS-E

Type

N R40

Form

C

Tolerance

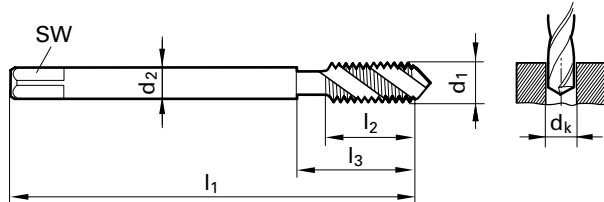
ISO 2 / 6H

Cutting direction

right-hand

Discount group

35



d1 X P	d2	SW	dk	l1	l2	l3	Code no.
	mm		mm	mm	mm	mm	
M 4 X 0.5	2.800	2.10	3.500	63.00	5.00	21.00	4.003
M 5 X 0.5	3.500	2.70	4.500	70.00	5.00	25.00	5.003
M 6 X 0.75	4.500	3.40	5.200	80.00	8.00	30.00	6.004
M 8 X1	6.000	4.90	7.000	90.00	11.00	35.00	8.005
M10 X1	7.000	5.50	9.000	90.00	11.00	35.00	10.005
M10 X1.25	7.000	5.50	8.800	100.00	14.00	39.00	10.006
M12 X1	9.000	7.00	11.000	100.00	11.00	40.00	12.005
M12 X1.25	9.000	7.00	10.800	100.00	16.00	40.00	12.006
M12 X1.5	9.000	7.00	10.500	100.00	16.00	40.00	12.007
M14 X1	11.000	9.00	13.000	100.00	11.00	40.00	14.005
M14 X1.5	11.000	9.00	12.500	100.00	15.00	40.00	14.007
M16 X1	12.000	9.00	15.000	100.00	11.00	44.00	16.005
M16 X1.5	12.000	9.00	14.500	100.00	15.00	44.00	16.007
M20 X1.5	16.000	12.00	18.500	125.00	16.00	44.00	20.007

Price per item in £

19.42

19.42

20.59

16.68

17.43

19.42

23.54

27.55

20.59

30.83

27.87

33.15

32.31

40.75

Table of application

ISO	P			M		K	N		S		H	
Material	Steel			Stainless steel		Cast iron	Aluminium		Special alloys		Hardened steel	
Properties	<800	<1000	<1200	<750	<950	GG	<6% Si	>6% Si	Ti	Ni	45-55 HRC	55-62 HRC
v _c m/min	10	8	6	6	6	12	12	8	2	x	x	x



blind holes



TiN-coated



external cooling

Guhring no.

5740

Standard

DIN 2184-1

Standard

DIN 374

Tool material

HSS-E-PM

Type

N R40

Form

C

Tolerance

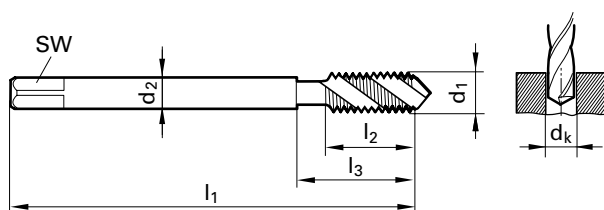
ISO 2 / 6H

Cutting direction

right-hand

Discount group

35



d1 X P	d2	SW	dk	l1	l2	l3	Code no.
	mm		mm	mm	mm	mm	
M 8 X1	6.000	4.90	7.000	90.00	11.00	35.00	8.005
M10 X1	7.000	5.50	9.000	90.00	11.00	35.00	10.005
M10 X1.25	7.000	5.50	8.800	100.00	14.00	39.00	10.006
M12 X1	9.000	7.00	11.000	100.00	11.00	40.00	12.005
M12 X1.25	9.000	7.00	10.800	100.00	16.00	40.00	12.006
M12 X1.5	9.000	7.00	10.500	100.00	16.00	40.00	12.007
M14 X1.25	11.000	9.00	13.000	100.00	11.00	40.00	14.006
M14 X1.5	11.000	9.00	12.500	100.00	15.00	40.00	14.007
M16 X1.5	12.000	9.00	14.500	100.00	15.00	44.00	16.007
M18 X1.5	14.000	11.00	16.500	110.00	16.00	44.00	18.007
M20 X1.5	16.000	12.00	18.500	125.00	16.00	44.00	20.007
M22 X1.5	18.000	14.50	20.500	125.00	16.00	44.00	22.007
M24 X1.5	18.000	14.50	22.500	140.00	16.00	48.00	24.007
M24 X2	18.000	14.50	22.000	140.00	22.00	48.00	24.008

Price per item in £

27.55

35.58

34.94

40.75

44.44

39.28

48.14

46.67

60.18

78.66

90.37

99.14

101.35

117.51

Table of application

ISO	P			M		K	N		S		H	
Material	Steel			Stainless steel		Cast iron	Aluminium		Special alloys		Hardened steel	
Properties	<800	<1000	<1200	<750	<950	GG	<6% Si	>6% Si	Ti	Ni	45-55 HRC	55-62 HRC
v _c m/min	12	10	8	8	8	15	x	10	2	x	x	x





through holes



steam tempered



external cooling

Guhring no.

5723

Standard

DIN 2184-1

Standard

DIN 374

Tool material

HSS-E

Type

N

Form

B

Tolerance

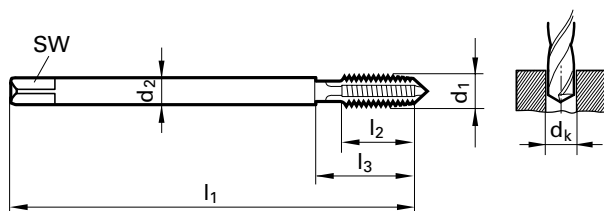
ISO 2 / 6H

Cutting direction

right-hand

Discount group

35



d1 X P	d2	SW	dk	l1	l2	l3	Code no.
	mm		mm	mm	mm	mm	
M 4 X 0.5	2.800	2.10	3.500	63.00	8.00	21.00	4.003
M 5 X 0.5	3.500	2.70	4.500	70.00	10.00	25.00	5.003
M 6 X 0.75	4.500	3.40	5.200	80.00	13.00	30.00	6.004
M 8 X 1	6.000	4.90	7.000	90.00	17.00	35.00	8.005
M 10 X 1	7.000	5.50	9.000	90.00	17.00	35.00	10.005
M 12 X 1	9.000	7.00	11.000	100.00	20.00	40.00	12.005
M 12 X 1.5	9.000	7.00	10.500	100.00	20.00	40.00	12.007
M 14 X 1.5	11.000	9.00	12.500	100.00	20.00	40.00	14.007
M 16 X 1.5	12.000	9.00	14.500	100.00	22.00	44.00	16.007
M 20 X 1.5	16.000	12.00	18.500	125.00	25.00	44.00	20.007

Price per item in £

19.42

19.42

19.42

17.31

17.85

22.81

20.27

29.04

29.66

45.82

Table of application

ISO	P			M		K	N		S		H	
Material	Steel			Stainless steel		Cast iron	Aluminium		Special alloys		Hardened steel	
Properties	<800	<1000	<1200	<750	<950	GG	<6% Si	>6% Si	Ti	Ni	45-55 HRC	55-62 HRC
v _c m/min	12	10	8	8	8	15	15	10	4	x	x	x



through holes



TiN-coated



external cooling

Guhring no.

5739

Standard

DIN 2184-1

Standard

DIN 374

Tool material

HSS-E-PM

Type

N

Form

B

Tolerance

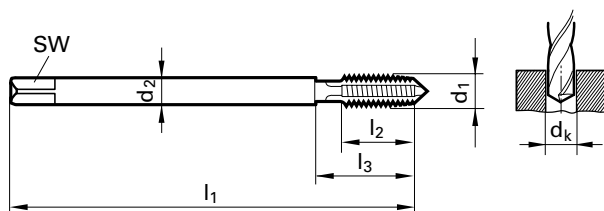
ISO 2 / 6H

Cutting direction

right-hand

Discount group

35



d1 X P	d2	SW	dk	l1	l2	l3	Code no.
	mm		mm	mm	mm	mm	
M 8 X1	6.000	4.90	7.000	90.00	16.00	35.00	8.005
M10 X1	7.000	5.50	9.000	90.00	16.00	35.00	10.005
M10 X1.25	7.000	5.50	8.800	100.00	20.00	39.00	10.006
M12 X1	9.000	7.00	11.000	100.00	20.00	40.00	12.005
M12 X1.25	9.000	7.00	10.800	100.00	20.00	40.00	12.006
M12 X1.5	9.000	7.00	10.500	100.00	20.00	40.00	12.007
M14 X1.25	11.000	9.00	13.000	100.00	20.00	40.00	14.006
M14 X1.5	11.000	9.00	12.500	100.00	20.00	40.00	14.007
M16 X1.5	12.000	9.00	14.500	100.00	22.00	44.00	16.007
M18 X1.5	14.000	11.00	16.500	110.00	25.00	44.00	18.007
M20 X1.5	16.000	12.00	18.500	125.00	25.00	44.00	20.007
M22 X1.5	18.000	14.50	20.500	125.00	25.00	44.00	22.007
M24 X1.5	18.000	14.50	22.500	140.00	28.00	48.00	24.007
M24 X2	18.000	14.50	22.000	140.00	28.00	48.00	24.008

Price per item in £

27.87

32.31

34.52

39.70

41.49

36.74

47.83

45.50

51.10

68.31

91.85

85.94

99.14

113.07

Table of application

ISO	P			M		K	N		S		H	
Material	Steel			Stainless steel		Cast iron	Aluminium		Special alloys		Hardened steel	
Properties	<800	<1000	<1200	<750	<950	GG	<6% Si	>6% Si	Ti	Ni	45-55 HRC	55-62 HRC
v _c m/min	20	15	12	12	12	25	x	25	6	4	x	x





blind holes



steam tempered



external cooling

Guhring no.

5726

Standard

DIN 2184-1

Standard

~ DIN 371 / ~ DIN 376

Tool material

HSS-E

Type

N R40

Form

C

Tolerance

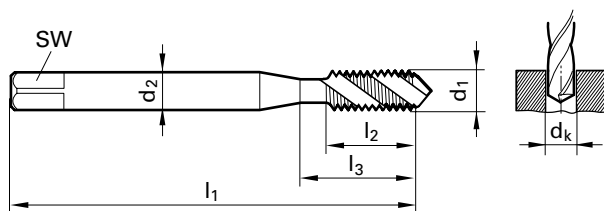
2B

Cutting direction

right-hand

Discount group

35



d1 - P	d2	SW	dk	l1	l2	l3	Code no.
	mm		mm	mm	mm	mm	
NO. 4 -40	3.500	2.70	2.350	56.00	7.00	18.00	2.845
NO. 6 -32	4.000	3.00	2.850	56.00	8.00	20.00	3.505
NO. 8 -32	4.500	3.40	3.500	63.00	8.00	21.00	4.166
NO.10 -24	6.000	4.90	3.900	70.00	11.00	25.00	4.826
1/4 -20	7.000	5.50	5.100	80.00	13.00	30.00	6.350
5/16-18	8.000	6.20	6.600	90.00	14.00	35.00	7.938
3/8 -16	10.000	8.00	8.000	100.00	16.00	39.00	9.525
7/16-14	8.000	6.20	9.400	100.00	18.00	42.00	11.113
1/2 -13	9.000	7.00	10.800	110.00	20.00	49.00	12.700
5/8 -11	12.000	9.00	13.500	110.00	24.00	53.00	15.875
3/4 -10	14.000	11.00	16.500	125.00	25.00	62.00	19.050

Price per item in £

20.27

17.43

18.79

18.37

19.84

19.42

20.90

33.47

30.83

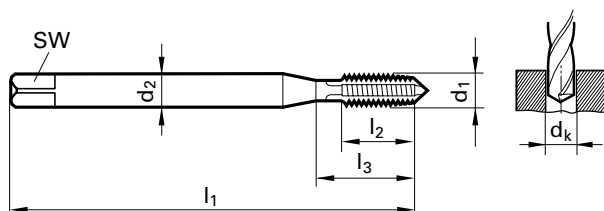
38.96

53.63

Table of application

ISO	P			M		K	N		S		H	
Material	Steel			Stainless steel		Cast iron	Aluminium		Special alloys		Hardened steel	
Properties	<800	<1000	<1200	<750	<950	GG	<6% Si	>6% Si	Ti	Ni	45-55 HRC	55-62 HRC
v _c m/min	10	8	6	6	6	12	12	8	2	x	x	x

 through holes  steam tempered  external cooling	Guhring no.	5725
	Standard	DIN 2184-1
	Standard	~ DIN 371 / ~ DIN 376
	Tool material	HSS-E
	Type	N
	Form	B
	Tolerance	2B
	Cutting direction	right-hand
	Discount group	35



d1 - P	d2	SW	dk	l1	l2	l3	Code no.
	mm		mm	mm	mm	mm	
NO. 4 -40	3.500	2.70	2.350	56.00	11.00	18.00	2.845
NO. 6 -32	4.000	3.00	2.850	56.00	12.00	20.00	3.505
NO. 8 -32	4.500	3.40	3.500	63.00	13.00	21.00	4.166
NO.10 -24	6.000	4.90	3.900	70.00	14.00	25.00	4.826
1/4 -20	7.000	5.50	5.100	80.00	16.00	30.00	6.350
5/16-18	8.000	6.20	6.600	90.00	18.00	35.00	7.938
3/8 -16	10.000	8.00	8.000	100.00	20.00	39.00	9.525
7/16-14	8.000	6.20	9.400	100.00	22.00	42.00	11.113
1/2 -13	9.000	7.00	10.800	110.00	25.00	49.00	12.700
5/8 -11	12.000	9.00	13.500	110.00	30.00	53.00	15.875
3/4 -10	14.000	11.00	16.500	125.00	33.00	62.00	19.050

Price per item in £
15.94
14.15
14.46
19.42
15.84
19.11
24.92
25.34
30.83
38.96
50.26

Table of application

ISO	P			M		K	N		S		H	
Material	Steel			Stainless steel		Cast iron	Aluminium		Special alloys		Hardened steel	
Properties	<800	<1000	<1200	<750	<950	GG	<6% Si	>6% Si	Ti	Ni	45-55 HRC	55-62 HRC
v _c m/min	12	10	8	8	8	15	15	10	4	x	x	x





blind holes



steam tempered



external cooling

Guhring no.

5728

Standard

DIN 2184-1

Standard

~ DIN 374

Tool material

HSS-E

Type

N R40

Form

C

Tolerance

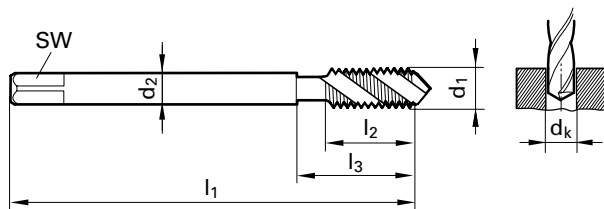
2B

Cutting direction

right-hand

Discount group

35



d1 - P	d2	SW	dk	l1	l2	l3	Code no.
	mm		mm	mm	mm	mm	
NO. 4 -48	2.200		2.400	56.00	6.00	18.00	2.845
NO. 6 -40	2.500	2.10	2.950	56.00	6.50	20.00	3.505
NO.10 -32	3.500	2.70	4.100	70.00	8.50	25.00	4.826
1/4 -28	4.500	3.40	5.500	80.00	9.00	30.00	6.350
3/8 -24	7.000	5.50	8.500	90.00	11.00	35.00	9.525
5/8 -18	12.000	9.00	14.500	100.00	15.00	44.00	15.875

Price per item in £

24.92

20.59

19.42

22.81

24.92

51.10

Table of application

ISO	P			M		K	N		S		H	
Material	Steel			Stainless steel		Cast iron	Aluminium		Special alloys		Hardened steel	
Properties	<800	<1000	<1200	<750	<950	GG	<6% Si	>6% Si	Ti	Ni	45-55 HRC	55-62 HRC
v _c m/min	10	8	6	6	6	12	12	8	2	x	x	x



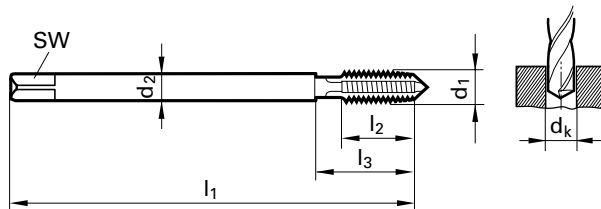
through holes



steam tempered



external cooling

Guhring no.**5727****Standard****DIN 2184-1****Standard****~ DIN 374****Tool material****HSS-E****Type****N****Form****B****Tolerance****2B****Cutting direction****right-hand****Discount group****35**

d1 - P	d2	SW	dk	l1	l2	l3	Code no.
	mm		mm	mm	mm	mm	
NO. 4 -48	2.200		2.400	56.00	10.00	18.00	2.845
NO. 6 -40	2.500	2.10	2.950	56.00	11.00	20.00	3.505
NO.10 -32	3.500	2.70	4.100	70.00	14.00	25.00	4.826
1/4 -28	4.500	3.40	5.500	80.00	16.00	30.00	6.350
3/8 -24	7.000	5.50	8.500	90.00	18.00	35.00	9.525
5/8 -18	12.000	9.00	14.500	100.00	22.00	44.00	15.875

Price per item in £

22.07**22.07****22.07****27.23****29.35****49.94****Table of application**

ISO	P			M		K	N		S		H	
Material	Steel			Stainless steel		Cast iron	Aluminium		Special alloys		Hardened steel	
Properties	<800	<1000	<1200	<750	<950	GG	<6% Si	>6% Si	Ti	Ni	45-55 HRC	55-62 HRC
v _c m/min	12	10	8	8	8	15	15	10	4	x	x	x





blind holes



steam tempered



external cooling

Guhring no.

5732

Standard

DIN 2184-1

Standard

DIN 5156

Tool material

HSS-E

Type

N R40

Form

C

Tolerance

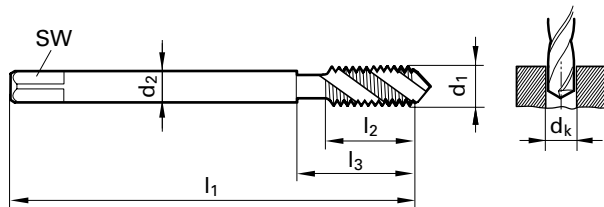
-

Cutting direction

right-hand

Discount group

35



d1	P	d2	SW	dk	l1	l2	l3	Code no.
	G/inch	mm		mm	mm	mm	mm	
G 1/8	28.00	7.00	5.50	8.800	90.00	11.00	35.00	9.728
G 1/4	19.00	11.00	9.00	11.800	100.00	14.00	40.00	13.157
G 3/8	19.00	12.00	9.00	15.250	100.00	14.00	44.00	16.662
G 1/2	14.00	16.00	12.00	19.000	125.00	18.00	44.00	20.955
G 3/4	14.00	20.00	16.00	24.500	140.00	20.00	53.00	26.441
G1	11.00	25.00	20.00	30.750	160.00	24.00	56.00	33.249

Price per item in £

20.59

29.35

42.55

54.68

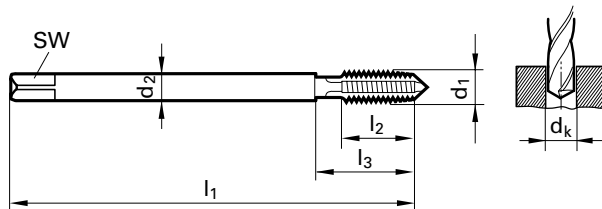
84.46

117.51

Table of application

ISO	P			M		K	N		S		H	
Material	Steel			Stainless steel		Cast iron	Aluminium		Special alloys		Hardened steel	
Properties	<800	<1000	<1200	<750	<950	GG	<6% Si	>6% Si	Ti	Ni	45-55 HRC	55-62 HRC
v _c m/min	10	8	6	6	6	12	12	8	2	x	x	x

 ☐ steam tempered ☒ external cooling	Guhring no.	5731
	Standard	DIN 2184-1
	Standard	DIN 5156
	Tool material	HSS-E
	Type	N
	Form	B
	Tolerance	-
	Cutting direction	right-hand
	Discount group	35



d1	P	d2	SW	dk	l1	l2	l3	Code no.
	G/inch	mm		mm	mm	mm	mm	
G 1/8	28.00	7.00	5.50	8.800	90.00	18.00	35.00	9.728
G 1/4	19.00	11.00	9.00	11.800	100.00	20.00	40.00	13.157
G 3/8	19.00	12.00	9.00	15.250	100.00	22.00	44.00	16.662
G 1/2	14.00	16.00	12.00	19.000	125.00	25.00	44.00	20.955
G 3/4	14.00	20.00	16.00	24.500	140.00	28.00	53.00	26.441
G1	11.00	25.00	20.00	30.750	160.00	30.00	56.00	33.249

Price per item in £

19.84**26.39****32.63****45.18****88.16****97.76**

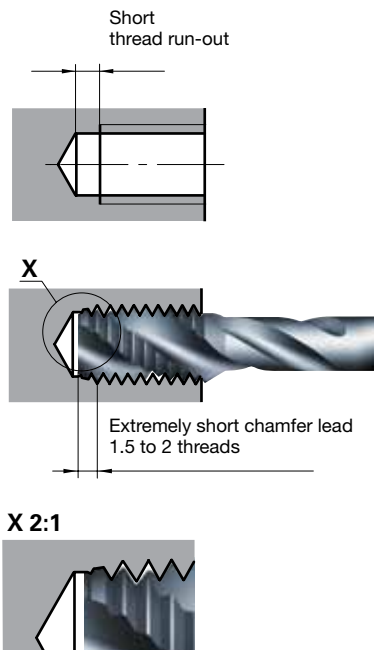
Table of application

ISO	P			M		K	N		S		H	
Material	Steel			Stainless steel		Cast iron	Aluminium		Special alloys		Hardened steel	
Properties	<800	<1000	<1200	<750	<950	GG	<6% Si	>6% Si	Ti	Ni	45-55 HRC	55-62 HRC
v _c m/min	12	10	8	8	8	15	15	10	4	x	x	x



Why is Guhring increasingly offering Form E taps?

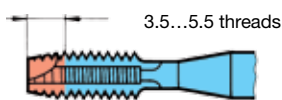
In addition to the conventional Form B and C for machine taps we are increasingly including Form E tools in our standard range. Thus, we are taking into account the increasing demand for taps with which threads can be produced as close as possible to the bottom of the bore when machining blind holes and to produce deepest threads as possible when machining through holes.



Taps with Form E feature an extremely short chamfer lead with only 1.5 to 2 threads. On modern machines and tapping chucks any inferior guidance of the tool in comparison to Forms B and C with long chamfer lead are eliminated. The run-out of the tap is impossible thanks to the rigid tool clamping. Taps with Form E can provide a significant advantage in the production of very deep reaching, fully tapped threads.

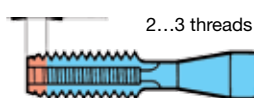
Conventional Forms B and C for machine taps

Form B



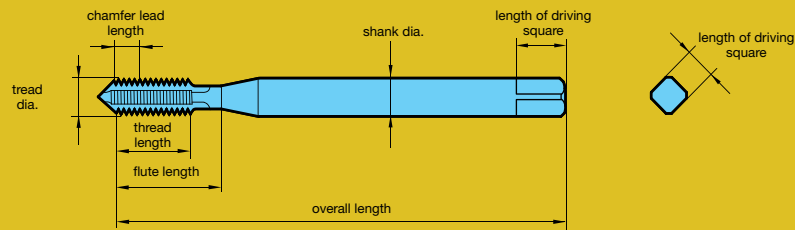
medium, 3.5 - 5.5 threads,
with spiral point,
for through holes

Form C

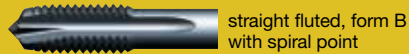


short, 2 - 3 threads
for blind holes

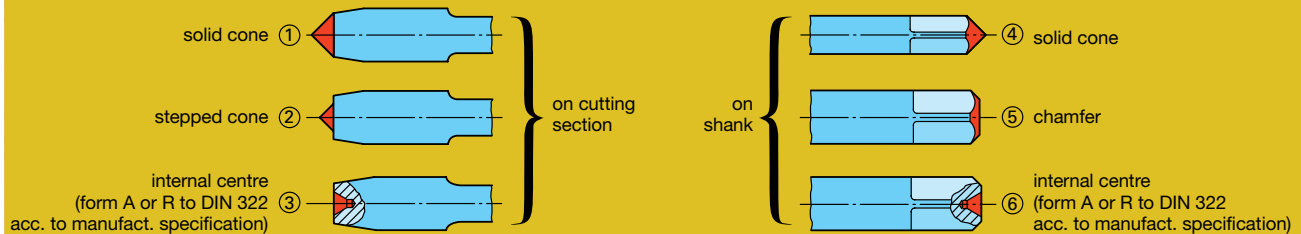
Definitions and angles



Flute forms



Types of centres



Thread dia. range mm	Centre on cutting section		Centre on shank
	with chamfer forms C, E	with chamfer form B	
≤ 4,2	①	①	④ ⑤ ⑥
> 4,2 ... 5,6	① ②	①	④ ⑤ ⑥
> 5,6 ... 10,0	① ② ③	① ② ③	④ ⑤ ⑥
> 10,0	③	③	⑥



Std. ISO metric threads DIN 13				
nom. Ø	pitch P	tapping size hole Ø DIN 336 mm	core diameter of int. thread 6H*	
	mm		min. mm	max. mm
M 2	0.40	1.60	1.567	1.679
M 3	0.50	2.50	2.459	2.599
M 4	0.70	3.30	3.242	3.422
M 5	0.80	4.20	4.134	4.334
M 6	1.00	5.00	4.917	5.153
M 8	1.25	6.80	6.647	6.912
M 10	1.50	8.50	8.376	8.676
M 12	1.75	10.20	10.106	10.441
M 14	2.00	12.00	11.835	12.210
M 16	2.00	14.00	13.835	14.210
M 18	2.50	15.50	15.294	15.744
M 20	2.50	17.50	17.294	17.744
M 24	3.00	21.00	20.752	21.252

ISO metric fine threads DIN 13				
nom. Ø	x	pitch P	tapping size hole Ø DIN 336 mm	core diameter of int. thread 6H
		mm		min. mm max. mm
M 4.0 x	0.50		3.50	3.459 3.599
M 5.0 x	0.50		4.50	4.459 4.599
M 6.0 x	0.75		5.20	5.188 5.378
M 8.0 x	1.00		7.00	6.917 7.153
M 10 x	1.25		8.80	8.647 8.912
M 12 x	1.25		10.80	10.647 10.912
M 12 x	1.50		10.50	10.376 10.676
M 14 x	1.00		13.00	12.917 13.153
M 14 x	1.25		12.80	12.647 12.912
M 14 x	1.50		12.50	12.376 12.676
M 16 x	1.00		15.00	14.917 15.153
M 16 x	1.50		14.50	14.376 14.676
M 18 x	1.50		16.50	16.376 16.676
M 20 x	1.50		18.50	18.376 18.676
M 22 x	1.50		20.50	20.376 20.676
M 24 x	1.50		22.50	22.376 22.676
M 24 x	2.00		22.00	21.835 22.210

UNC threads ASME B1.1				
nom. Ø	threads	tapping size hole Ø DIN 336 mm	core diameter of int. thread 2B	
	per inch		min. mm	max. mm
Nr. 4 -	40	2.35	2.157	2.385
Nr. 6 -	32	2.85	2.642	2.896
Nr. 8 -	32	3.50	3.302	3.531
Nr. 10 -	24	3.90	3.683	3.937
1/4 -	20	5.10	4.978	5.258
5/16 -	18	6.60	6.401	6.731
3/8 -	16	8.00	7.798	8.153
7/16 -	14	9.40	9.144	9.550
1/2 -	13	10.80	10.592	11.024
5/8 -	11	13.50	13.386	13.868
3/4 -	10	16.50	16.307	16.840

UNF threads ASME B1.1				
nom. Ø	threads	tapping size hole Ø DIN 336 mm	core diameter of int. thread 2B	
	per mm		min. mm	max. mm
Nr. 4 -	48	2.40	2.271	2.459
Nr. 6 -	40	2.95	2.819	3.023
Nr. 10 -	32	4.10	3.962	4.166
1/4 -	28	5.50	5.359	5.588
3/8 -	24	8.50	8.382	8.636
5/8 -	18	14.50	14.351	14.681

(Whitworth) threads (DIN-ISO 228-1)				
nom. Ø	threads	tapping size hole Ø DIN 336 mm	core diameter of int. thread	
inch	per inch		min. mm	max. mm
G 1/8	28	8.80	8.566	8.848
G 1/4	19	11.80	11.445	11.890
G 3/8	19	15.25	14.950	15.395
G 1/2	14	19.00	18.631	19.172
G 3/4	14	24.50	24.117	24.658
G 1	11	30.75	30.291	30.931



Tap size		Tapping size hole	Recommended core drills	
metric	inch	Ø mm		
M 2		1.600		
	NO. 4 -40	2.350		carbide micro-precision drill, 4 x D, without IC, Guhring no. 6400
	NO. 4 -48	2.400		carbide micro-precision drill, 5 x D, with IC, Guhring no. 6405
M 3		2.500		
	NO. 6 -32	2.850		GU 500, jobber drill, HSCO, Guhring no. 5523
	NO. 6 -40	2.950		
M 4		3.300		
	NO. 8 -32	3.500		
	NO.10 -24	3.900		
	NO.10 -32	4.100		
M 5		4.200		
M 6		5.000		
	1/4 -20	5.100		
M 6 X 0.75		5.200		
	1/4 -28	5.500		
	5/16-18	6.600		
M 8		6.800		RT 100 U, 5 x D, with IC, Guhring no. 5511
M 8 X1		7.000		
	3/8 -16	8.000		RT 100 U, 5 x D, without IC, Guhring no. 5515
M10		8.500		
M10 X1.25	G 1/8	8.800		GU 500, jobber drill, HSCO, Guhring no. 5523
M10 X1		9.000		
	7/16-14	9.400		
M12		10.200		
M12 X1.5		10.500		
M12 X1.25	1/2 -13	10.800		
M12 X1		11.000		
	G 1/4	11.800		
M14		12.000		
M14 X1.5		12.500		
M14 X1		13.000		
	5/8 -11	13.500		
M16		14.000		
M16 X1.5	5/8 -18	14.500		
M16 X1		15.000		
	G 3/8	15.250		RT 100 U, 5 x D, with IC, Guhring no. 5511
M 18		15.500		
M18 X1.5	3/4 -10	16.500		RT 100 U, 5 x D, without IC, Guhring no. 5515
M20		17.500		
M20 X1.5		18.500		HT 800 holder 5 x D and insert, Guhring no. 4108 + 4112
	G 1/2	19.000		
M22 X1.5		20.500		
M24		21.000		
M24 X2		22.000		
M24 X1.5		22.500		HT 800 holder 5 x D and insert, Guhring no. 4108 + 4112
	G 3/4	24.500		
	G1	30.750		



GÜHROSync

0.3 mm minimal compensation
for up to 75% reduced axial forces

for internal, peripheral or
MQL cooling lubrication

high concentricity and
application speed

elastic polymer elements for effective axial
and torsion damping of force peaks

quick and simple handling, slim design

long-life metal spring packet with progressive
force/travel characteristic curve

maximum tool life
and thread accuracy

The new **GÜHROSync** tapping chuck

Synchro and hydraulic clamping technology intelligently combined

by **GUHRING**

SAME PRICE
MORE PERFORMANCE

GÜHROSYNC



by **GUHRING**

power*tap*

UNIVERSAL TAPS

MADE BY

GUHRING



Guhring Ltd.

Castle Bromwich Business Park,
Tameside Drive,
Birmingham B35 7AG

Tel.: 0121 749 5544
Fax: 0121 776 7224
www.guhring.co.uk

No liability can be accepted for printing errors or technical changes of any kind.
Our Terms and Conditions of Payment apply. Available on request.

Prices shown exclude delivery and statutory value-added-tax.