powertap

UNIVERSAL**TAPS**

MADE BY

GUHRING



PERFECT CHOICE
FOR UNIVERSAL
APPLICATIONS

PERFECT CHOICE
FOR MANY MATERIALS

POWER
PRICE

UNIVERSAL TAPS

TAL**UNC** Power

VERSAL TAPS

SAL perfect thread form

APS powerful **UNF**



POWERTAP – ABSOLUTELY PERFECT

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

by GUHRING

powertap





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
» LONG TOOL LIFE
» 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!**

by GUHRING

Tool material			HSS-E	HSS-E	HSS-E-PM	HSS-E	HSS-E-PM	HSS-E	HSS-E-PM
Type/form			NR40/C	NR40/C	NR40/C	NR40/E	NR50/C	N/B	N/B
Surface finish			○	Ⓢ	Ⓢ	○	Ⓢ	○	Ⓢ
Cooling			☒	☒	☒	☒	☒	☒	☒
			Blind holes	Blind holes	Blind holes	Blind holes	Blind holes	Through holes	Through holes
									
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 *p. 8*	**5737** M2 – M10 *p. 9*		**5721** M3 – M10 *p. 13*	**5722** M3 – M10 *p. 14*	**5733** M3 – M10 *p. 16*	**5736** M2 – M10 *p. 19*
M	**ISO 3 6G**	**DIN 371**	**5720** M3 – M10 *p. 11*					**5719** M3 – M10 *p. 18*	
M	**6HX**	**Guhring standard** (long reach)		**5718** M3 – M20 *p. 15*					
M	**ISO 2 6H**	**DIN 376**	**5717** M3 – M20 *p. 10*				**5722** M12 – M20 *p. 14*	**5716** M3 – M20 *p. 17*	**5736** M12 – M20 *p. 19*
M	**6HX**	**DIN 376**		**5738** M3 – M24 *p. 12*					
MF	**ISO 2 6H**	**DIN 374**	**5724** M4x0.5 – M20x1.5 *p. 20*		**5740** M8x1 – M24x2 *p. 21*			**5723** M4x0.5 – M20x1.5 *p. 22*	**5739** M8x1 – M24x2 *p. 23*
UNC	**2B**	**~ DIN 371**	**5726** Nr. 4-40 – $^{3}/_{8}$ - 16 *p. 24*					**5725** Nr. 4-40 – $^{3}/_{8}$ - 16 *p. 25*	
UNC	**2B**	**~ DIN 376**	**5726** $^{7}/_{16}$ - 14 – $^{3}/_{4}$ - 10 *p. 24*					**5725** $^{7}/_{16}$ - 14 – $^{3}/_{4}$ - 10 *p. 25*	
UNF	**2B**	**~ DIN 374**	**5728** Nr. 4-48 – $^{5}/_{8}$ - 18 *p. 26*					**5727** Nr. 4-48 – $^{5}/_{8}$ - 18 *p. 27*	
G BSP-taps	**–**	**DIN 5156**	**5732** G $^{1}/_{8}$ – G 1 *p. 28*					**5731** G $^{1}/_{8}$ – G 1 *p. 29*	

Shank designs

DIN 371		DIN 376 / DIN 374 / DIN 5156
		
d_1 0,9 … 2,6 mm	d_1 > 2,6 … 10 mm	

Typee clarification

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

Machine taps for ISO metric threads

Standard	Type	Form	Tole-rance	Tool illustration	Tool material	Sur-face finish	d1	Guhring no.	Discount group	Standard range page
DIN 371	N R40	C	ISO 2 / 6H		HSS-E	○	M 3 - M 10	5734	203	8
DIN 371	N R40	C	ISO 2 / 6H		HSS-E	S	M 2 - M 10	5737	203	9
DIN 376	N R40	C	ISO 2 / 6H		HSS-E	○	M 3 - M 20	5717	203	10
DIN 371	N R40	C	ISO 3 / 6G		HSS-E	○	M 3 - M 10	5720	203	11
DIN 376	N R40	C	6HX		HSS-E	S	M 3 - M 24	5738	203	12
DIN 371	N R40	E	ISO 2 / 6H		HSS-E	○	M 3 - M 10	5721	203	13
DIN 371/ 376	N R50	C	ISO 2 / 6H		HSS-E-PM	S	M 3 - M 20	5722	203	14
Guhring std.	N R40	C	6HX		HSS-E	S	M 3 - M 20	5718	203	15
DIN 371	N	B	ISO 2 / 6H		HSS-E	○	M 3 - M 10	5733	203	16
DIN 376	N	B	ISO 2 / 6H		HSS-E	○	M 3 - M 20	5716	203	17
DIN 371	N	B	ISO 3 / 6G		HSS-E	○	M 3 - M 10	5719	203	18
DIN 371/ 376	N	B	ISO 2 / 6H		HSS-E-PM	S	M 2 - M 20	5736	203	19

blind holes

through holes

○ steam tempered

S TiN-coated

☒ external cooling

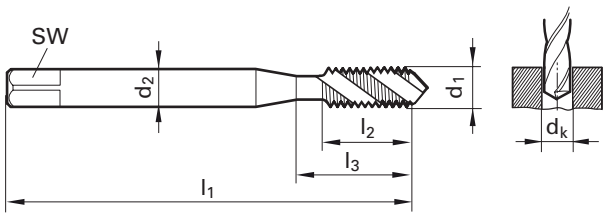
Standard	Type	Form	Tole-rance	Tool illustration	Tool material	Sur-face finish	d1	Guhring no.	Discount group	Standard range page
Machine taps for ISO metric fine threads										
DIN 374	N R40	C	ISO 2 / 6H		HSS-E		M4 x 0.5 - M20 x 1.5	5724	203	20
DIN 374	N R40	C	ISO 2 / 6H		HSS-E-PM	S	M8 x 1 - M24 x 2	5740	203	21
DIN 374	N	B	ISO 2 / 6H		HSS-E		M4 x 0.5 - M20 x 1.5	5723	203	22
DIN 374	N	B	ISO 2 / 6H		HSS-E-PM	S	M8 x 1 - M24 x 2	5739	203	23
Machine taps for UNC-threads										
~ DIN 371/ 376	N R40	C	2B		HSS-E		Nr. 4-40 - 3/4-10	5726	203	24
~ DIN 371/ 376	N	B	2B		HSS-E		Nr. 4-40 - 3/4-10	5725	203	25
Machine taps for UNF-threads										
~ DIN 374	N R40	C	2B		HSS-E		Nr. 4-48 - 5/8-18	5728	203	26
~ DIN 374	N	B	2B		HSS-E		Nr. 4-48 - 5/8-18	5727	203	27
Machine taps for BSP-threads										
DIN 5156	N R40	C	-		HSS-E		G 1/8 - G1	5732	203	28
DIN 5156	N	B	-		HSS-E		G 1/8 - G1	5731	203	29

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	203





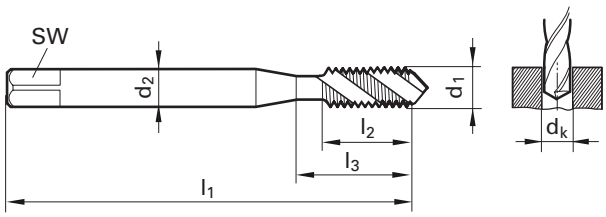
d1	P	d2	SW	dk	l1	l2	l3	Code no.	Availability
	mm	mm		mm	mm	mm	mm		
M 3	0.50	3.500	2.70	2.500	56.00	6.00	18.00	3.000	●
M 4	0.70	4.500	3.40	3.300	63.00	7.50	21.00	4.000	●
M 5	0.80	6.000	4.90	4.200	70.00	8.50	25.00	5.000	●
M 6	1.00	6.000	4.90	5.000	80.00	11.00	30.00	6.000	●
M 8	1.25	8.000	6.20	6.800	90.00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

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	**203**





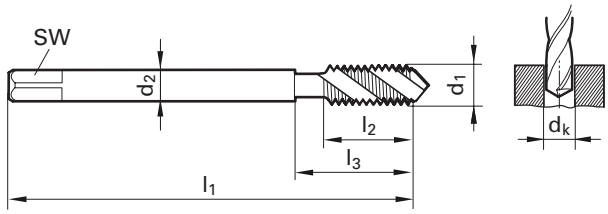
d1	P	d2	SW	dk	l1	l2	l3	Code no.	Availability
	mm	mm		mm	mm	mm	mm		
M 2	0.40	2.800	2.10	1.600	45.00	4.50	13.50	2.000	●
M 3	0.50	3.500	2.70	2.500	56.00	6.00	18.00	3.000	●
M 4	0.70	4.500	3.40	3.300	63.00	7.50	21.00	4.000	●
M 5	0.80	6.000	4.90	4.200	70.00	8.50	25.00	5.000	●
M 6	1.00	6.000	4.90	5.000	80.00	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	●

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	203





d1	P	d2	SW	dk	l1	l2	l3	Code no.	Availability
	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	●

blind holes

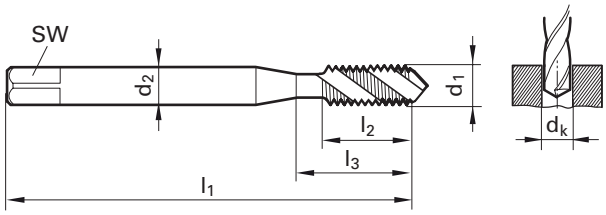
steam tempered

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	203







d1	P	d2	SW	dk	l1	l2	l3	Code no.	Availability
	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	●

blind holes

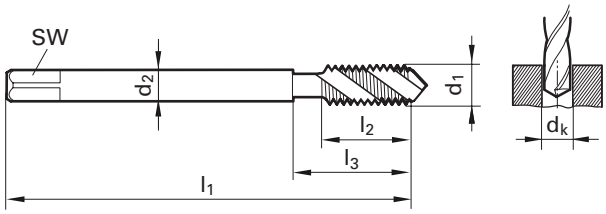
TiN-coated

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	203







d1	P	d2	SW	dk	l1	l2	l3	Code no.	Availability
	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	●

blind holes

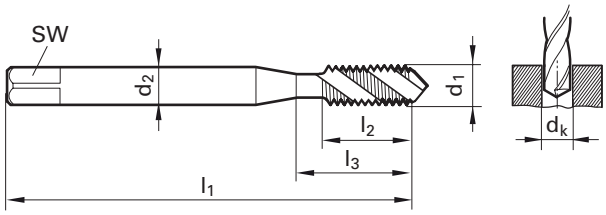
steam tempered

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	203







d1	P	d2	SW	dk	l1	l2	l3	Code no.	Availability
	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	●

blind holes

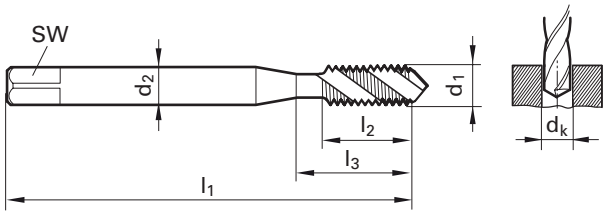
TiN-coated

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	203







d1	P	d2	SW	dk	l1	l2	l3	Code no.	Availability
	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	●

blind holes

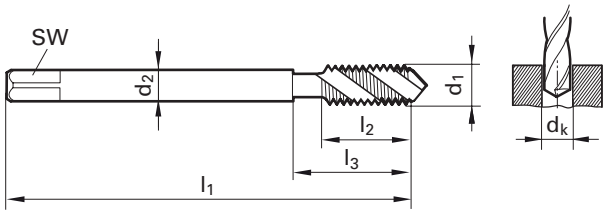
TiN-coated

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	203

EXTRA LENGTH TAP





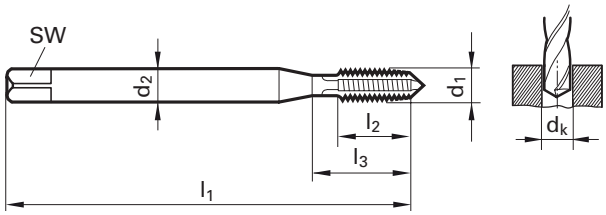
d1	P	d2	SW	dk	l1	l2	l3	Code no.	Availability
	mm	mm		mm	mm	mm	mm		
M 3	0.50	3.500	2.70	2.500	112.00	6.00	18.00	3.000	●
M 4	0.70	2.800	2.10	3.300	112.00	7.50	77.00	4.000	●
M 5	0.80	3.500	2.70	4.200	125.00	8.50	90.00	5.000	●
M 6	1.00	4.500	3.40	5.000	125.00	11.00	90.00	6.000	●
M 8	1.25	6.000	4.90	6.800	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	●

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	203





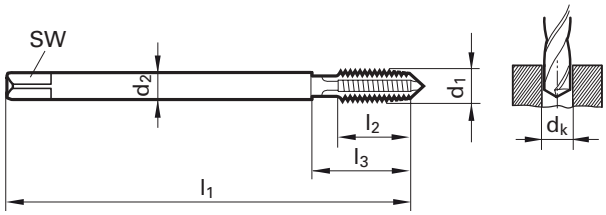
d1	P	d2	SW	dk	l1	l2	l3	Code no.	Availability
	mm	mm		mm	mm	mm	mm		
M 3	0.50	3.500	2.70	2.500	56.00	10.00	18.00	3.000	●
M 4	0.70	4.500	3.40	3.300	63.00	12.00	21.00	4.000	●
M 5	0.80	6.000	4.90	4.200	70.00	14.00	25.00	5.000	●
M 6	1.00	6.000	4.90	5.000	80.00	16.00	30.00	6.000	●
M 8	1.25	8.000	6.20	6.800	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	●

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	**203**





d1	P	d2	SW	dk	l1	l2	l3	Code no.	Availability
	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	●

through holes

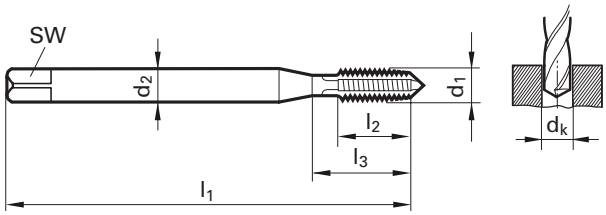
steam tempered

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	203







d1	P	d2	SW	dk	l1	l2	l3	Code no.	Availability
	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	●

through holes

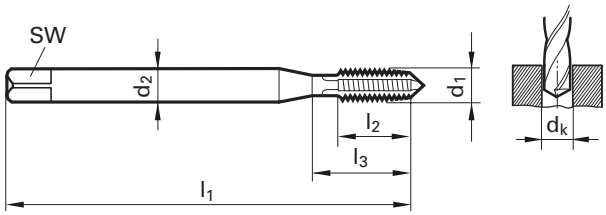
S TiN-coated

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	203







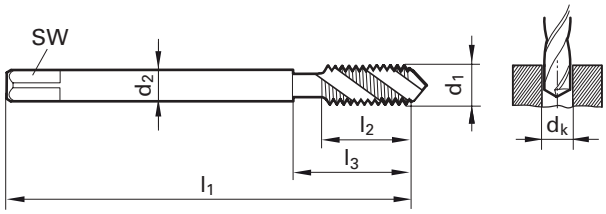
d1	P	d2	SW	dk	l1	l2	l3	Code no.	Availability
	mm	mm		mm	mm	mm	mm		
M 2	0.40	2.800	2.10	1.600	45.00	8.00	13.50	2.000	●
M 3	0.50	3.500	2.70	2.500	56.00	10.00	18.00	3.000	●
M 4	0.70	4.500	3.40	3.300	63.00	12.00	21.00	4.000	●
M 5	0.80	6.000	4.90	4.200	70.00	14.00	25.00	5.000	●
M 6	1.00	6.000	4.90	5.000	80.00	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	●

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	203





d1 X P	d2	SW	dk	l1	l2	l3	Code no.	Availability
	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	●

blind holes

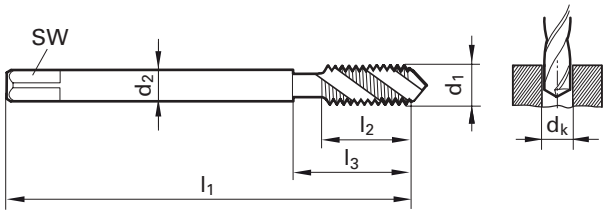
TiN-coated

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	203







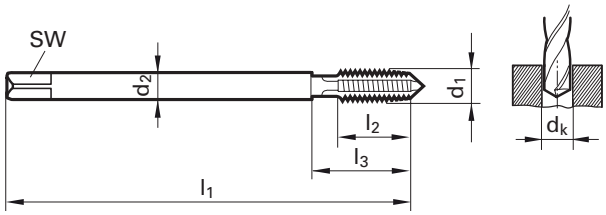
d1 X P	d2	SW	dk	l1	l2	l3	Code no.	Availability
	mm		mm	mm	mm	mm		
M 8 X1	6.000	4.90	7.000	90.00	11.00	35.00	8.005	●
M10 X1	7.000	5.50	9.000	90.00	11.00	35.00	10.005	●
M10 X1.25	7.000	5.50	8.800	100.00	14.00	39.00	10.006	●
M12 X1	9.000	7.00	11.000	100.00	11.00	40.00	12.005	●
M12 X1.25	9.000	7.00	10.800	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	●

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	203





d1 X P	d2	SW	dk	l1	l2	l3	Code no.	Availability
	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	●

through holes

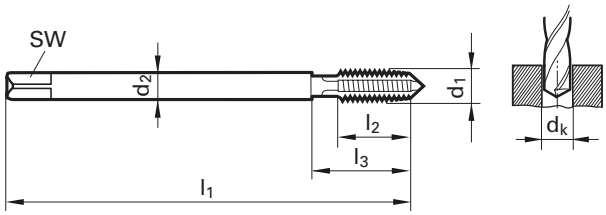
S TiN-coated

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	203







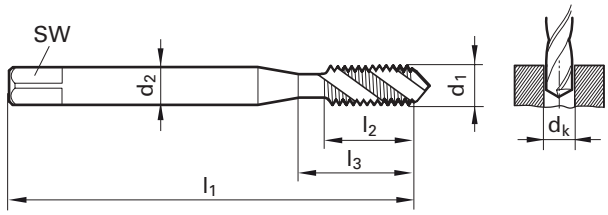
d1 X P	d2	SW	dk	l1	l2	l3	Code no.	Availability
	mm		mm	mm	mm	mm		
M 8 X1	6.000	4.90	7.000	90.00	16.00	35.00	8.005	●
M10 X1	7.000	5.50	9.000	90.00	16.00	35.00	10.005	●
M10 X1.25	7.000	5.50	8.800	100.00	20.00	39.00	10.006	●
M12 X1	9.000	7.00	11.000	100.00	20.00	40.00	12.005	●
M12 X1.25	9.000	7.00	10.800	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	11.000	9.00	13.000	100.00	20.00	40.00	14.005	●
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	●

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	**203**





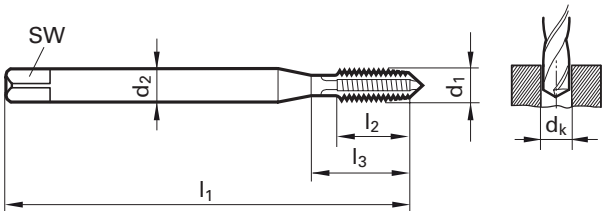
d1 - P	d2	SW	dk	l1	l2	l3	Code no.	Availability
	mm		mm	mm	mm	mm		
NO. 4 -40	3.500	2.70	2.350	56.00	7.00	18.00	2.845	●
NO. 6 -32	4.000	3.00	2.850	56.00	8.00	20.00	3.505	●
NO. 8 -32	4.500	3.40	3.500	63.00	8.00	21.00	4.166	●
NO.10 -24	6.000	4.90	3.900	70.00	11.00	25.00	4.826	●
1/4 -20	7.000	5.50	5.100	80.00	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	●

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	203





d1 - P	d2	SW	dk	l1	l2	l3	Code no.	Availability
	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	●

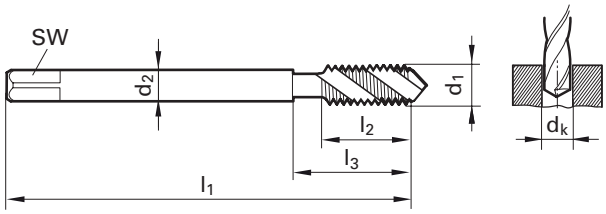
blind holes

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	203





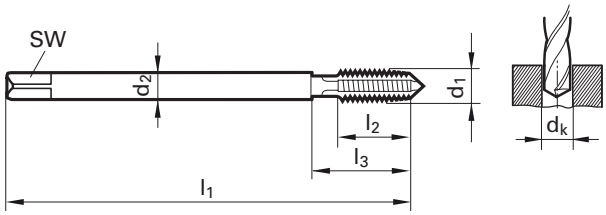
d1 - P	d2	SW	dk	l1	l2	l3	Code no.	Availability
	mm		mm	mm	mm	mm		
NO. 4 -48	2.200		2.400	56.00	6.00	18.00	2.845	●
NO. 6 -40	2.500	2.10	2.950	56.00	6.50	20.00	3.505	●
NO.10 -32	3.500	2.70	4.100	70.00	8.50	25.00	4.826	●
1/4 -28	4.500	3.40	5.500	80.00	9.00	30.00	6.350	●
3/8 -24	7.000	5.50	8.500	90.00	11.00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

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	203





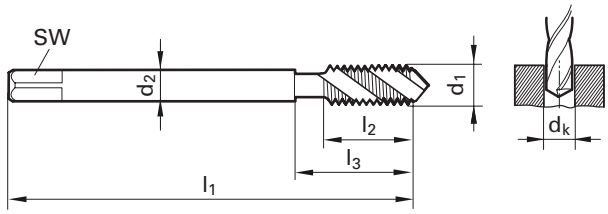
d1 - P	d2	SW	dk	l1	l2	l3	Code no.	Availability
	mm		mm	mm	mm	mm		
NO. 4 -48	2.200		2.400	56.00	10.00	18.00	2.845	●
NO. 6 -40	2.500	2.10	2.950	56.00	11.00	20.00	3.505	●
NO.10 -32	3.500	2.70	4.100	70.00	14.00	25.00	4.826	●
1/4 -28	4.500	3.40	5.500	80.00	16.00	30.00	6.350	●
3/8 -24	7.000	5.50	8.500	90.00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

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	203





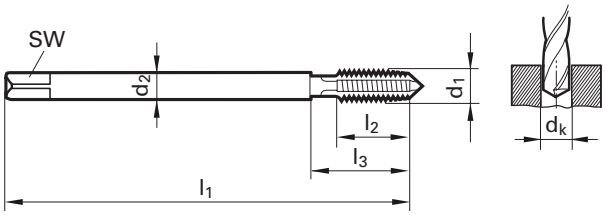
d1	P	d2	SW	dk	l1	l2	l3	Code no.	Availability
	G/inch	mm		mm	mm	mm	mm		
G 1/8	28.00	7.00	5.50	8.800	90.00	11.00	35.00	9.728	●
G 1/4	19.00	11.00	9.00	11.800	100.00	14.00	40.00	13.157	●
G 3/8	19.00	12.00	9.00	15.250	100.00	14.00	44.00	16.662	●
G 1/2	14.00	16.00	12.00	19.000	125.00	18.00	44.00	20.955	●
G 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	●

through holes

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	**203**

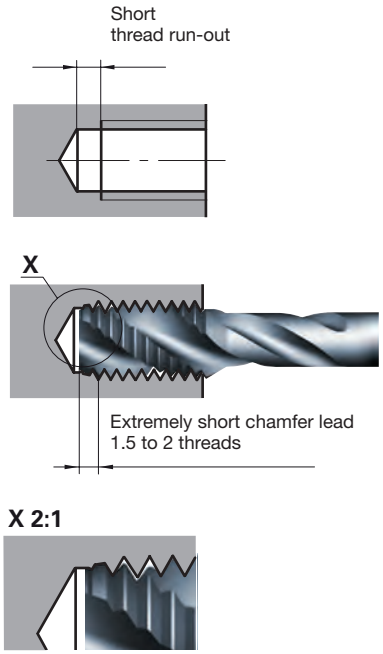




d1	P	d2	SW	dk	l1	l2	l3	Code no.	Availability
	G/inch	mm		mm	mm	mm	mm		
G 1/8	28.00	7.00	5.50	8.800	90.00	18.00	35.00	9.728	●
G 1/4	19.00	11.00	9.00	11.800	100.00	20.00	40.00	13.157	●
G 3/8	19.00	12.00	9.00	15.250	100.00	22.00	44.00	16.662	●
G 1/2	14.00	16.00	12.00	19.000	125.00	25.00	44.00	20.955	●
G 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	●

Why is Guhring increasingly offering Form E taps?

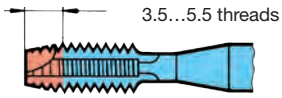
In addition to the conventional Form B and C for machine taps we are increasingly including Form E tools in our standard range. Thus, we are taking into account the increasing demand for taps with which threads can be produced as close as possible to the bottom of the bore when machining blind holes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

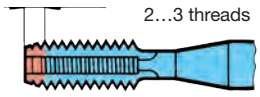
Conventional Forms B and C for machine taps

Form B



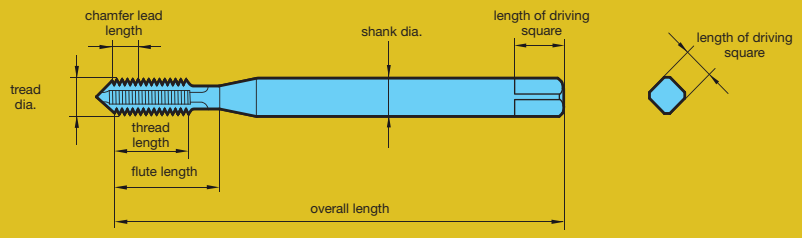
medium, 3.5 - 5.5 threads,
with spiral point,
for through holes

Form C



short, 2 - 3 threads
for blind holes

Definitions and angles



Flute forms

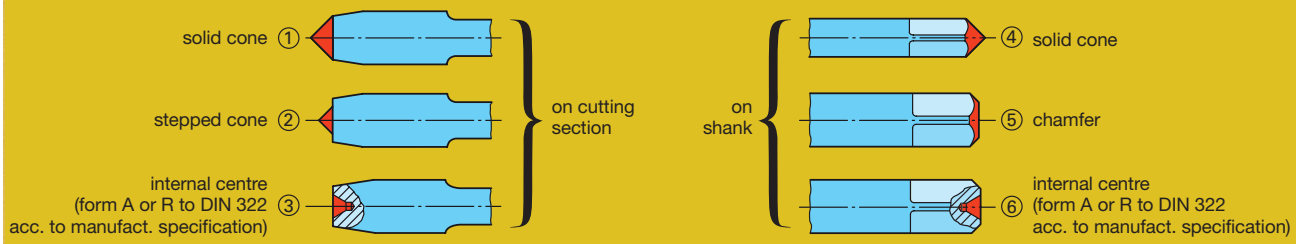


straight fluted, form B
with spiral point



right-hand helix angle
40°

Types of centres



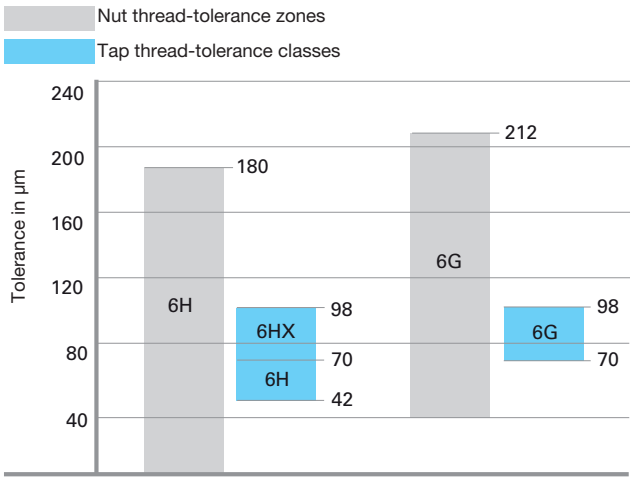
Thread dia. range mm	Centre on cutting section		Centre on shank
	with chamfer forms C, E	with chamfer form B	
≤ 4,2	①	①	④ ⑤ ⑥
> 4,2 … 5,6	① ②	①	④ ⑤ ⑥
> 5,6 … 10,0	① ② ③	① ② ③	④ ⑤ ⑥
> 10,0	③	③	⑥

	Tensile strength MPa (N/mm²)	Hardness HB	Cutting speed v_c m/min*	
			HSS-E	HSS-E-PM
Structural steels	≤ 850	–	10 - 15	15 - 20
Free-cutting steels	≤ 1000	–	10 - 20	15 - 25
Unalloyed case hardened steels	≤ 750	–	10 - 15	15 - 20
Unalloyed heat-treatable steels	≤ 850	–	10 - 15	15 - 20
Alloyed case hardened steels	≥ 850 ... 1200	–	8 - 12	10 - 15
Alloyed heat-treatable steels	≥ 850 ... 1200	–	8 - 12	10 - 15
Alloyed tool steels	≤ 1000	–	6 - 10	8 - 12
High speed tool steels	≥ 650 ... 1000	–	6 - 10	8 - 12
Stainl./acid-resist. steels, sulphured	≤ 850	–	6 - 12	8 - 15
austenitic	≤ 850	–	6 - 12	8 - 15
martensitic	≤ 850	–	6 - 12	8 - 15
Aluminum and Al-alloys	≤ 400	–	15 - 20	20 - 25
Al wrought alloys	≤ 400	–	15 - 20	20 - 25
Al cast alloys ≤ 10 % Si	≤ 600	–	15 - 20	20 - 25
> 10 % Si	≤ 600	–	15 - 20	20 - 25
Cast iron	–	≤ 240	15 - 20	20 - 25
Spheroidal grahpite iron	–	≤ 240	15 - 20	20 - 25
Malleable cast iron	–	< 300	15 - 20	20 - 25

* With coated tools Vc can be increased by up to 50%.

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.

Tap size metric	Tap size inch	Tapping size hole Ø mm	Recommended core drills
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	3/8 -24	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

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