

powertap

UNIVERSAL TAPS

MADE BY
GUHRING

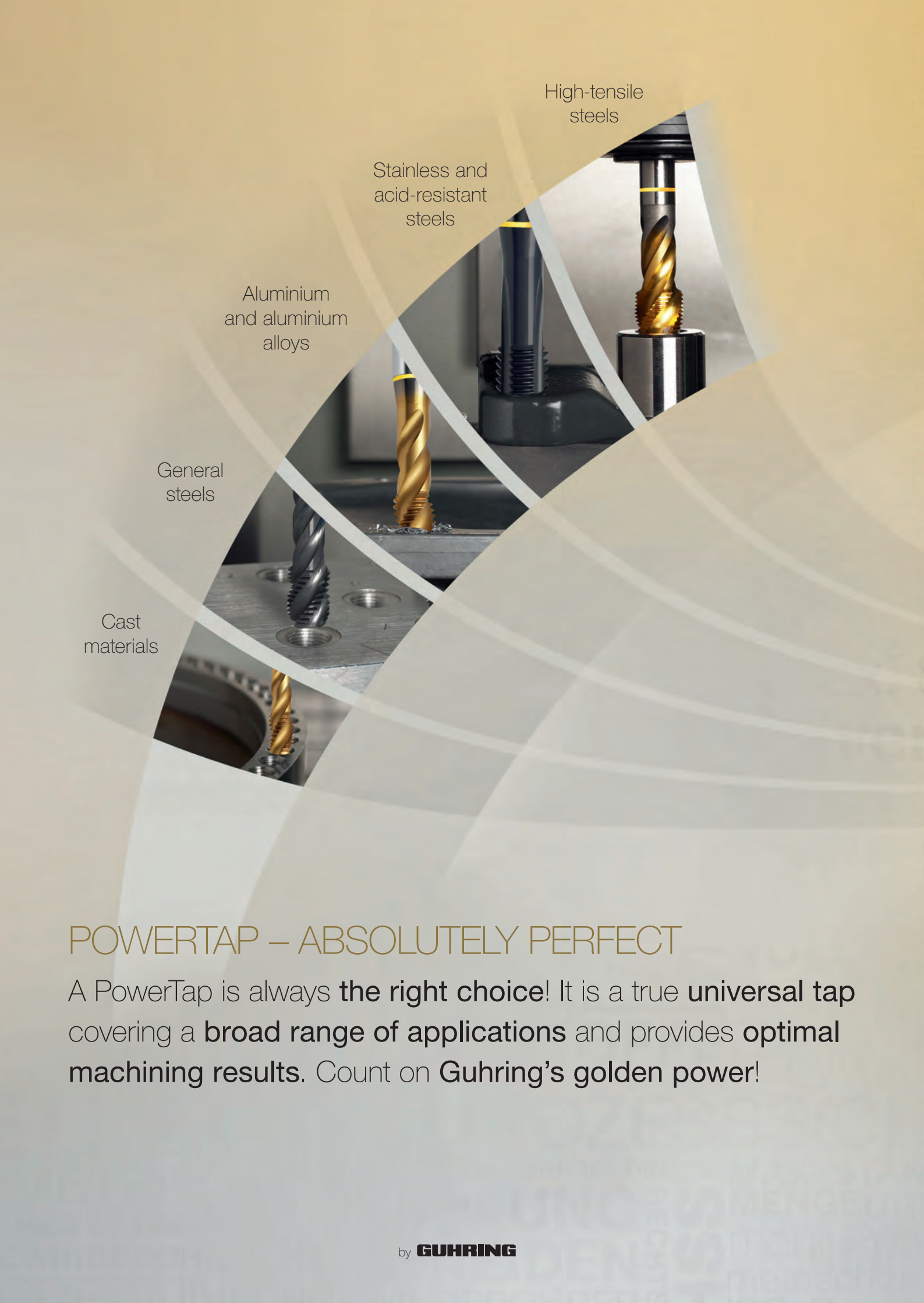


PERFECT CHOICE
FOR UNIVERSAL
APPLICATIONS

TOP OF
FORM
UNIVERSAL
power
perfect
choice
UNIVERSAL
PROCEDURE
PERFECT
UNIVERSAL
power
Power

TR
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AF
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eal
life
BLE
ORM

PERFECT CHOICE
FOR MANY MATERIALS
POWER
PRICE
UNIVERSAL TAPS
TALUNC Power
UNIVERSAL TAPS
SAL perfect thread form
APS powerful UNF



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** and provides **optimal machining results**. Count on **Guhring's golden power!**

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

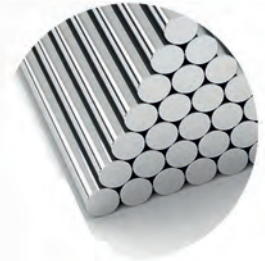
Optimised geometries for maximum performance!



Completely precision ground on specially developed machines!



Finest quality steels as tool material!



More power for your production!



More power for your production



4

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



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


 d_1 0,9 ... 2,6 mm

DIN 376 / DIN 374 / DIN 5156


 $d_1 > 2,6$... 10 mm

Typee clarification

NR40= Type N, RH spiral 40°

NR50= Type N, RH spiral 50°

Standard	Type	Form	Tolerance	Tool illustration	Tool material	Surface finish	d1	Guhring no.	Discount group	Standard range page
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Machine taps for ISO metric threads

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

Powertap overview



6



blind holes



steam tempered



through holes











TiN-coated







external cooling

Standard	Type	Form	Tolerance	Tool illustration		Tool material	Surface finish	d1	Guhring no.	Discount group	Standard range page
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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	Ⓢ	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	Ⓢ	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

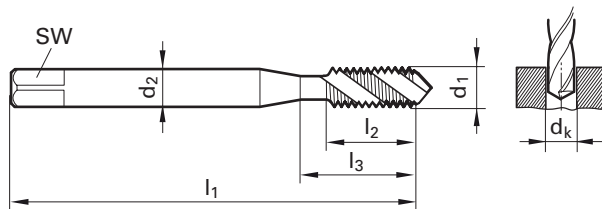
ISO 2 / 6H

Cutting direction

right-hand

Discount group

203



for blind holes



8

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

Availability
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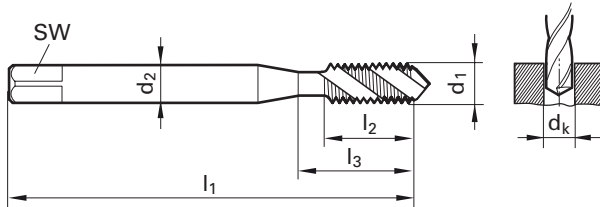
blind holes



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.
	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

Availability



for blind holes

9

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



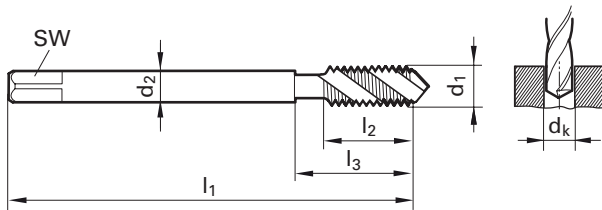
blind holes



steam tempered



external cooling



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

Availability
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for blind holes



10



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

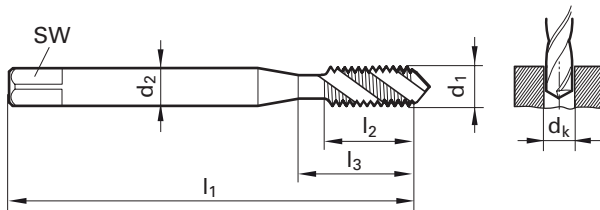
ISO 3 / 6G

Cutting direction

right-hand

Discount group

203



d1	P	d2	SW	dk	l1	l2	l3	Code no.
	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

Availability
●
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●

for blind holes





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

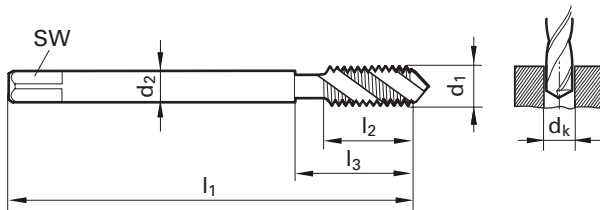
6HX

Cutting direction

right-hand

Discount group

203



for blind holes



12

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

Availability
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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

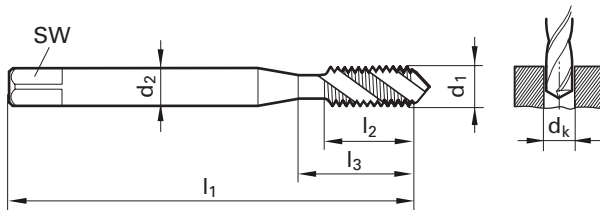
Cutting direction

right-hand

Discount group

203

**FORM E
WITH SHORT
CHAMFER
LEAD**



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

Availability
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for blind holes



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



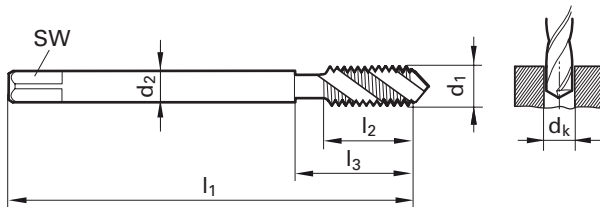
blind holes



TiN-coated



external cooling



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

Availability
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for blind holes





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

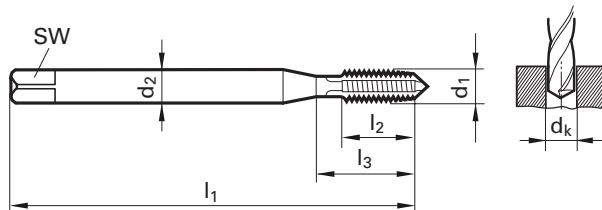
ISO 2 / 6H

Cutting direction

right-hand

Discount group

203



for through holes



16

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

Availability
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●



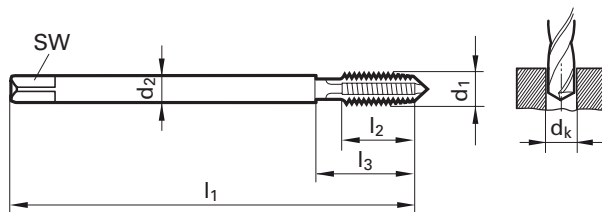
through holes



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.
	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

Availability



for through holes



17



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

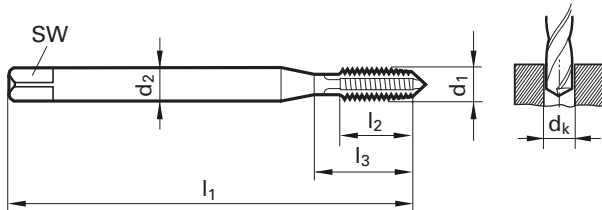
ISO 3 / 6G

Cutting direction

right-hand

Discount group

203



d1	P	d2	SW	dk	l1	l2	l3	Code no.
	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

Availability
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for through holes





through holes



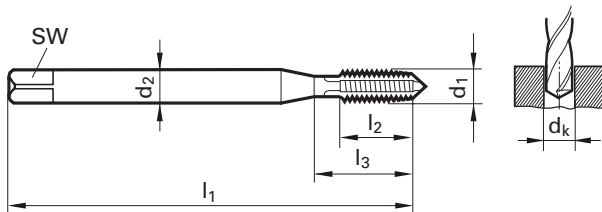
TiN-coated



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	203

**HSS-E-PM +
TIN
FOR MAXIMUM
TOOL LIFE**



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

Availability
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for through holes





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

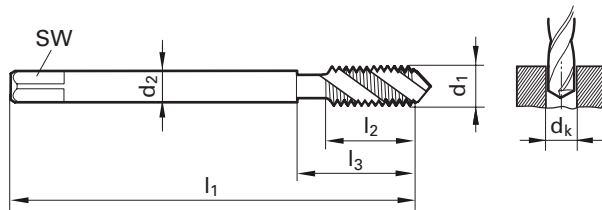
ISO 2 / 6H

Cutting direction

right-hand

Discount group

203



for blind holes



20

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 X 1	6.000	4.90	7.000	90.00	11.00	35.00	8.005
M10 X 1	7.000	5.50	9.000	90.00	11.00	35.00	10.005
M10 X 1.25	7.000	5.50	8.800	100.00	14.00	39.00	10.006
M12 X 1	9.000	7.00	11.000	100.00	11.00	40.00	12.005
M12 X 1.25	9.000	7.00	10.800	100.00	16.00	40.00	12.006
M12 X 1.5	9.000	7.00	10.500	100.00	16.00	40.00	12.007
M14 X 1	11.000	9.00	13.000	100.00	11.00	40.00	14.005
M14 X 1.5	11.000	9.00	12.500	100.00	15.00	40.00	14.007
M16 X 1	12.000	9.00	15.000	100.00	11.00	44.00	16.005
M16 X 1.5	12.000	9.00	14.500	100.00	15.00	44.00	16.007
M20 X 1.5	16.000	12.00	18.500	125.00	16.00	44.00	20.007

Availability
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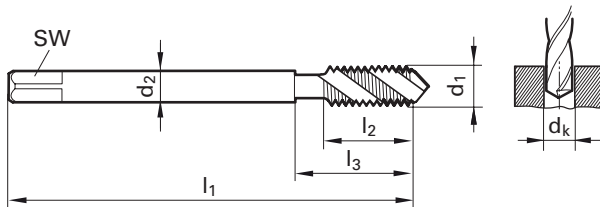
blind holes



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.
	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

Availability
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for blind holes





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

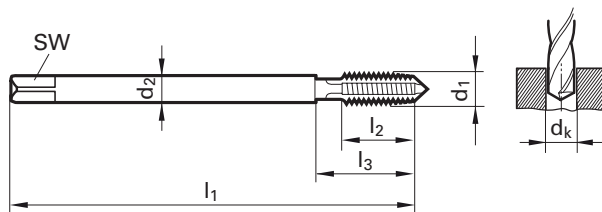
ISO 2 / 6H

Cutting direction

right-hand

Discount group

203



for through holes



22

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

Availability
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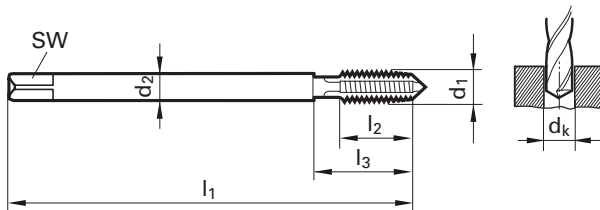
through holes



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****203**

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	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

Availability





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

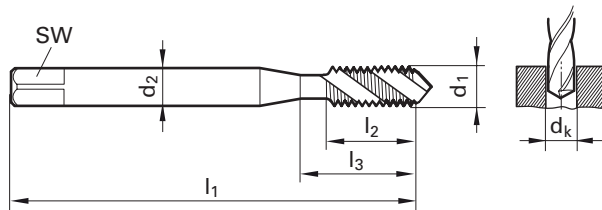
2B

Cutting direction

right-hand

Discount group

203



for blind holes



24

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

Availability
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through holes

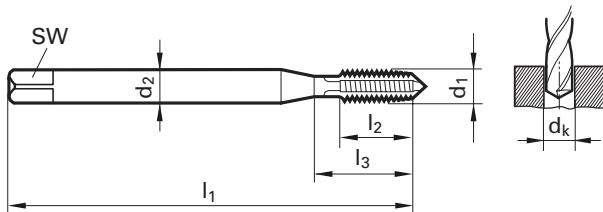


steam tempered



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.
	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

Availability
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for through holes





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

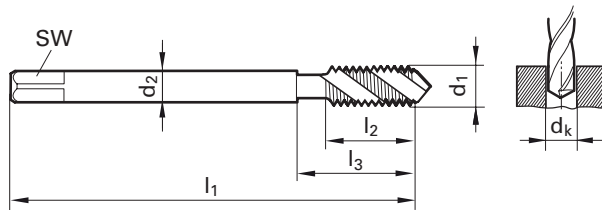
2B

Cutting direction

right-hand

Discount group

203



for blind holes



26

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

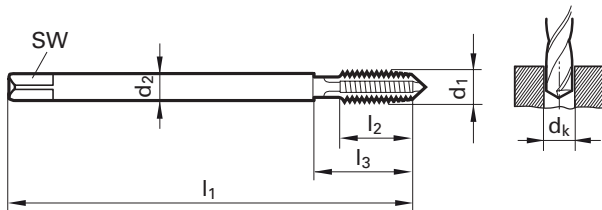
Availability
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Guhring no.	5727
Standard	DIN 2184-1
Standard	~ DIN 374
Tool material	HSS-E
Type	N
Form	B
Tolerance	2B
Cutting direction	right-hand
Discount group	203

 through holes

steam tempered

external cooling



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

Availability
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for through holes





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

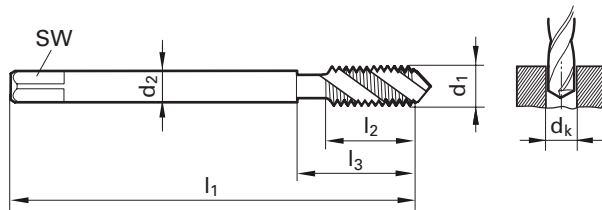
-

Cutting direction

right-hand

Discount group

203



for blind holes



28

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

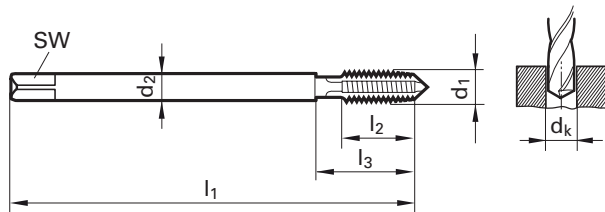
Availability
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Guhring no.	5731
Standard	DIN 2184-1
Standard	DIN 5156
Tool material	HSS-E
Type	N
Form	B
Tolerance	-
Cutting direction	right-hand
Discount group	203

 through holes

steam tempered

external cooling



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

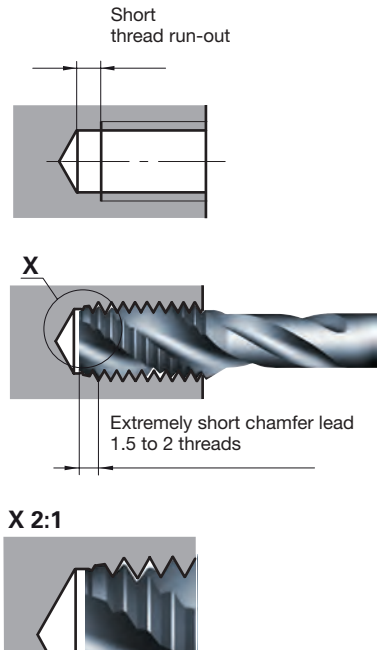
Availability
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for through holes



Why is Guhring increasingly offering Form E taps?

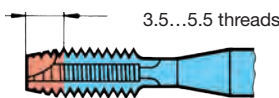
In addition to the conventional Form B and C for machine taps we are increasingly including Form E tools in our standard range. Thus, we are taking into account the increasing demand for taps with which threads can be produced as close as possible to the bottom of the bore when machining blind holes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

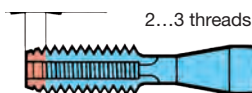
Conventional Forms B and C for machine taps

Form B



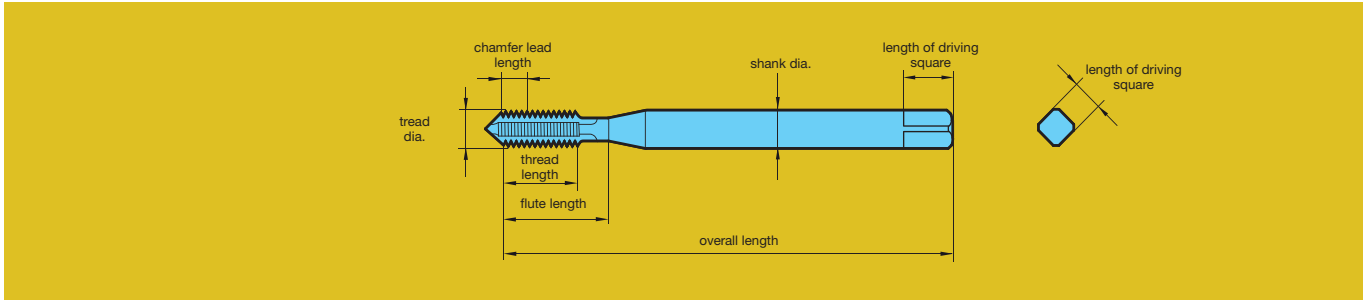
medium, 3.5 - 5.5 threads, with spiral point, for through holes

Form C

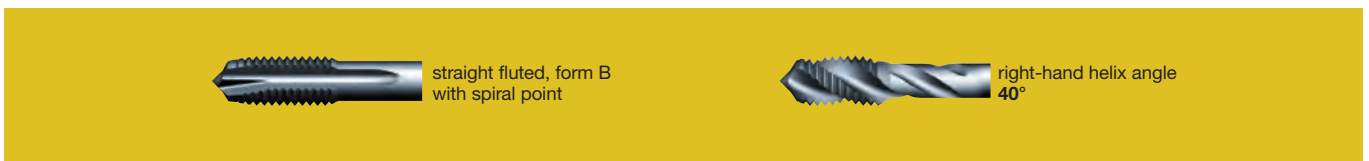


short, 2 - 3 threads for blind holes

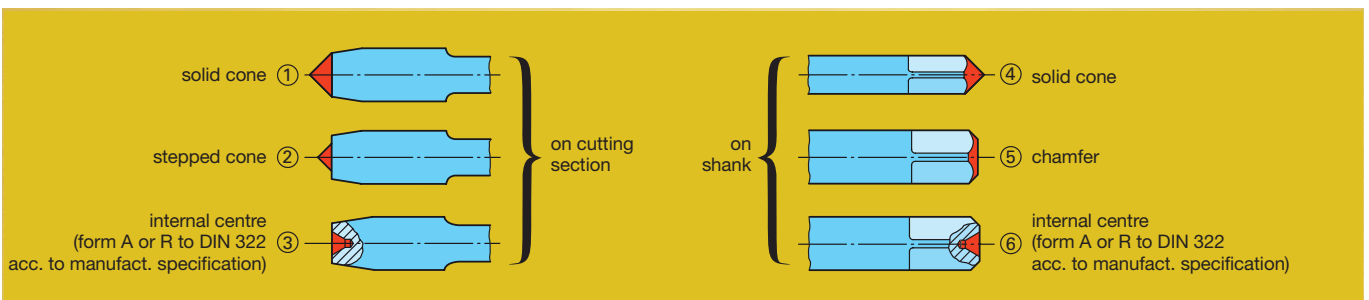
Definitions and angles



Flute forms



Types of centres



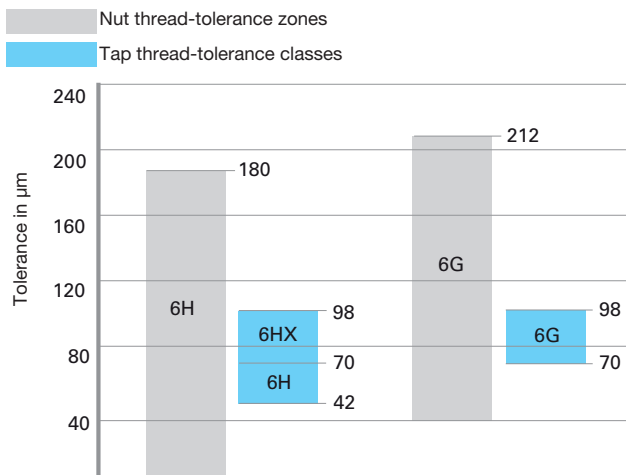
Thread dia. range mm	Centre on cutting section		Centre on shank
	with chamfer forms C, E	with chamfer form B	
≤ 4,2	①	①	④ ⑤ ⑥
> 4,2 ... 5,6	① ②	①	④ ⑤ ⑥
> 5,6 ... 10,0	① ② ③	① ② ③	④ ⑤ ⑥
> 10,0	③	③	⑥

	Tensile strength MPa (N/mm ²)	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
	martensitic	≤ 850	–	6 - 12
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	–	20 - 25
Cast iron	–	≤ 240	15 - 20	20 - 25
Spheroidal graphite iron	–	≤ 240	15 - 20	20 - 25
Malleable cast iron	–	< 300	15 - 20	20 - 25

* With coated tools V_c 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:


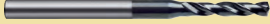







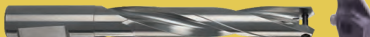
The tolerance zone 6H corresponds with the standard tolerance for taps to DIN EN 22857.

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		Tapping size hole Ø mm	Recommended core drills	
metric	inch			
M 2		1.600		
		2.350		carbide micro-precision drill, 4 x D, without IC, Guhring no. 6400
		2.400		
M 3		2.500		carbide micro-precision drill, 5 x D, with IC, Guhring no. 6405
		2.850		
		2.950		GU 500, jobber drill, HSCO, Guhring no. 5523
M 4		3.300		
		3.500		
		3.900		
		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		



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for internal, peripheral or
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application speed

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force/travel characteristic curve

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and thread accuracy

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PO Box 100247 | 72423 Albstadt
Herderstraße 50-54 | 72458 Albstadt

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

info@guehring.de
www.guehring.de

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