

powertap

UNIVERSAL TAPS

MADE BY

GUHRING



PERFECT CHOICE
FOR UNIVERSAL
APPLICATIONS

TOP QUALITY
FORM PRECISION
UNIVERSAL TAPS
powerful
perfect choice
UNF process
PERFECT
UNIV power
Power

PERFECT CHOICE
FOR MANY MATERIALS
POWER PRICE
UNIVERSAL TAPS
TAP **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!**

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!

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!

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									
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



d1 0,9 ... 2,6 mm

DIN 376 / DIN 374 / DIN 5156



d1 > 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



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	● 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

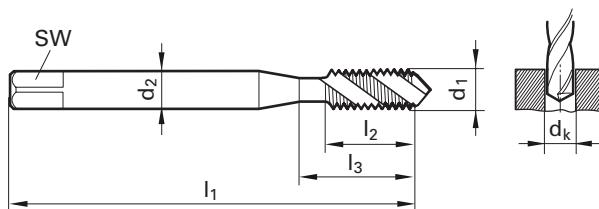
Machine taps for UNF-threads

~ 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

	Guhring no.	5734
<input checked="" type="checkbox"/> blind holes	Standard	DIN 2184-1
<input checked="" type="checkbox"/> steam tempered	Standard	DIN 371
<input checked="" type="checkbox"/> external cooling	Tool material	HSS-E
	Type	N R40
	Form	C
	Tolerance	ISO 2 / 6H
	Cutting direction	right-hand
	Discount group	203



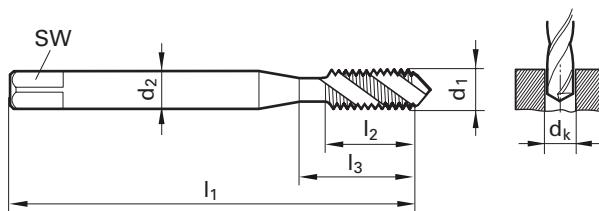
8

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



	blind holes	Guhring no.	5737
	TIN-coated	Standard	DIN 2184-1
<input checked="" type="checkbox"/>	external cooling	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



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

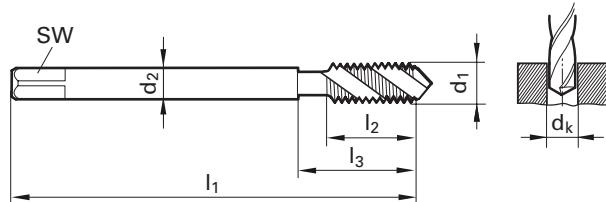
ISO 2 / 6H

Cutting direction

right-hand

Discount group

203



10

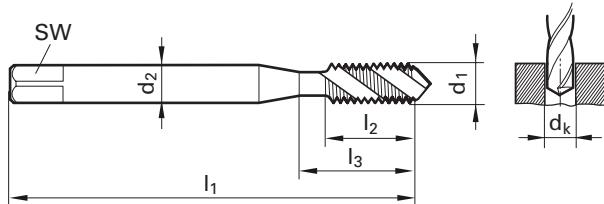
d1	P	d2	SW	dk	l1	l2	l3	Code no.
		mm	mm	mm	mm	mm	mm	
M 3	0.50	2.200		2.500	56.00	6.00	18.00	3.000
M 4	0.70	2.800	2.10	3.300	63.00	7.50	21.00	4.000
M 5	0.80	3.500	2.70	4.200	70.00	8.50	25.00	5.000
M 6	1.00	4.500	3.40	5.000	80.00	11.00	30.00	6.000
M 8	1.25	6.000	4.90	6.800	90.00	14.00	35.00	8.000
M10	1.50	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



	Guhring no.	5720
<input checked="" type="checkbox"/> steam tempered	Standard	DIN 2184-1
<input type="checkbox"/> external cooling	Standard	DIN 371
	Tool material	HSS-E
	Type	N R40
	Form	C
	Tolerance	ISO 3 / 6G
	Cutting direction	right-hand
	Discount group	203

**TOLERANCE
ISO 3/6G**



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



for blind holes



blind holes

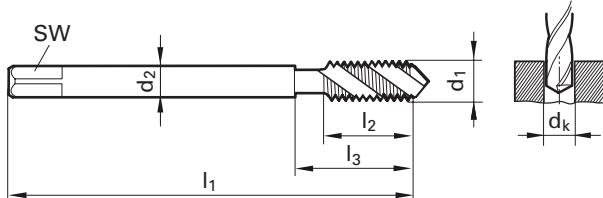


TiN-coated



external cooling

	Guhring no.	5738
 blind holes	Standard	DIN 2184-1
	Standard	DIN 376
 TiN-coated	Tool material	HSS-E
<input checked="" type="checkbox"/> external cooling	Type	N R40
	Form	C
	Tolerance	6HX
	Cutting direction	right-hand
	Discount group	203

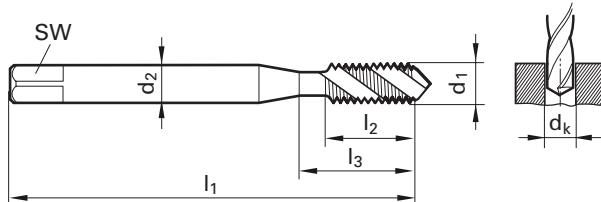


d1	P	d2	SW	dk	I1	I2	I3	Code no.
	mm	mm		mm	mm	mm	mm	
M 3	0.50	2.200		2.500	56.00	6.00	18.00	3.000
M 4	0.70	2.800	2.10	3.300	63.00	7.50	21.00	4.000
M 5	0.80	3.500	2.70	4.200	70.00	8.50	25.00	5.000
M 6	1.00	4.500	3.40	5.000	80.00	11.00	30.00	6.000
M 8	1.25	6.000	4.90	6.800	90.00	14.00	35.00	8.000
M10	1.50	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

The figure consists of five horizontal bars stacked vertically. The top bar is a solid yellow rectangle. Below it are three bars that are light yellow on the left and white on the right. The bottom bar is yellow on the left and light yellow on the right. A vertical black dot is positioned in the center of each bar.

	Guhring no.	5721
<input checked="" type="checkbox"/> blind holes	Standard	DIN 2184-1
<input checked="" type="checkbox"/> steam tempered	Standard	DIN 371
<input checked="" type="checkbox"/> external cooling	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



for blind holes

13



blind holes

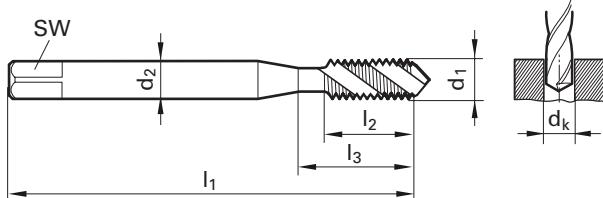


TiN-coated



external cooling

	Guhring no.	5722
 blind holes	Standard	DIN 2184-1
	Standard	DIN 371 / DIN 376
 TiN-coated	Tool material	HSS-E-PM
<input checked="" type="checkbox"/> external cooling	Type	N R50
	Form	C
	Tolerance	ISO 2 / 6H
	Cutting direction	right-hand
	Discount group	203



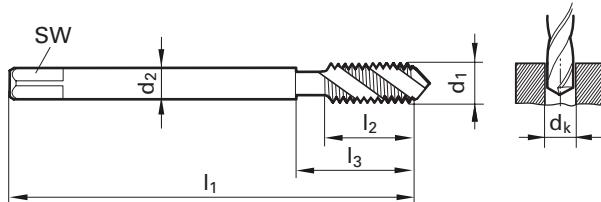
d1	P	d2	SW	dk	I1	I2	I3	Code no.
	mm	mm		mm	mm	mm	mm	
M 3	0.50	3.500	2.70	2.500	56.00	6.00	18.00	3.000
M 4	0.70	4.500	3.40	3.300	63.00	7.50	21.00	4.000
M 5	0.80	6.000	4.90	4.200	70.00	8.50	25.00	5.000
M 6	1.00	6.000	4.90	5.000	80.00	11.00	30.00	6.000
M 8	1.25	8.000	6.20	6.800	90.00	14.00	35.00	8.000
M 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

Availability



	blind holes	Guhring no.	5718
	TIN-coated	Standard	
<input checked="" type="checkbox"/>	external cooling	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.
		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

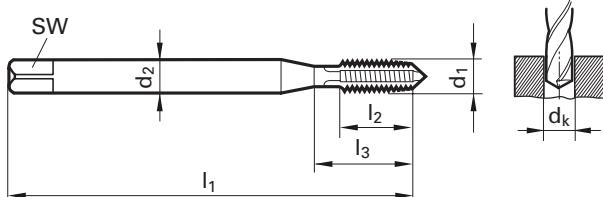


for blind holes

	Guhring no.	5733
<input checked="" type="checkbox"/> through holes	Standard	DIN 2184-1
	Standard	DIN 371
<input checked="" type="checkbox"/> steam tempered	Tool material	HSS-E
<input checked="" type="checkbox"/> external cooling	Type	N
	Form	B
	Tolerance	ISO 2 / 6H
	Cutting direction	right-hand
	Discount group	203

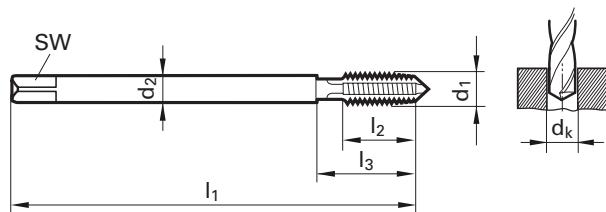
for through holes

16




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

	Guhring no.	5716
<input checked="" type="checkbox"/> steam tempered	Standard	DIN 2184-1
<input type="checkbox"/> external cooling	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	
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

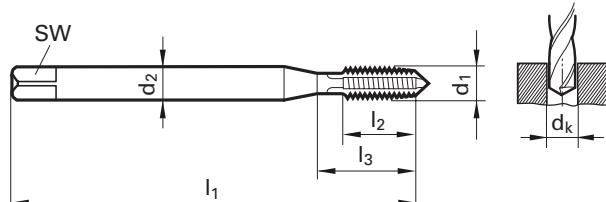


for through holes



	Guhring no.	5719
<input checked="" type="checkbox"/> through holes	Standard	DIN 2184-1
<input checked="" type="checkbox"/> steam tempered	Standard	DIN 371
<input checked="" type="checkbox"/> external cooling	Tool material	HSS-E
	Type	N
	Form	B
	Tolerance	ISO 3 / 6G
	Cutting direction	right-hand
	Discount group	203

**TOLERANCE
ISO 3/6G**



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
●
●
●
●



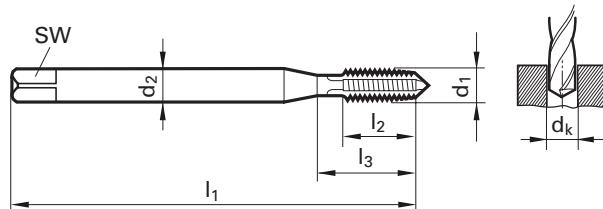
Guhring no.	5736
Standard	DIN 2184-1
Standard	DIN 371 / DIN 376
Tool material	HSS-E-PM
Type	N
Form	B
Tolerance	ISO 2 / 6H
Cutting direction	right-hand
Discount group	203



TIN-coated

external cooling

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



for through holes



blind holes

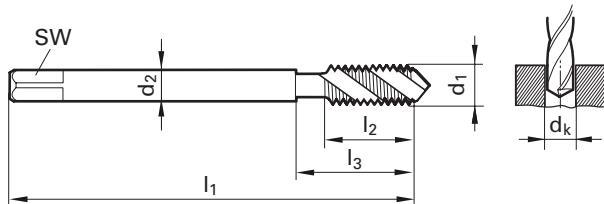


steam tempered



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
fitting direction	right-hand
discount group	203

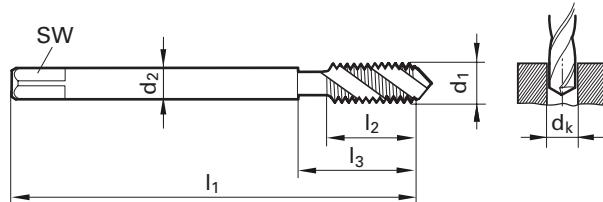


d1 X P	d2	SW	dk	I1	I2	I3	Code no.
	mm		mm	mm	mm	mm	
M 4 X 0.5	2.800	2.10	3.500	63.00	5.00	21.00	4.003
M 5 X 0.5	3.500	2.70	4.500	70.00	5.00	25.00	5.003
M 6 X 0.75	4.500	3.40	5.200	80.00	8.00	30.00	6.004
M 8 X1	6.000	4.90	7.000	90.00	11.00	35.00	8.005
M10 X1	7.000	5.50	9.000	90.00	11.00	35.00	10.005
M10 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

The figure consists of five horizontal bars stacked vertically. The colors of the bars transition from dark yellow at the top to light beige at the bottom. Each bar features a vertical column of black dots in its center. The number of dots per bar is as follows: the top bar has 3 dots, the second bar has 5 dots, the third bar has 3 dots, the fourth bar has 5 dots, and the bottom bar has 2 dots.

	blind holes	Guhring no.	5740
	TIN-coated	Standard	DIN 2184-1
<input checked="" type="checkbox"/>	external cooling	Standard	DIN 374
		Tool material	HSS-E-PM
		Type	N R40
		Form	C
		Tolerance	ISO 2 / 6H
		Cutting direction	right-hand
		Discount group	203

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



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





through holes

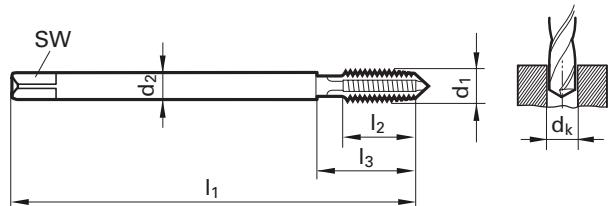


steam tempered



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



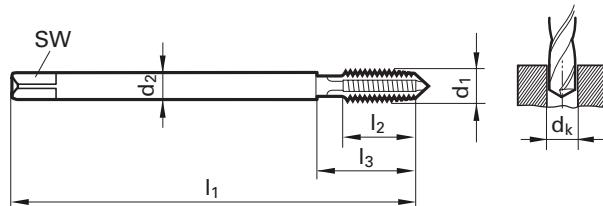
d1 X P	d2	SW	dk	I1	I2	I3	Code no.
	mm		mm	mm	mm	mm	
M 4 X 0.5	2.800	2.10	3.500	63.00	8.00	21.00	4.003
M 5 X 0.5	3.500	2.70	4.500	70.00	10.00	25.00	5.003
M 6 X 0.75	4.500	3.40	5.200	80.00	13.00	30.00	6.004
M 8 X 1	6.000	4.90	7.000	90.00	17.00	35.00	8.005
M 10 X 1	7.000	5.50	9.000	90.00	17.00	35.00	10.005
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

The figure is a vertical bar chart titled "Availability". It consists of five horizontal bars of different heights, each with a central black dot. The bars are arranged vertically from top to bottom. The top three bars are yellow, and the bottom two are a lighter beige color. The height of each bar corresponds to its availability level, with the number of black dots indicating the value. The bars are separated by thin white spaces.

Category	Availability Level
1	Low (1 dot)
2	Medium-Low (2 dots)
3	Medium-High (3 dots)
4	High (4 dots)
5	Very High (5 dots)

	through holes	Guhring no.	5739
<input checked="" type="checkbox"/> TIN-coated		Standard	DIN 2184-1
<input type="checkbox"/> external cooling		Standard	DIN 374
		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 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



 for through holes



blind holes

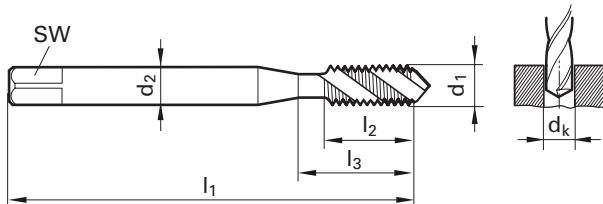


steam tempered



external cooling

	Guhring no.	5726
	Standard	DIN 2184-1
	Standard	~ DIN 371 / ~ DIN 376
blind holes	Tool material	HSS-E
<input type="radio"/>	Type	N R40
<input checked="" type="checkbox"/>	Form	C
steam tempered	Tolerance	2B
external cooling	Cutting direction	right-hand
	Discount group	203

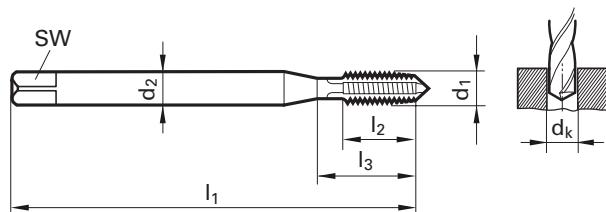


d1 - P	d2	SW	dk	I1	I2	I3	Code no.
	mm		mm	mm	mm	mm	
NO. 4 -40	3.500	2.70	2.350	56.00	7.00	18.00	2.845
NO. 6 -32	4.000	3.00	2.850	56.00	8.00	20.00	3.505
NO. 8 -32	4.500	3.40	3.500	63.00	8.00	21.00	4.166
NO.10 -24	6.000	4.90	3.900	70.00	11.00	25.00	4.826
1/4 -20	7.000	5.50	5.100	80.00	13.00	30.00	6.350
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



24

	through holes	Guhring no.	5725
<input checked="" type="checkbox"/>	steam tempered	Standard	DIN 2184-1
<input type="checkbox"/>	external cooling	Standard	~ DIN 371 / ~ DIN 376
		Tool material	HSS-E
		Type	N
		Form	B
		Tolerance	2B
		Cutting direction	right-hand
		Discount group	203



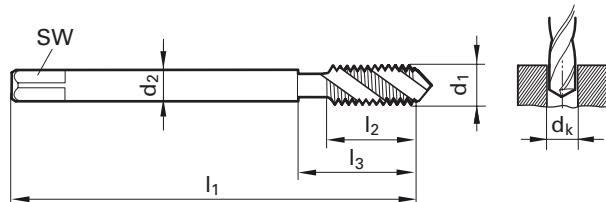
d1 - P	d2	SW	dk	l1	l2	l3	Code no.
	mm		mm	mm	mm	mm	
NO. 4 -40	3.500	2.70	2.350	56.00	11.00	18.00	2.845
NO. 6 -32	4.000	3.00	2.850	56.00	12.00	20.00	3.505
NO. 8 -32	4.500	3.40	3.500	63.00	13.00	21.00	4.166
NO.10 -24	6.000	4.90	3.900	70.00	14.00	25.00	4.826
1/4 -20	7.000	5.50	5.100	80.00	16.00	30.00	6.350
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



for through holes

	Guhring no.	5728
<input checked="" type="checkbox"/> blind holes	Standard	DIN 2184-1
	Standard	~ DIN 374
<input checked="" type="checkbox"/> steam tempered	Tool material	HSS-E
<input checked="" type="checkbox"/> external cooling	Type	N R40
	Form	C
	Tolerance	2B
	Cutting direction	right-hand
	Discount group	203

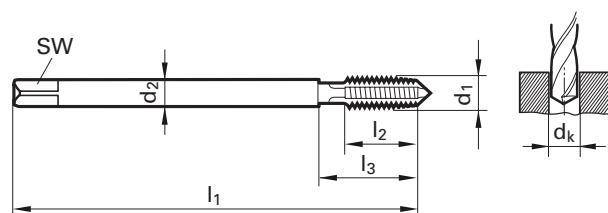


d1 - P	d2	SW	dk	l1	l2	l3	Code no.
	mm		mm	mm	mm	mm	
NO. 4 -48	2.200		2.400	56.00	6.00	18.00	2.845
NO. 6 -40	2.500	2.10	2.950	56.00	6.50	20.00	3.505
NO.10 -32	3.500	2.70	4.100	70.00	8.50	25.00	4.826
1/4 -28	4.500	3.40	5.500	80.00	9.00	30.00	6.350
3/8 -24	7.000	5.50	8.500	90.00	11.00	35.00	9.525
5/8 -18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

Availability



	through holes	Guhring no.	5727
<input checked="" type="checkbox"/>	steam tempered	Standard	DIN 2184-1
<input type="checkbox"/>	external cooling	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.
	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

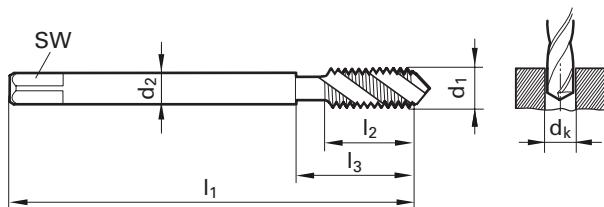
Availability



	Guhring no.	5732
<input checked="" type="checkbox"/> blind holes	Standard	DIN 2184-1
<input checked="" type="checkbox"/> steam tempered	Standard	DIN 5156
<input checked="" type="checkbox"/> external cooling	Tool material	HSS-E
	Type	N R40
	Form	C
	Tolerance	-
	Cutting direction	right-hand
	Discount group	203



28

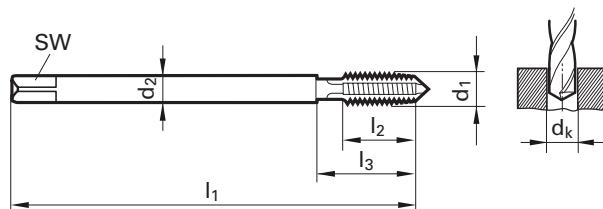


d1	P	d2	SW	dk	l1	l2	l3	Code no.
	G/inch	mm		mm	mm	mm	mm	
G 1/8	28.00	7.00	5.50	8.800	90.00	11.00	35.00	9.728
G 1/4	19.00	11.00	9.00	11.800	100.00	14.00	40.00	13.157
G 3/8	19.00	12.00	9.00	15.250	100.00	14.00	44.00	16.662
G 1/2	14.00	16.00	12.00	19.000	125.00	18.00	44.00	20.955
G 3/4	14.00	20.00	16.00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



	through holes	Guhring no.	5731
<input checked="" type="checkbox"/>	steam tempered	Standard	DIN 2184-1
<input type="checkbox"/>	external cooling	Standard	DIN 5156
		Tool material	HSS-E
		Type	N
		Form	B
		Tolerance	-
		Cutting direction	right-hand
		Discount group	203



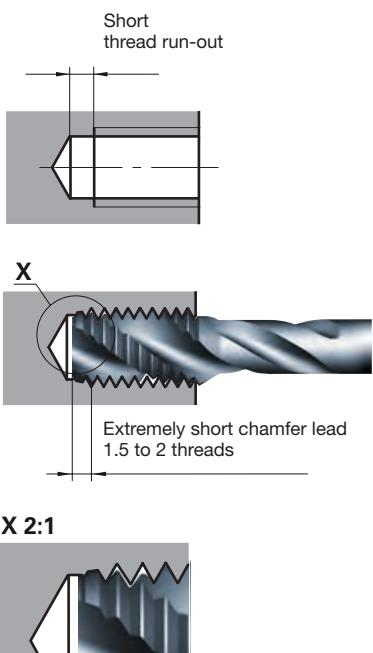
d1	P	d2	SW	dk	l1	l2	l3	Code no.
	G/inch	mm		mm	mm	mm	mm	
G 1/8	28.00	7.00	5.50	8.800	90.00	18.00	35.00	9.728
G 1/4	19.00	11.00	9.00	11.800	100.00	20.00	40.00	13.157
G 3/8	19.00	12.00	9.00	15.250	100.00	22.00	44.00	16.662
G 1/2	14.00	16.00	12.00	19.000	125.00	25.00	44.00	20.955
G 3/4	14.00	20.00	16.00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



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.

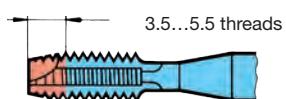


Taps with Form E feature an extremely short chamfer lead with only 1.5 to 2 threads. On modern machines and tapping chucks any inferior guidance of the tool in comparison to Forms B and C with long chamfer lead are eliminated. The run-out of the tap is impossible thanks to the rigid tool clamping. Taps 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

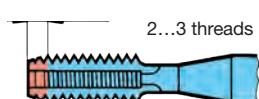
30

Form B



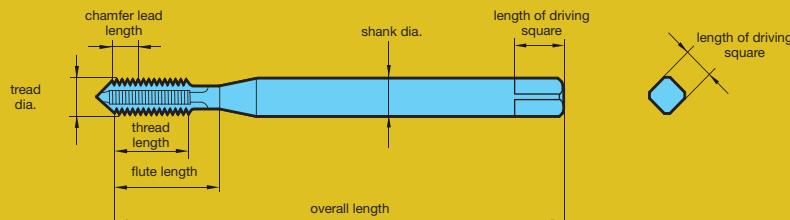
medium, 3.5 - 5.5 threads,
with spiral point,
for through holes

Form C



short, 2 - 3 threads
for blind holes

Definitions and angles



Flute forms

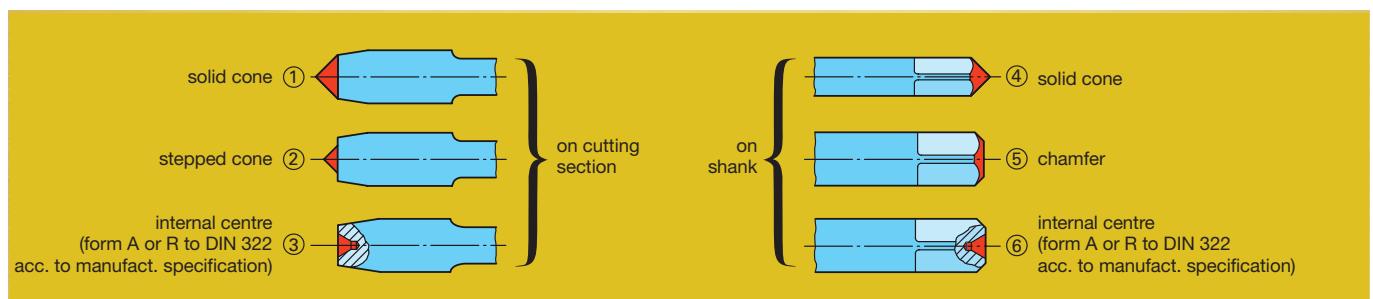


straight fluted, form B
with spiral point



right-hand helix angle
 40°

Types of centres

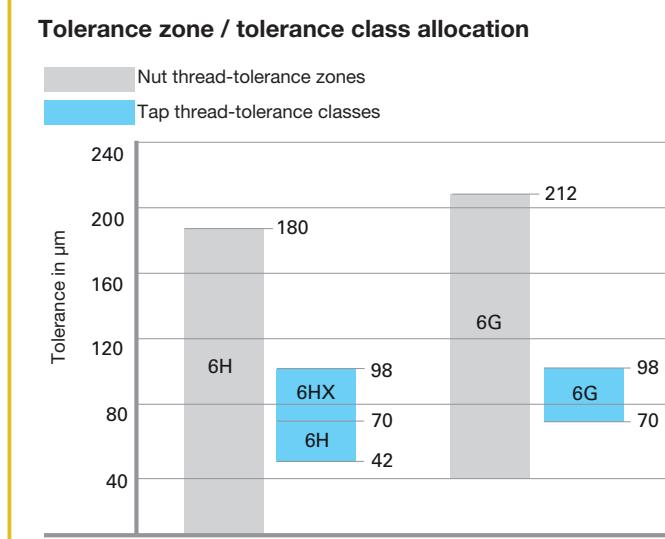


Thread dia. range mm	Centre on cutting section		Centre on shank
	with chamfer forms C, E	with chamfer form B	
$\leq 4,2$	(1)	(1)	(4) (5) (6)
$> 4,2 \dots 5,6$	(1) (2)	(1)	(4) (5) (6)
$> 5,6 \dots 10,0$	(1) (2) (3)	(1) (2) (3)	(4) (5) (6)
$> 10,0$	(3)	(3)	(6)

	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 austenitic martensitic	≤ 850	–	6 - 12	8 - 15
	≤ 850	–	6 - 12	8 - 15
	≤ 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 > 10 % Si	≤ 600	–	15 - 20	20 - 25
	≤ 600	–	15 - 20	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



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.

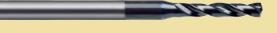
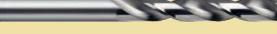
6HX:

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.

Powertap recommended tapping hole drills / **powertap**

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	
M 5		4.100	
		4.200	
	M 6	5.000	
M 6 X 0.75	1/4 -20	5.100	
		5.200	
	1/4 -28	5.500	
M 8	5/16-18	6.600	
		6.800	 RT 100 U, 5 x D, with IC, Guhring no. 5511
	M 8 X1	7.000	
M10	3/8 -16	8.000	 RT 100 U, 5 x D, without IC, Guhring no. 5515
	3/8 -24	8.500	
	M10 X1.25	G 1/8	 GU 500, jobber drill, HSCO, Guhring no. 5523
M10 X1		9.000	
		9.400	
	7/16-14	10.200	
M12		10.500	
	M12 X1.5	10.800	
	M12 X1.25	1/2 -13	
M12 X1		11.000	
		G 1/4	
	M14	11.800	
M14		12.000	
	M14 X1.5	12.500	
	M14 X1	13.000	
M16	5/8 -11	13.500	
		14.000	
	M16 X1.5	5/8 -18	
M16 X1		14.500	
		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	 RT 100 U, 5 x D, without IC, Guhring no. 5515
	M20	16.500	
M20 X1.5		17.500	
		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
		24.500	
	G 3/4	24.500	
G1		30.750	
	G1	30.750	



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for up to 75% reduced axial forces

for internal, peripheral or
MQL cooling lubrication

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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

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and thread accuracy

The new **GÜHROSync** tapping chuck

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by **GUHRING**

SAME PRICE
MORE PERFORMANCE

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*power*tap

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Guhring KG

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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