

powertap

UNIVERSAL TAPS

MADE BY
GUHRING



PERFECT CHOICE
FOR ALL MATERIALS

TOP OF TR
FORME RS
UNIV AF
pow ul
perfect deal
choice UNF life
PROC BLE
PERFE ORN
UNIV AL
pow ul
Power VE

PERFECT CHOICE
FOR ALL MATERIALS
POWER
PRICE UNI
VER
UNIVERSAL TAPS SAL
TAL UNF Power
VERSAL 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



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!

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!**

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

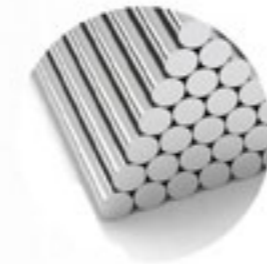
Optimised geometries for maximum performance!



Completely precision ground on specially developed machines!



Finest quality steels as tool material!



More power for your production!



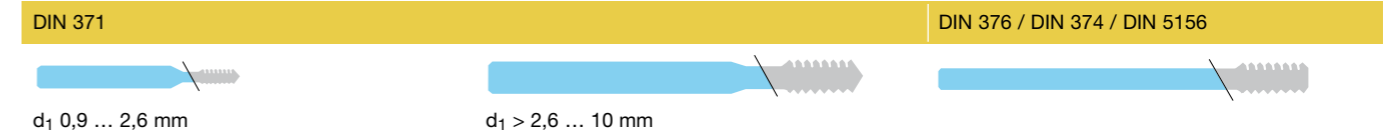
In Treuen/Saxony Guhring has built for you: 4000 m² facility with state-of-the-art manufacturing technology!



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 DIN2184-1	Guhring no. O-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



Typee clarification

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

by **GUHRING**

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



blind holes



through holes



steam tempered



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		M 4 x 0.5 - M 20 x 1.5	5724	203	20
DIN 374	N R40	C	ISO 2 / 6H		HSS-E-PM	S	M 8 x 1 - M 24 x 2	5740	203	21
DIN 374	N	B	ISO 2 / 6H		HSS-E		M 4 x 0.5 - M 20 x 1.5	5723	203	22
DIN 374	N	B	ISO 2 / 6H		HSS-E-PM	S	M 8 x 1 - M 24 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

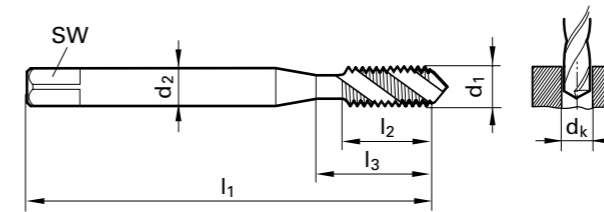
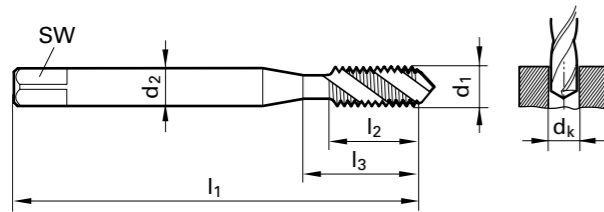
DIN 5156	N R40	C	-		HSS-E		G 1/8 - G 1	5732	203	28
DIN 5156	N	B	-		HSS-E		G 1/8 - G 1	5731	203	29

Powertap overview

Powertap overview

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

	Guhring no.	5737
	Standard	DIN 2184-1
 blind holes	Standard	DIN 371
<input checked="" type="checkbox"/> TiN-coated	Tool material	HSS-E
<input checked="" type="checkbox"/> external cooling	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	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	●


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


for blind holes

for blind holes

8

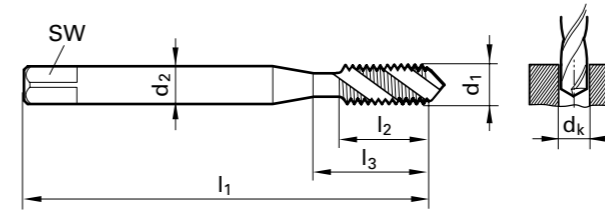
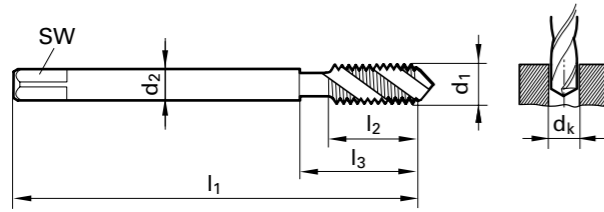
9

	Guhring no.	5717
	Standard	DIN 2184-1
 blind holes	Standard	DIN 376
<input type="checkbox"/> steam tempered	Tool material	HSS-E
<input checked="" type="checkbox"/> external cooling	Type	N R40
	Form	C
	Tolerance	ISO 2 / 6H
	Cutting direction	right-hand
	Discount group	203

	Guhring no.	5720
	Standard	DIN 2184-1
 blind holes	Standard	DIN 371
<input type="checkbox"/> steam tempered	Tool material	HSS-E
<input checked="" type="checkbox"/> external cooling	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.	Availability
mm	mm	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	●

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	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	●

for blind holes
10

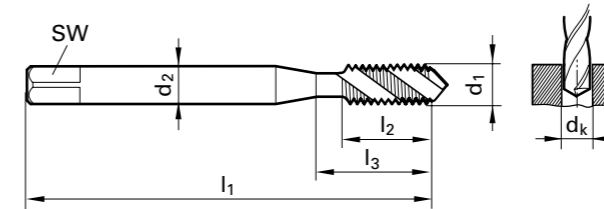
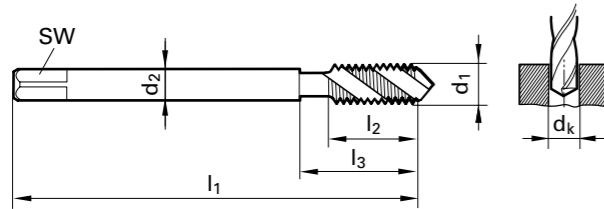
for blind holes
11

	Guhring no.	5738
	Standard	DIN 2184-1
 blind holes	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

	Guhring no.	5721
	Standard	DIN 2184-1
 blind holes	Standard	DIN 371
 steam tempered	Tool material	HSS-E
<input checked="" type="checkbox"/> external cooling	Type	N R40
	Form	E
	Tolerance	ISO 2 / 6H
	Cutting direction	right-hand
	Discount group	203


**TOLERANCE
6HX**


**FORM E
WITH SHORT
CHAMFER
LEAD**



d1	P	d2	SW	dk	l1	l2	l3	Code no.	Availability
mm	mm	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	●	
M 5	0.80	3.500	2.70	4.200	70.00	8.50	25.00	●	
M 6	1.00	4.500	3.40	5.000	80.00	11.00	30.00	●	
M 8	1.25	6.000	4.90	6.800	90.00	14.00	35.00	●	
M10	1.50	7.000	5.50	8.500	100.00	16.00	39.00	●	
M12	1.75	9.000	7.00	10.20	110.00	18.50	49.00	●	
M14	2.00	11.000	9.00	12.00	110.00	20.00	53.00	●	
M16	2.00	12.000	9.00	14.00	110.00	20.00	54.00	●	
M20	2.50	16.000	12.00	17.50	140.00	25.00	62.00	●	
M24	3.00	18.000	14.50	21.00	160.00	30.00	73.00	●	

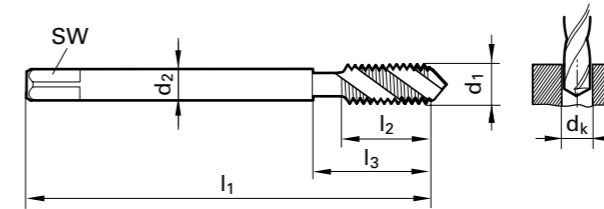
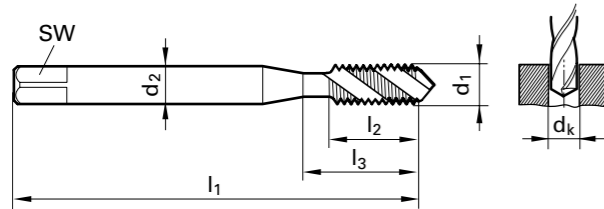
d1	P	d2	SW	dk	l1	l2	l3	Code no.	Availability
mm	mm	mm	mm	mm	mm	mm	mm		
M 3	0.50	3.500	2.70	2.500	56.00	6.00	18.00	3.000	●
M 4	0.70	4.500	3.40	3.300	63.00	7.50	21.00	4.000	●
M 5	0.80	6.000	4.90	4.200	70.00	8.50	25.00	5.000	●
M 6	1.00	6.000	4.90	5.000	80.00	11.00	30.00	6.000	●
M 8	1.25	8.000	6.20	6.800	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	Guhring no.	5722
<input checked="" type="checkbox"/> external cooling	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

 blind holes	Guhring no.	5718
<input checked="" type="checkbox"/> external cooling	Standard	
	Standard	Guhring standard
	Tool material	HSS-E
	Type	N R40
	Form	C
	Tolerance	6HX
	Cutting direction	right-hand
	Discount group	203

**HSS-E-PM + TIN
+ 50°-HELIX
FOR MAXIMUM
TOOL LIFE**

**EXTRA
LENGTH TAP**



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	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	●

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	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	●


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

 through holes

steam tempered

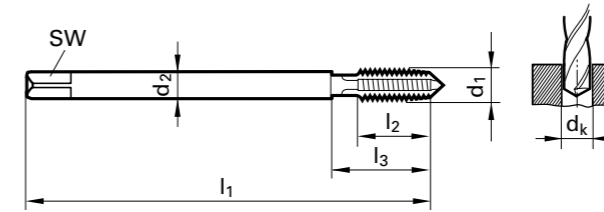
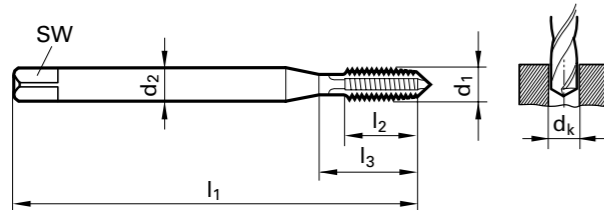
external cooling

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

 through holes


steam tempered

external cooling





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

d1	P	d2	SW	dk	l1	l2	l3	Code no.	Availability
mm	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
<input type="radio"/>	steam tempered
<input checked="" type="checkbox"/>	external cooling

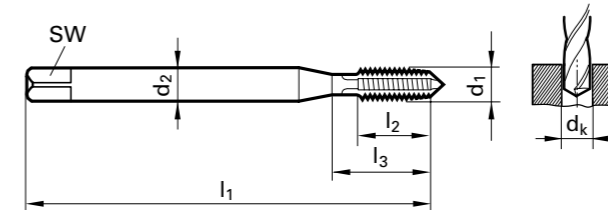
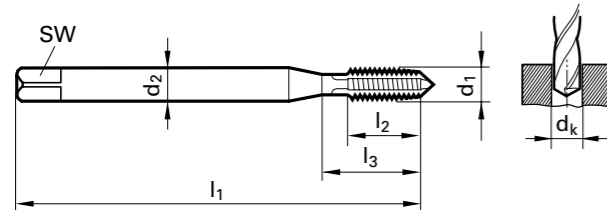
Guhring no.	5719
Standard	DIN 2184-1
Standard	DIN 371
Tool material	HSS-E
Type	N
Form	B
Tolerance	ISO 3 / 6G
Cutting direction	right-hand
Discount group	203

	through holes
	TiN-coated
<input checked="" type="checkbox"/>	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

**TOLERANCE
ISO 3/6G**

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



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	●
M 10	1.50	10.000	8.00	8.500	100.00	20.00	39.00	10.000	●
									●
									●
									●
									●
									●
									●
									●

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

for through holes

for through holes

	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



blind holes

● steam tempered

☒ 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



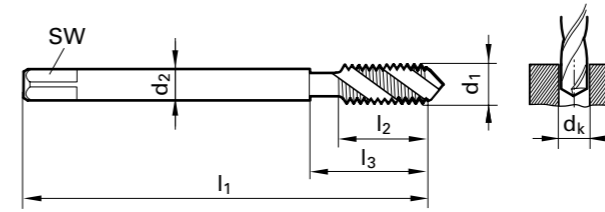
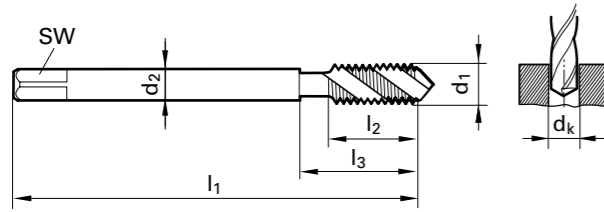
blind holes

Ⓢ TiN-coated

☒ external cooling



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



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 X 1	6.000	4.90	7.000	90.00	11.00	35.00	8.005	●
M 10 X 1	7.000	5.50	9.000	90.00	11.00	35.00	10.005	●
M 10 X 1.25	7.000	5.50	8.800	100.00	14.00	39.00	10.006	●
M 12 X 1	9.000	7.00	11.000	100.00	11.00	40.00	12.005	●
M 12 X 1.25	9.000	7.00	10.800	100.00	16.00	40.00	12.006	●
M 12 X 1.5	9.000	7.00	10.500	100.00	16.00	40.00	12.007	●
M 14 X 1	11.000	9.00	13.000	100.00	11.00	40.00	14.005	●
M 14 X 1.5	11.000	9.00	12.500	100.00	15.00	40.00	14.007	●
M 16 X 1	12.000	9.00	15.000	100.00	11.00	44.00	16.005	●
M 16 X 1.5	12.000	9.00	14.500	100.00	15.00	44.00	16.007	●
M 20 X 1.5	16.000	12.00	18.500	125.00	16.00	44.00	20.007	●

d1 X P	d2	SW	dk	l1	l2	l3	Code no.	Availability
	mm		mm	mm	mm	mm		
M 8 X 1	6.000	4.90	7.000	90.00	11.00	35.00	8.005	●
M 10 X 1	7.000	5.50	9.000	90.00	11.00	35.00	10.005	●
M 10 X 1.25	7.000	5.50	8.800	100.00	14.00	39.00	10.006	●
M 12 X 1	9.000	7.00	11.000	100.00	11.00	40.00	12.005	●
M 12 X 1.25	9.000	7.00	10.800	100.00	16.00	40.00	12.006	●
M 12 X 1.5	9.000	7.00	10.500	100.00	16.00	40.00	12.007	●
M 14 X 1	11.000	9.00	13.000	100.00	11.00	40.00	14.006	●
M 14 X 1.5	11.000	9.00	12.500	100.00	15.00	40.00	14.007	●
M 16 X 1.5	12.000	9.00	14.500	100.00	15.00	44.00	16.007	●
M 18 X 1.5	14.000	11.00	16.500	110.00	16.00	44.00	18.007	●
M 20 X 1.5	16.000	12.00	18.500	125.00	16.00	44.00	20.007	●
M 22 X 1.5	18.000	14.50	20.500	125.00	16.00	44.00	22.007	●
M 24 X 1.5	18.000	14.50	22.500	140.00	16.00	48.00	24.007	●
M 24 X 2	18.000	14.50	22.000	140.00	22.00	48.00	24.008	●

for blind holes

for blind holes


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

 through holes

steam tempered

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

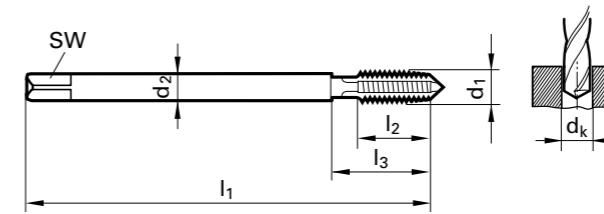
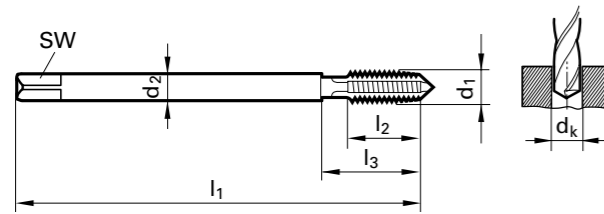
 through holes

TiN-coated

external cooling



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



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	●

d1 X P	d2	SW	dk	l1	l2	l3	Code no.	Availability
	mm		mm	mm	mm	mm		
M 8 X 1	6.000	4.90	7.000	90.00	16.00	35.00	8.005	●
M10 X 1	7.000	5.50	9.000	90.00	16.00	35.00	10.005	●
M10 X 1.25	7.000	5.50	8.800	100.00	20.00	39.00	10.006	●
M12 X 1	9.000	7.00	11.000	100.00	20.00	40.00	12.005	●
M12 X 1.25	9.000	7.00	10.800	100.00	20.00	40.00	12.006	●
M12 X 1.5	9.000	7.00	10.500	100.00	20.00	40.00	12.007	●
M14 X 1	11.000	9.00	13.000	100.00	20.00	40.00	14.006	●
M14 X 1.5	11.000	9.00	12.500	100.00	20.00	40.00	14.007	●
M16 X 1.5	12.000	9.00	14.500	100.00	22.00	44.00	16.007	●
M18 X 1.5	14.000	11.00	16.500	110.00	25.00	44.00	18.007	●
M20 X 1.5	16.000	12.00	18.500	125.00	25.00	44.00	20.007	●
M22 X 1.5	18.000	14.50	20.500	125.00	25.00	44.00	22.007	●
M24 X 1.5	18.000	14.50	22.500	140.00	28.00	48.00	24.007	●
M24 X 2	18.000	14.50	22.000	140.00	28.00	48.00	24.008	●

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



blind holes

steam tempered

external cooling

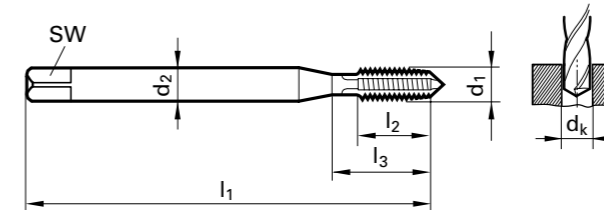
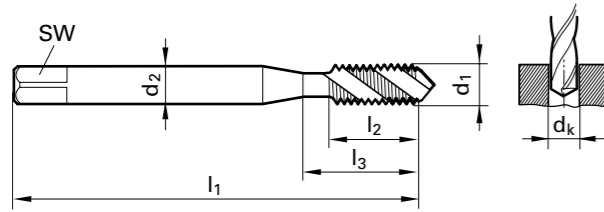
Guhring no.	5725
Standard	DIN 2184-1
Standard	~ DIN 371 / ~ DIN 376
Tool material	HSS-E
Type	N
Form	B
Tolerance	2B
Cutting direction	right-hand
Discount group	203



through holes

steam tempered

external cooling




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	●


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	●

for blind holes

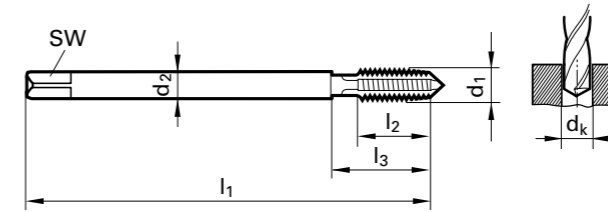
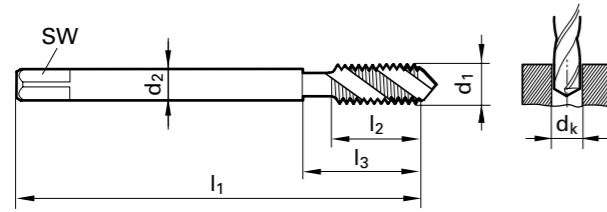
for through holes

	blind holes
<input type="radio"/>	steam tempered
<input checked="" type="checkbox"/>	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

	through holes
<input type="radio"/>	steam tempered
<input checked="" type="checkbox"/>	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	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	●


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	●

for blind holes

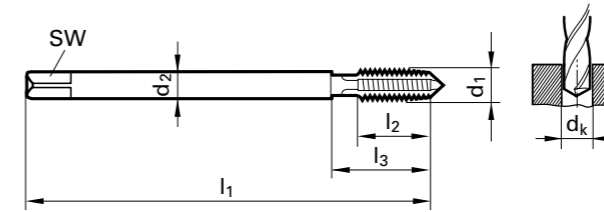
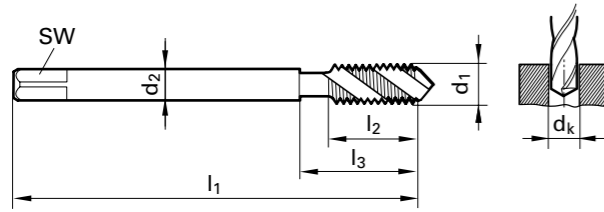
for through holes

	blind holes
<input type="radio"/>	steam tempered
<input checked="" type="checkbox"/>	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

	through holes
<input type="radio"/>	steam tempered
<input checked="" type="checkbox"/>	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	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	●

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	●

for blind holes

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.

Short thread run-out

Extremely short chamfer lead 1.5 to 2 threads

X 2:1

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

3.5...5.5 threads

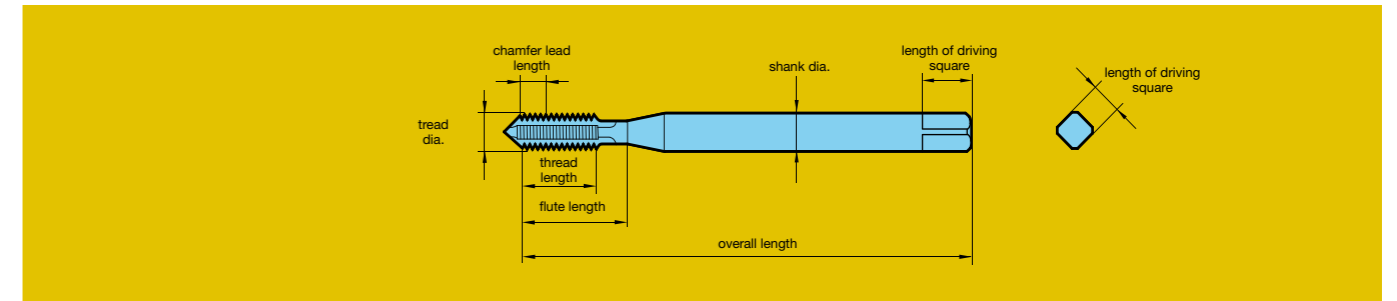
medium, 3.5 - 5.5 threads, with spiral point, for through holes

Form C

2...3 threads

short, 2 - 3 threads for blind holes

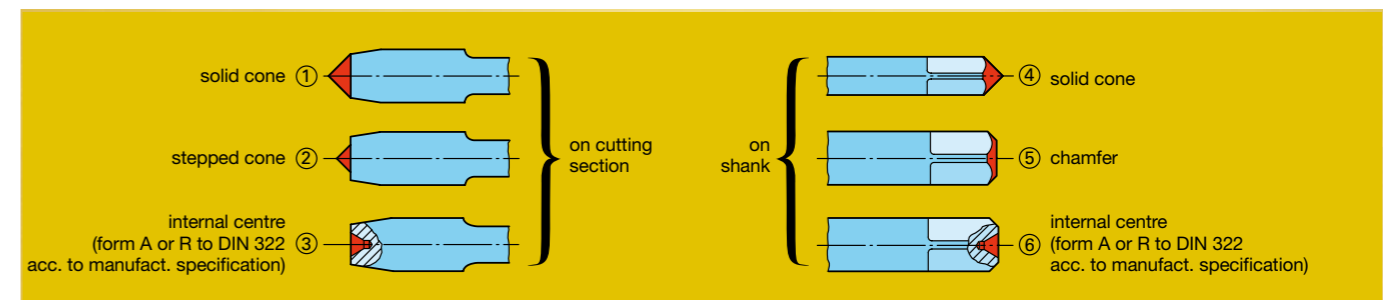
Definitions and angles



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	–	15 - 20
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 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	
			Image	Description
M 2	NO. 4 -40	1.600		carbide micro-precision drill, 4 x D, without IC, Guhring no. 6400
	NO. 4 -48	2.350		carbide micro-precision drill, 5 x D, with IC, Guhring no. 6405
M 3	NO. 6 -32	2.500		GU 500, jobber drill, HSCO, Guhring no. 5523
	NO. 6 -40	2.850		
M 4	NO. 8 -32	3.300		
	NO.10 -24	3.900		
	NO.10 -32	4.100		
M 5		4.200		
		5.000		
M 6	1/4 -20	5.100		
		5.200		
M 6 X 0.75	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
		9.000		
M10 X1		9.400		
	7/16-14	10.200		
M12		10.500		
		10.800		
M12 X1.25	1/2 -13	10.800		
		11.000		
M12 X1		11.800		
	G 1/4	12.000		
M14		12.500		
		13.000		
M14 X1		13.500		
	5/8 -11	14.000		
M16		14.500		
		15.000		
M16 X1.5	5/8 -18	14.500		RT 100 U, 5 x D, with IC, Guhring no. 5511
		15.250		
M16 X1	G 3/8	15.250		
		15.500		RT 100 U, 5 x D, without IC, Guhring no. 5515
M 18		16.500		
	3/4 -10	16.500		
M20		17.500		
		18.500		HT 800 holder 5 x D and insert, Guhring no. 4108 + 4112
M20 X1.5	G 1/2	18.500		
		19.000		
M22 X1.5		20.500		
		21.000		
M24		22.000		
		22.500		HT 800 holder 5 x D and insert, Guhring no. 4108 + 4112
M24 X2		22.500		
		24.500		
M24 X1.5	G 3/4	24.500		
	G1	30.750		

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maximum tool life
and thread accuracy

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MORE PERFORMANCE

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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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