powertap

UNIVERSAL**TAPS**

MADE BY

GÜHRING

PERFECT CHOICE
FOR UNIVERSAL
APPLICATIONS

PERFECT CHOICE
FOR MANY MATERIALS
POWER
PRICE
UNIVERSAL TAPS
UNC
perfect thread form
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 Gühring's new PowerTaps: Performance, quality, price and universal application range. Gühring'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 Gühring PowerTaps makes them genuine all-rounders in close to all materials.

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

by GÜHRING

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!

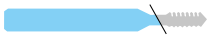
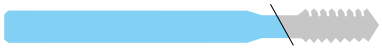
More power for your production!

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

by GÜHRING

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	**Article 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** / **Gühring standard** (long reach)		**5718** M3 – M20 *p. 15*					
M / **ISO 2 6H** / **DIN 376**	**5717** M3 – M20 *p. 10*				**5722** M12 – M20 *p. 14*	**5716** M3 – M20 *p. 17*	**5736** M12 – M20 *p. 19*
M / **6HX** / **DIN 376**		**5738** M3 – M24 *p. 12*					
MF / **ISO 2 6H** / **DIN 374**	**5724** M4x0.5 – M20x1.5 *p. 20*		**5740** M8x1 – M24x2 *p. 21*			**5723** M4x0.5 – M20x1.5 *p. 22*	**5739** M8x1 – M24x2 *p. 23*
UNC / **2B** / **~ DIN 371**	**5726** Nr. 4-40 – 3/8 - 16 *p. 24*					**5725** Nr. 4-40 – 3/8 - 16 *p. 25*	
UNC / **2B** / **~ DIN 376**	**5726** 7/16 - 14 – 3/4 - 10 *p. 24*					**5725** 7/16 - 14 – 3/4 - 10 *p. 25*	
UNF / **2B** / **~ DIN 374**	**5728** Nr. 4-48 – 5/8 - 18 *p. 26*					**5727** Nr. 4-48 – 5/8 - 18 *p. 27*	
G BSP-taps / **–** / **DIN 5156**	**5732** G 1/8 – G 1 *p. 28*					**5731** G 1/8 – G 1 *p. 29*	

Shank designs

DIN 371		DIN 376 / DIN 374 / DIN 5156
		
d_1 0.9 … 2.6 mm	d_1 > 2.6 … 10 mm	

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

Blind holes — steam tempered — Through holes — TiN-beschichtet — external cooling

Machine taps for ISO metric threads

Standard	Type	Form	Tole-rance	Tool illustration	Tool material	Surface finish	d1	Article no.	Discount group	Standard range page
DIN 371	N R40	C	ISO 2 / 6H		HSS-E	○	M 3 - M 10	5734	203	8
DIN 371	N R40	C	ISO 2 / 6H		HSS-E	S	M 2 - M 10	5737	203	9
DIN 376	N R40	C	ISO 2 / 6H		HSS-E	○	M 3 - M 20	5717	203	10
DIN 371	N R40	C	ISO 3 / 6G		HSS-E	○	M 3 - M 10	5720	203	11
DIN 376	N R40	C	6HX		HSS-E	S	M 3 - M 24	5738	203	12
DIN 371	N R40	E	ISO 2 / 6H		HSS-E	○	M 3 - M 10	5721	203	13
DIN 371/ 376	N R50	C	ISO 2 / 6H		HSS-E-PM	S	M 3 - M 20	5722	203	14
Gühring 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

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

Blind holes
○ steam tempered
Through holes
S TiN-beschichtet
external cooling

Machine taps for ISO metric fine threads

Standard	Type	Form	Tole-rance	Tool illustration	Tool material	Surface finish	d1	Article no.	Discount group	Standard range page
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

Standard	Type	Form	Tole-rance	Tool illustration	Tool material	Surface finish	d1	Article no.	Discount group	Standard range page
~ 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

Standard	Type	Form	Tole-rance	Tool illustration	Tool material	Surface finish	d1	Article no.	Discount group	Standard range page
~ 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

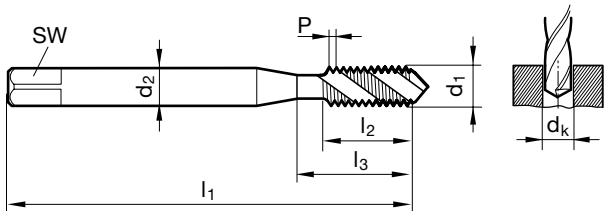
Standard	Type	Form	Tole-rance	Tool illustration	Tool material	Surface finish	d1	Article no.	Discount group	Standard range page
DIN 5156	N R40	C	-		HSS-E		G 1/8 - G1	5732	203	28
DIN 5156	N	B	-		HSS-E		G 1/8 - G1	5731	203	29

blind holes

steam tempered

external cooling

Article no.	**5734**
Standard	**DIN 2184-1**
Standard	**DIN 371**
Tool material	**HSS-E**
Type	**N R40**
Form	**C**
Tolerance	**ISO 2 / 6H**
Cutting direction	**right-hand**
Discount group	**203**



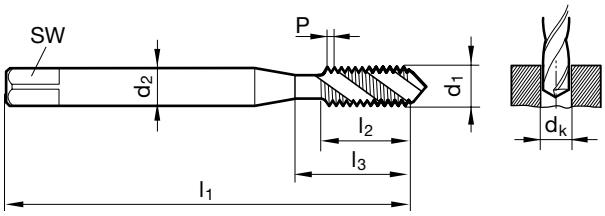
d1	P	d2	SW	dk	l1	l2	l3	Code no.	Availability
	mm	mm		mm	mm	mm	mm		
M 3	0.50	3.500	2.70	2.500	56.00	6.00	18.00	3.000	●
M 4	0.70	4.500	3.40	3.300	63.00	7.50	21.00	4.000	●
M 5	0.80	6.000	4.90	4.200	70.00	8.50	25.00	5.000	●
M 6	1.00	6.000	4.90	5.000	80.00	11.00	30.00	6.000	●
M 8	1.25	8.000	6.20	6.800	90.00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

blind holes

TiN-coated

external cooling

Article no.	**5737**
Standard	**DIN 2184-1**
Standard	**DIN 371**
Tool material	**HSS-E**
Type	**N R40**
Form	**C**
Tolerance	**ISO 2 / 6H**
Cutting direction	**right-hand**
Discount group	**203**



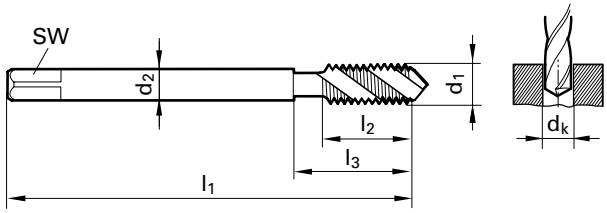
d1	P	d2	SW	dk	l1	l2	l3	Code no.	Availability
	mm	mm		mm	mm	mm	mm		
M 2	0.40	2.800	2.10	1.600	45.00	4.50	13.50	2.000	●
M 3	0.50	3.500	2.70	2.500	56.00	6.00	18.00	3.000	●
M 4	0.70	4.500	3.40	3.300	63.00	7.50	21.00	4.000	●
M 5	0.80	6.000	4.90	4.200	70.00	8.50	25.00	5.000	●
M 6	1.00	6.000	4.90	5.000	80.00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

blind holes

steam tempered

external cooling

Article no.	**5717**
Standard	**DIN 2184-1**
Standard	**DIN 376**
Tool material	**HSS-E**
Type	**N R40**
Form	**C**
Tolerance	**ISO 2 / 6H**
Cutting direction	**right-hand**
Discount group	**203**



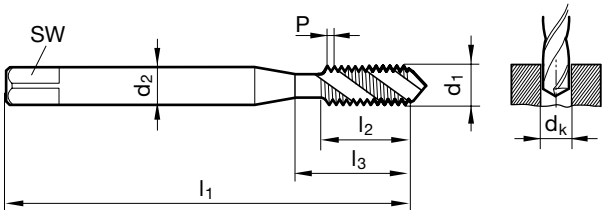
d1	P	d2	SW	dk	l1	l2	l3	Code no.	Availability
	mm	mm		mm	mm	mm	mm		
M 3	0.50	2.200		2.500	56.00	6.00	18.00	3.000	●
M 4	0.70	2.800	2.10	3.300	63.00	7.50	21.00	4.000	●
M 5	0.80	3.500	2.70	4.200	70.00	8.50	25.00	5.000	●
M 6	1.00	4.500	3.40	5.000	80.00	11.00	30.00	6.000	●
M 8	1.25	6.000	4.90	6.800	90.00	14.00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

blind holes

steam tempered

external cooling

Article no.	**5720**
Standard	**DIN 2184-1**
Standard	**DIN 371**
Tool material	**HSS-E**
Type	**N R40**
Form	**C**
Tolerance	**ISO 3 / 6G**
Cutting direction	**right-hand**
Discount group	**203**



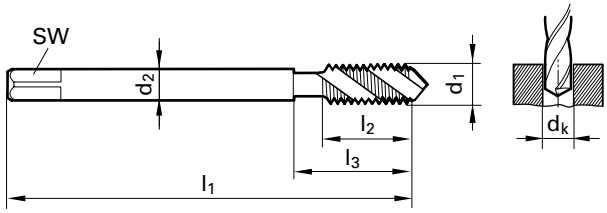
d1	P	d2	SW	dk	l1	l2	l3	Code no.	Availability
	mm	mm		mm	mm	mm	mm		
M 3	0.50	3.500	2.70	2.500	56.00	6.00	18.00	3.000	●
M 4	0.70	4.500	3.40	3.300	63.00	7.50	21.00	4.000	●
M 5	0.80	6.000	4.90	4.200	70.00	8.50	25.00	5.000	●
M 6	1.00	6.000	4.90	5.000	80.00	11.00	30.00	6.000	●
M 8	1.25	8.000	6.20	6.800	90.00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

blind holes

TiN-coated

external cooling

Article no.	**5738**
Standard	**DIN 2184-1**
Standard	**DIN 376**
Tool material	**HSS-E**
Type	**N R40**
Form	**C**
Tolerance	**6HX**
Cutting direction	**right-hand**
Discount group	**203**



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

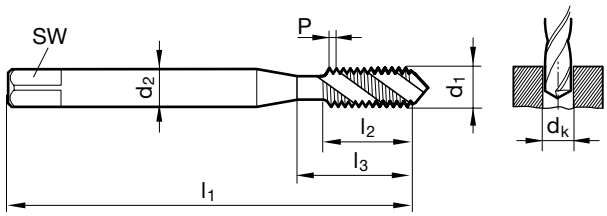
blind holes

steam tempered

external cooling

Article 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.	Availability
	mm	mm		mm	mm	mm	mm		
M 3	0.50	3.500	2.70	2.500	56.00	6.00	18.00	3.000	●
M 4	0.70	4.500	3.40	3.300	63.00	7.50	21.00	4.000	●
M 5	0.80	6.000	4.90	4.200	70.00	8.50	25.00	5.000	●
M 6	1.00	6.000	4.90	5.000	80.00	11.00	30.00	6.000	●
M 8	1.25	8.000	6.20	6.800	90.00	14.00	35.00	8.000	●
M10	1.50	10.000	8.00	8.500	100.00	16.00	39.00	10.000	●

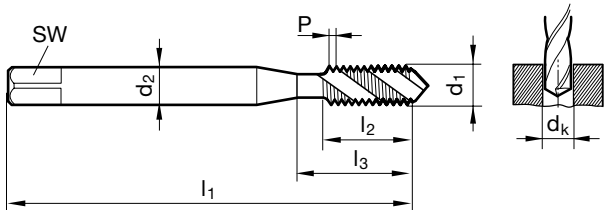
blind holes

TiN-coated

external cooling

Article no.	5722
Standard	DIN 2184-1
Standard	DIN 371 / DIN 376
Tool material	HSS-E-PM
Type	N R50
Form	C
Tolerance	ISO 2 / 6H
Cutting direction	right-hand
Discount group	203

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



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

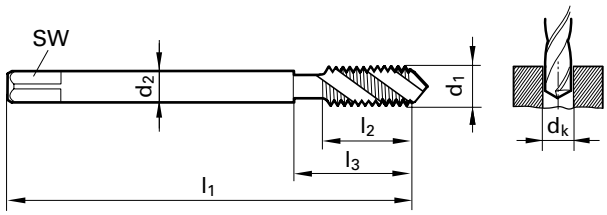
blind holes

TiN-coated

external cooling

Article no.	5718
Standard	
Standard	Gühring standard
Tool material	HSS-E
Type	N R40
Form	C
Tolerance	6HX
Cutting direction	right-hand
Discount group	203

EXTRA LENGTH TAP



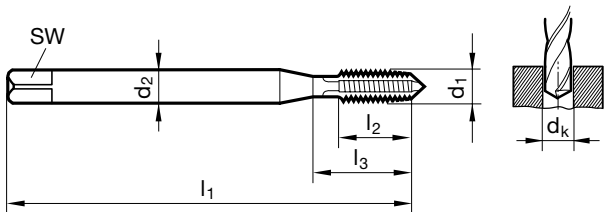
d1	P	d2	SW	dk	l1	l2	l3	Code no.	Availability
	mm	mm		mm	mm	mm	mm		
M 3	0.50	3.500	2.70	2.500	112.00	6.00	18.00	3.000	●
M 4	0.70	2.800	2.10	3.300	112.00	7.50	77.00	4.000	●
M 5	0.80	3.500	2.70	4.200	125.00	8.50	90.00	5.000	●
M 6	1.00	4.500	3.40	5.000	125.00	11.00	90.00	6.000	●
M 8	1.25	6.000	4.90	6.800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

through holes

steam tempered

external cooling

Article no.	**5733**
Standard	**DIN 2184-1**
Standard	**DIN 371**
Tool material	**HSS-E**
Type	**N**
Form	**B**
Tolerance	**ISO 2 / 6H**
Cutting direction	**right-hand**
Discount group	**203**



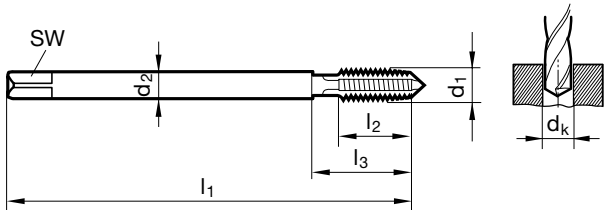
d1	P	d2	SW	dk	l1	l2	l3	Code no.	Availability
	mm	mm		mm	mm	mm	mm		
M 3	0.50	3.500	2.70	2.500	56.00	10.00	18.00	3.000	●
M 4	0.70	4.500	3.40	3.300	63.00	12.00	21.00	4.000	●
M 5	0.80	6.000	4.90	4.200	70.00	14.00	25.00	5.000	●
M 6	1.00	6.000	4.90	5.000	80.00	16.00	30.00	6.000	●
M 8	1.25	8.000	6.20	6.800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

through holes

steam tempered

external cooling

Article no.	**5716**
Standard	**DIN 2184-1**
Standard	**DIN 376**
Tool material	**HSS-E**
Type	**N**
Form	**B**
Tolerance	**ISO 2 / 6H**
Cutting direction	**right-hand**
Discount group	**203**



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

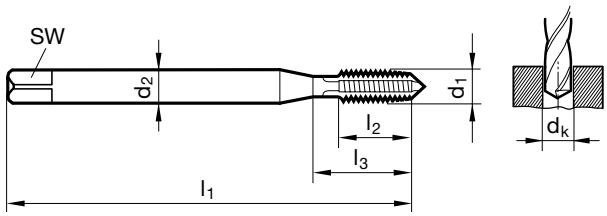
through holes

steam tempered

external cooling

Article 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**

TOLERANCE ISO 3/6G



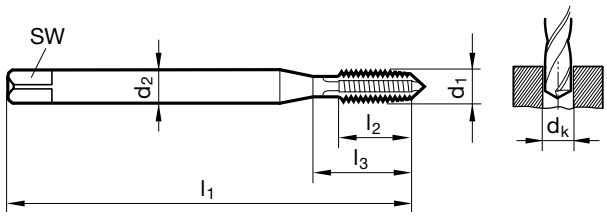
d1	P	d2	SW	dk	l1	l2	l3	Code no.	Availability
	mm	mm		mm	mm	mm	mm		
M 3	0.50	3.500	2.70	2.500	56.00	10.00	18.00	3.000	●
M 4	0.70	4.500	3.40	3.300	63.00	12.00	21.00	4.000	●
M 5	0.80	6.000	4.90	4.200	70.00	14.00	25.00	5.000	●
M 6	1.00	6.000	4.90	5.000	80.00	16.00	30.00	6.000	●
M 8	1.25	8.000	6.20	6.800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

through holes

S TiN-coated

external cooling

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



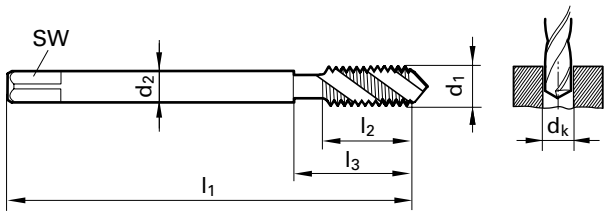
d1	P	d2	SW	dk	l1	l2	l3	Code no.	Availability
	mm	mm		mm	mm	mm	mm		
M 2	0.40	2.800	2.10	1.600	45.00	8.00	13.50	2.000	●
M 3	0.50	3.500	2.70	2.500	56.00	10.00	18.00	3.000	●
M 4	0.70	4.500	3.40	3.300	63.00	12.00	21.00	4.000	●
M 5	0.80	6.000	4.90	4.200	70.00	14.00	25.00	5.000	●
M 6	1.00	6.000	4.90	5.000	80.00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

blind holes

steam tempered

external cooling

Article no.	**5724**
Standard	**DIN 2184-1**
Standard	**DIN 374**
Tool material	**HSS-E**
Type	**N R40**
Form	**C**
Tolerance	**ISO 2 / 6H**
Cutting direction	**right-hand**
Discount group	**203**



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

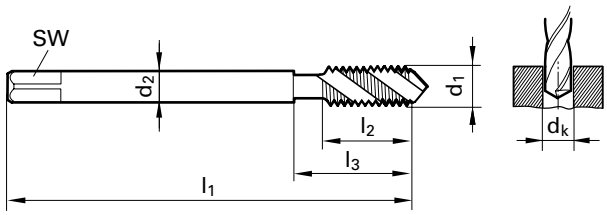
blind holes

TiN-coated

external cooling

Article 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**

HSS-E-PM + TiN FOR MAXIMUM TOOL LIFE



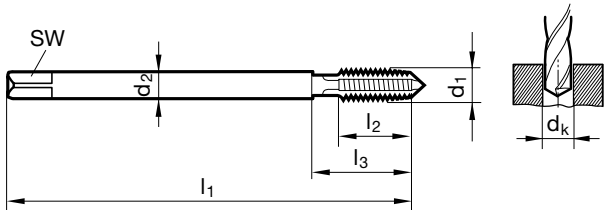
d1 X P	d2	SW	dk	l1	l2	l3	Code no.	Availability
	mm		mm	mm	mm	mm		
M 8 X1	6.000	4.90	7.000	90.00	11.00	35.00	8.005	●
M10 X1	7.000	5.50	9.000	90.00	11.00	35.00	10.005	●
M10 X1.25	7.000	5.50	8.800	100.00	14.00	39.00	10.006	●
M12 X1	9.000	7.00	11.000	100.00	11.00	40.00	12.005	●
M12 X1.25	9.000	7.00	10.800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

through holes

steam tempered

external cooling

Article no.	**5723**
Standard	**DIN 2184-1**
Standard	**DIN 374**
Tool material	**HSS-E**
Type	**N**
Form	**B**
Tolerance	**ISO 2 / 6H**
Cutting direction	**right-hand**
Discount group	**203**



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

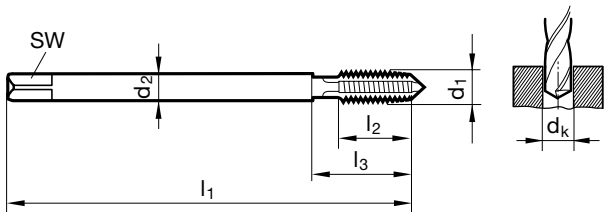
through holes

TiN-coated

external cooling

Article 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**

HSS-E-PM + TIN FOR MAXIMUM TOOL LIFE



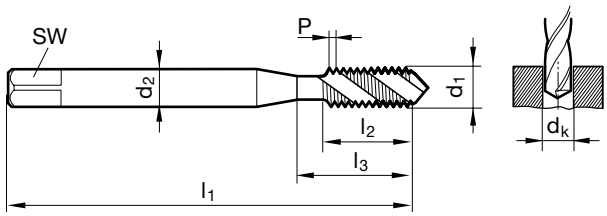
d1 X P	d2	SW	dk	l1	l2	l3	Code no.	Availability
	mm		mm	mm	mm	mm		
M 8 X1	6.000	4.90	7.000	90.00	16.00	35.00	8.005	●
M10 X1	7.000	5.50	9.000	90.00	16.00	35.00	10.005	●
M10 X1.25	7.000	5.50	8.800	100.00	20.00	39.00	10.006	●
M12 X1	9.000	7.00	11.000	100.00	20.00	40.00	12.005	●
M12 X1.25	9.000	7.00	10.800	100.00	20.00	40.00	12.006	●
M12 X1.5	9.000	7.00	10.500	100.00	20.00	40.00	12.007	●
M14 X1	11.000	9.00	13.000	100.00	20.00	40.00	14.005	●
M14 X1.25	11.000	9.00	13.000	100.00	20.00	40.00	14.006	●
M14 X1.5	11.000	9.00	12.500	100.00	20.00	40.00	14.007	●
M16 X1.5	12.000	9.00	14.500	100.00	22.00	44.00	16.007	●
M18 X1.5	14.000	11.00	16.500	110.00	25.00	44.00	18.007	●
M20 X1.5	16.000	12.00	18.500	125.00	25.00	44.00	20.007	●
M22 X1.5	18.000	14.50	20.500	125.00	25.00	44.00	22.007	●
M24 X1.5	18.000	14.50	22.500	140.00	28.00	48.00	24.007	●
M24 X2	18.000	14.50	22.000	140.00	28.00	48.00	24.008	●

blind holes

steam tempered

external cooling

Article no.	**5726**
Standard	**DIN 2184-1**
Standard	**~ DIN 371 / ~ DIN 376**
Tool material	**HSS-E**
Type	**N R40**
Form	**C**
Tolerance	**2B**
Cutting direction	**right-hand**
Discount group	**203**



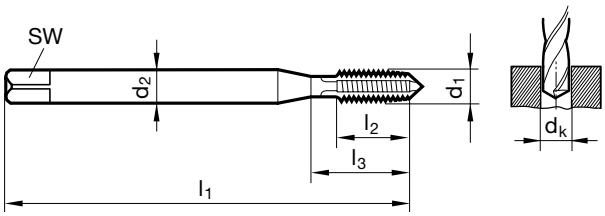
d1 - P	d2	SW	dk	l1	l2	l3	Code no.	Availability
	mm		mm	mm	mm	mm		
NO. 4 -40	3.500	2.70	2.350	56.00	7.00	18.00	2.845	●
NO. 6 -32	4.000	3.00	2.850	56.00	8.00	20.00	3.505	●
NO. 8 -32	4.500	3.40	3.500	63.00	8.00	21.00	4.166	●
NO.10 -24	6.000	4.90	3.900	70.00	11.00	25.00	4.826	●
1/4 -20	7.000	5.50	5.100	80.00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

through holes

steam tempered

external cooling

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



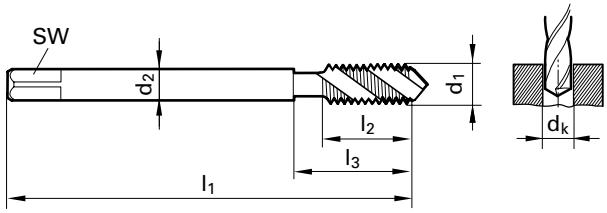
d1 - P	d2	SW	dk	l1	l2	l3	Code no.	Availability
	mm		mm	mm	mm	mm		
NO. 4 -40	3.500	2.70	2.350	56.00	11.00	18.00	2.845	●
NO. 6 -32	4.000	3.00	2.850	56.00	12.00	20.00	3.505	●
NO. 8 -32	4.500	3.40	3.500	63.00	13.00	21.00	4.166	●
NO.10 -24	6.000	4.90	3.900	70.00	14.00	25.00	4.826	●
1/4 -20	7.000	5.50	5.100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

blind holes

steam tempered

external cooling

Article no.	**5728**
Standard	**DIN 2184-1**
Standard	**~ DIN 374**
Tool material	**HSS-E**
Type	**N R40**
Form	**C**
Tolerance	**2B**
Cutting direction	**right-hand**
Discount group	**203**



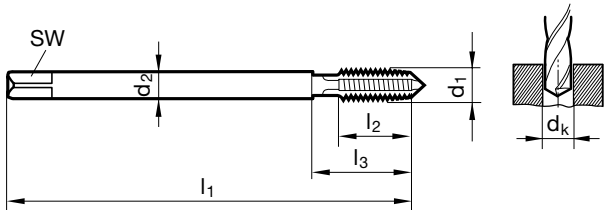
d1 - P	d2	SW	dk	l1	l2	l3	Code no.	Availability
	mm		mm	mm	mm	mm		
NO. 4 -48	2.200		2.400	56.00	6.00	18.00	2.845	●
NO. 6 -40	2.500	2.10	2.950	56.00	6.50	20.00	3.505	●
NO.10 -32	3.500	2.70	4.100	70.00	8.50	25.00	4.826	●
1/4 -28	4.500	3.40	5.500	80.00	9.00	30.00	6.350	●
3/8 -24	7.000	5.50	8.500	90.00	11.00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

through holes

steam tempered

external cooling

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



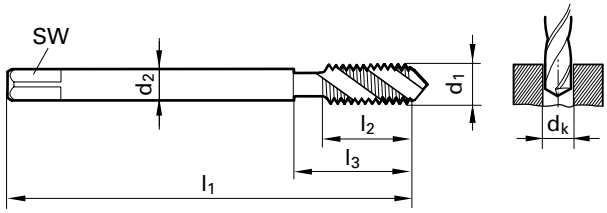
d1 - P	d2	SW	dk	l1	l2	l3	Code no.	Availability
	mm		mm	mm	mm	mm		
NO. 4 -48	2.200		2.400	56.00	10.00	18.00	2.845	●
NO. 6 -40	2.500	2.10	2.950	56.00	11.00	20.00	3.505	●
NO.10 -32	3.500	2.70	4.100	70.00	14.00	25.00	4.826	●
1/4 -28	4.500	3.40	5.500	80.00	16.00	30.00	6.350	●
3/8 -24	7.000	5.50	8.500	90.00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

blind holes

steam tempered

external cooling

Article no.	**5732**
Standard	**DIN 2184-1**
Standard	**DIN 5156**
Tool material	**HSS-E**
Type	**N R40**
Form	**C**
Tolerance	**-**
Cutting direction	**right-hand**
Discount group	**203**



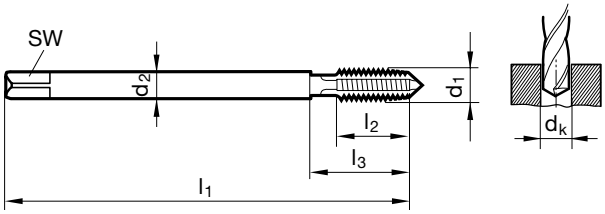
d1	P	d2	SW	dk	l1	l2	l3	Code no.	Availability
	G/inch	mm		mm	mm	mm	mm		
G 1/8	28.00	7.00	5.50	8.800	90.00	11.00	35.00	9.728	●
G 1/4	19.00	11.00	9.00	11.800	100.00	14.00	40.00	13.157	●
G 3/8	19.00	12.00	9.00	15.250	100.00	14.00	44.00	16.662	●
G 1/2	14.00	16.00	12.00	19.000	125.00	18.00	44.00	20.955	●
G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

through holes

steam tempered

external cooling

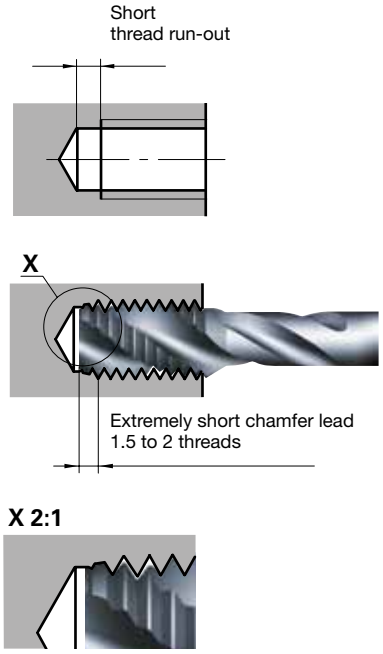
Article no.	**5731**
Standard	**DIN 2184-1**
Standard	**DIN 5156**
Tool material	**HSS-E**
Type	**N**
Form	**B**
Tolerance	**-**
Cutting direction	**right-hand**
Discount group	**203**



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

Why is Gühring increasingly offering Form E taps?

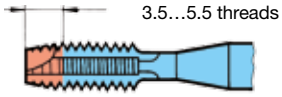
In addition to the conventional Form B and C for machine taps we are increasingly including Form E tools in our standard range. Thus, we are taking into account the increasing demand for taps with which threads can be produced as close as possible to the bottom of the bore when machining blind holes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



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

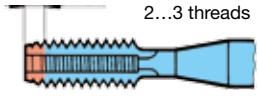
Conventional Forms B and C for machine taps

Form B



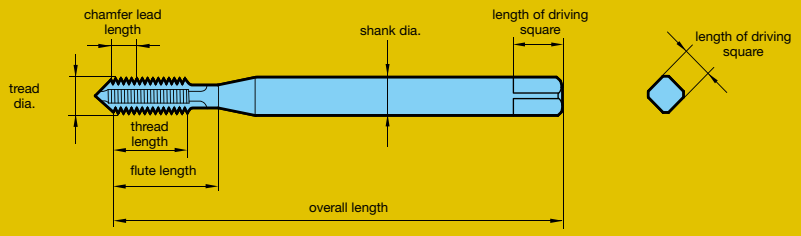
medium, 3.5 - 5.5 threads,
with spiral point,
for through holes

Form C



short, 2 - 3 threads
for blind holes

Definitions and angles

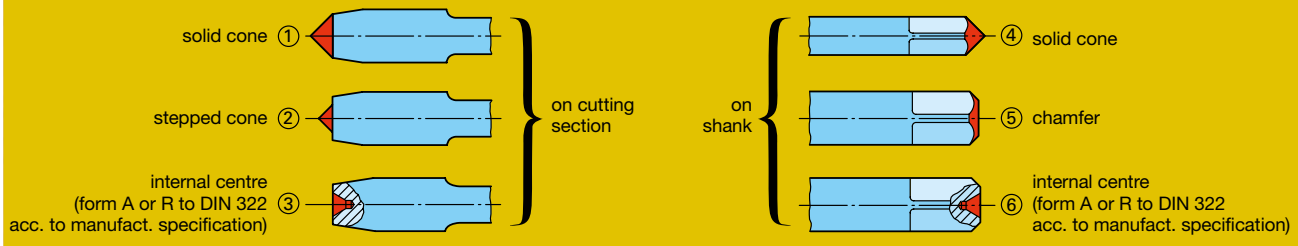


Flute forms

straight fluted, form B
with spiral point

right-hand helix angle
40°

Types of centres



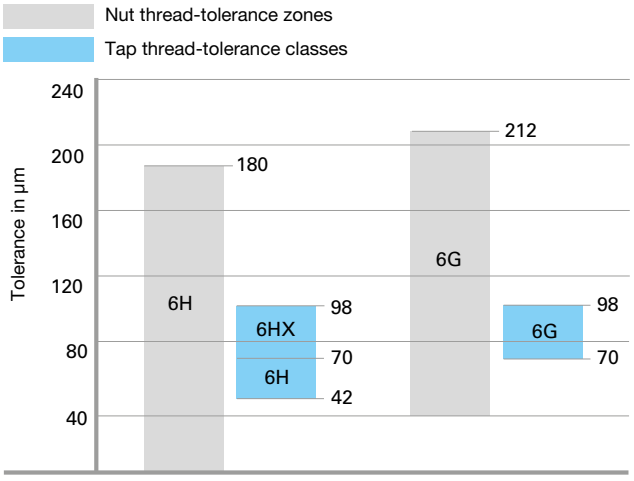
Thread dia. range mm	Centre on cutting section		Centre on shank
	with chamfer forms C, E	with chamfer form B	
≤ 4,2	①	①	④⑤⑥
> 4,2 … 5,6	①②	①	④⑤⑥
> 5,6 … 10,0	①②③	①②③	④⑤⑥
> 10,0	③	③	⑥

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

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

Available in all essential tolerances

Tolerance zone / tolerance class allocation



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

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

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

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

Tap size metric	Tap size inch	Tapping size hole Ø mm	Recommended core drills
M 2		1.600	
	NO. 4 -40	2.350	 carbide micro-precision drill, 4 x D, without IC, Article no. 6400
	NO. 4 -48	2.400	
			 carbide micro-precision drill, 5 x D, with IC, Article no. 6405
M 3		2.500	
	NO. 6 -32	2.850	 GU 500, jobber drill, HSCO, Article no. 5523
	NO. 6 -40	2.950	
M 4		3.300	
	NO. 8 -32	3.500	
	NO.10 -24	3.900	
	NO.10 -32	4.100	
M 5		4.200	
M 6		5.000	
	1/4 -20	5.100	
M 6 X 0.75		5.200	
	1/4 -28	5.500	
	5/16-18	6.600	
M 8		6.800	 RT 100 U, 5 x D, with IC, Article no. 5511
M 8 X1		7.000	
	3/8 -16	8.000	 RT 100 U, 5 x D, without IC, Article no. 5515
M10	3/8 -24	8.500	
M10 X1.25	G 1/8	8.800	 GU 500, jobber drill, HSCO, Article 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, Article no. 5511
M 18		15.500	
M18 X1.5	3/4 -10	16.500	 RT 100 U, 5 x D, without IC, Article no. 5515
M20		17.500	
M20 X1.5		18.500	 HT 800 holder 5 x D and insert, Article 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, Article no. 4108 + 4112
	G 3/4	24.500	
	G1	30.750	

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Gühring KG

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

T +49 74 31 17-0
F +49 74 31 17-21279

info@guehring.de
www.guehring.de

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