



TAPS
TAPS

METRIC GUN NOSE TAPS THROUGH HOLES



Through hole

Guhring no.
Standard
Tool material
Surface
Cutting direction
Tolerance
Application
Cutting speed m/min

803	5736	789
DIN 371		
HSS-E	HSS-E-PM	HSS-E
○	●	○
rh	rh	left hand
ISO 2 / 6H		
10-15	10-15	10-15

d1	P	d2	SW	dk	l1	l2
mm	mm	mm	mm	mm	mm	mm
M 1.4	0.30	2.50	2.10	1.10	40.00	7.00
M 1.6	0.35	2.50	2.10	1.25	40.00	8.00
M 2	0.40	2.80	2.10	1.60	45.00	8.00
M 2.5	0.45	2.80	2.10	2.05	50.00	9.00
M 3	0.50	3.50	2.70	2.50	56.00	10.00

AVAILABILITY

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Universal
 General Steel
 Tool Steel
 Stainless Steel
 Aluminium
 Cast Materials
 Bright
 Steam Tempered
 Nitrided Lands
 S-Coated (TiN)
 A-Coated (TiAlN)
 C-Coated (TiCN)
 F-Coated (FIRE)

804	57	2876	877	805	807
DIN 371					
HSS-E	HSS-E-PM	HSS-E	HSS-E-PM	HSS-E	
rh	rh	rh	rh	rh	rh
ISO 2 / 6H		ISO 2 / 6H			
8-12	8-12	10-15	6-12	10-15	10-15

AVAILABILITY

⋮			⋮	⋮	
⋮	•	•	⋮	⋮	•

- Universal
- General Steel
- Tool Steel
- Stainless Steel
- Aluminium
- Cast Materials
- Bright
- Steam Tempered
- Nitrided Lands
- S-Coated (TiN)
- A-Coated (TiAlN)
- C-Coated (TiCN)
- F-Coated (FIRE)

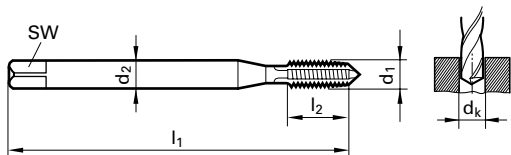
METRIC GUN NOSE TAPS THROUGH HOLES



Through hole

- Guhring no.
- Standard
- Tool material
- Surface
- Cutting direction
- Tolerance
- Application
- Cutting speed m/min

5733	5736	789
DIN 371		
HSS-E	HSS-E-PM	HSS-E
●	● S	○
rh	rh	left hand
ISO 2 / 6H		
○	○	○
10-15	10-15	10-15



d1	P	d2	SW	dk	l1	l2
	mm	mm	mm	mm	mm	mm
M 4	0.70	4.50	3.40	3.30	63.00	13.00
M 5	0.80	6.00	4.90	4.20	70.00	16.00
M 6	1.00	6.00	4.90	5.00	80.00	19.00
M 8	1.25	8.00	6.20	6.80	90.00	22.00
M 10	1.50	10.00	8.00	8.50	100.00	24.00

AVAILABILITY

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○ Universal
 ○ General Steel
 ○ Tool Steel
 ○ Stainless Steel
 ○ Aluminium
 ○ Cast Materials
○ Bright
 ● Steam Tempered
 ● Nitrided Lands
 ●**S** S-Coated (TiN)
 ●**A** A-Coated (TiAlN)
 ●**C** C-Coated (TiCN)
 ●**F** F-Coated (FIRE)

5558	57	5559	5561	5557	5550
DIN 371					
HSS-E	HSS-E-PM			HSS-E	
rh	rh	rh	rh	rh	rh
ISO 2 / 6H					
8-12	8-12	6-12	10-15	10-15	10-15

AVAILABILITY

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- Universal
- General Steel
- Tool Steel
- Stainless Steel
- Aluminium
- Cast Materials
- Bright
- Steam Tempered
- Nitrided Lands
- S-Coated (TiN)
- A-Coated (TiAlN)
- C-Coated (TiCN)
- F-Coated (FIRE)

METRIC GUN NOSE TAPS THROUGH HOLES

Through hole

Guhring no.
Standard
Tool material
Surface
Cutting direction
Tolerance
Application
Cutting speed m/min
















5716	5736	790
DIN 376		
HSS-E	HSS-E-PM	HSS-E
●	S	○
rh		left hand
ISO 2 / 6H		
10-15	10-15	10-15

d1	P	d2	SW	dk	l1	l2
	mm	mm	mm	mm	mm	mm
M 6	1.00	4.50	3.40	5.00	80.00	16.00
M 7	1.00	5.50	4.30	6.00	80.00	16.00
M 8	1.25	6.00	4.90	6.80	90.00	18.00
M 10	1.50	7.00	5.50	8.50	100.00	20.00
M 12	1.75	9.00	7.00	10.20	110.00	24.00
M 14	2.00	11.00	9.00	12.00	110.00	26.00
M 16	2.00	12.00	9.00	14.00	110.00	26.00
M 18	2.50	14.00	11.00	15.50	125.00	30.00
M 20	2.50	16.00	12.00	17.50	140.00	32.00
M 22	2.50	18.00	14.50	19.50	140.00	32.00
M 24	3.00	18.00	14.50	21.00	160.00	36.00
M 30	3.50	22.00	18.00	26.50	180.00	40.00
M 36	4.00	28.00	22.00	32.00	200.00	50.00

AVAILABILITY














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Universal
 General Steel
 Tool Steel
 Stainless Steel
 Aluminium
 Cast Materials
 Bright
 Steam Tempered
 Nitrided Lands
 S-Coated (TiN)
 A-Coated (TiAlN)
 C-Coated (TiCN)
 F-Coated (FIRE)

816	58	879	2877	817
DIN 376				
HSS-E	HSS-E-PM		HSS-E	
				
rh	rh	rh	rh	rh
ISO 2 / 6H				
				
8-12	8-12	6-12	10-15	10-15
				

AVAILABILITY







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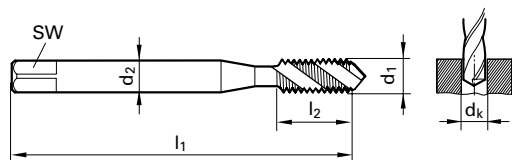
 Universal	 General Steel	 Tool Steel	 Stainless Steel	 Aluminium	 Cast Materials	
 Bright	 Steam Tempered	 Nitrided Lands	 S-Coated (TiN)	 A-Coated (TiAlN)	 C-Coated (TiCN)	 F-Coated (FIRE)

METRIC SPIRAL TAPS THROUGH & BLIND HOLES


**Through hole and
blind hole**

Guhring no.
Standard
Tool material
Surface
Cutting direction
Tolerance
Application
Cutting speed m/min






810	5722	786
DIN 371		
HSS-E	HSS-E-PM	HSS-E
○	⊙	○
rh	rh	left hand
ISO 2 / 6H		
		
10-15	10-15	10-15
		



d1	P	d2	SW	dk	l1	l2
	mm	mm	mm	mm	mm	mm
M 2	0.40	2.80	2.10	1.60	45.00	8.00
M 2.5	0.45	2.80	2.10	2.05	50.00	9.00
M 3	0.50	3.50	2.70	2.50	56.00	10.00















AVAILABILITY

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	50° Helix for maximum tool life	

811	909	59	812	889
DIN 371				
HSS-E-PM			HSS-E	
○	○	● ^S	○	○
rh	rh	rh	rh	rh
ISO 2 / 6H				
○	○	○	○	○
8-12	6-12	6-12	10-15	10-15
				

AVAILABILITY

⋮	•	•	⋮	⋮

  Universal
  General Steel
  Tool Steel
  Stainless Steel
  Aluminium
  Cast Materials
 Bright
  Steam Tempered
  Nitrided Lands
  ^S S-Coated (TiN)
  ^A A-Coated (TiAlN)
  ^C C-Coated (TiCN)
  ^F F-Coated (FIRE)

**METRIC SPIRAL TAPS
THROUGH & BLIND HOLES**

**Through hole and
blind hole**
















Guhring no.	
Standard	
Tool material	
Surface	
Cutting direction	
Tolerance	
Application	
Cutting speed m/min	

5734	5722	786
DIN 371		
HSS-E	HSS-E-PM	HSS-E
rh	rh	left hand
ISO 2 / 6H		
10-15	10-15	10-15

d1	P	d2	SW	dk	l1	l2
mm	mm	mm	mm	mm	mm	mm
M 4	0.70	4.50	3.40	3.30	63.00	7.50
M 5	0.80	6.00	4.90	4.20	70.00	8.50
M 6	1.00	6.00	4.90	5.00	80.00	11.00
M 8	1.25	8.00	6.20	6.80	90.00	14.00
M10	1.50	10.00	8.00	8.50	100.00	16.00















AVAILABILITY

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	50° Helix for maximum tool life	

5552	5553	59	5551	5555
DIN 371				
HSS-E		HSS-E-PM	HSS-E	
				
rh	rh	rh	rh	rh
ISO 2 / 6H				
				
8-12	6-12	6-12	10-15	10-15
				

AVAILABILITY

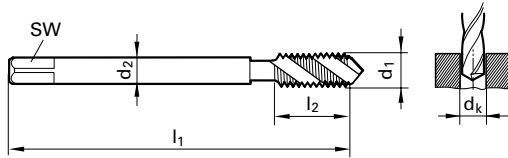
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|---|--|--|---|--|---|---|
|   Universal |  General Steel |  Tool Steel |  Stainless Steel |  Aluminium |  Cast Materials | |
|  Bright |  Steam Tempered |  Nitrided Lands |  S-Coated (TiN) |  A-Coated (TiAlN) |  C-Coated (TiCN) |  F-Coated (FIRE) |

METRIC SPIRAL TAPS THROUGH & BLIND HOLES

 **Through hole and
blind hole**

Guhring no.	
Standard	
Tool material	
Surface	
Cutting direction	
Tolerance	
Application	
Cutting speed m/min	










5717	5722	787
DIN 376		
HSS-E	HSS-E-PM	HSS-E
Bright	S	Bright
rh	rh	left hand
ISO 2 / 6H		
Universal	General Steel	General Steel
10-15	10-15	10-15
		








AVAILABILITY




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50° Helix
for maximum
tool life

d1	P	d2	SW	dk	l1	l2
mm	mm	mm	mm	mm	mm	mm
M12	1.75	9.00	7.00	10.20	110.00	18.50
M14	2.00	11.00	9.00	12.00	110.00	20.00
M16	2.00	12.00	9.00	14.00	110.00	20.00
M18	2.50	14.00	11.00	15.50	125.00	25.00
M20	2.50	16.00	12.00	17.50	140.00	25.00
M22	2.50	18.00	14.50	19.50	140.00	27.00
M24	3.00	18.00	14.50	21.00	160.00	30.00
M30	3.50	22.00	18.00	26.50	180.00	35.00

  Universal
  General Steel
  Tool Steel
  Stainless Steel
  Aluminium
  Cast Materials

 Bright
  Steam Tempered
  Nitrided Lands
  S-Coated (TiN)
  A-Coated (TiAlN)
  C-Coated (TiCN)
  F-Coated (FIRE)

823	910	60	890	824
DIN 376				
HSS-E	HSS-E-PM		HSS-E	
○	○	● ^S	○	○
rh	rh	rh	rh	rh
ISO 2 / 6H				
○	○	○	○	○
8-12	6-12	6-12	10-15	10-15
				

AVAILABILITY

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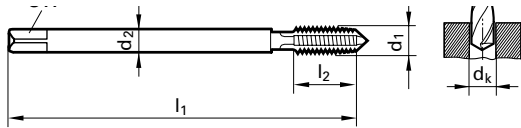
METRIC FINE GUN NOSE TAPS THROUGH HOLES



Through hole

- Guhring no.**
- Standard**
- Tool material**
- Surface**
- Cutting direction**
- Tolerance**
- Application**
- Cutting speed m/min**

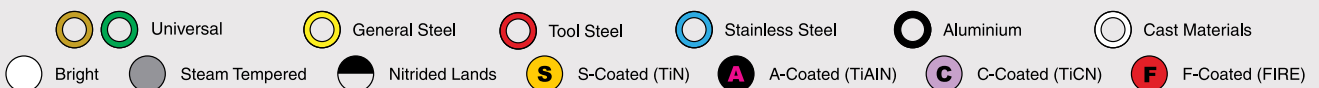
827
DIN 374
HSS-E
○
rh
ISO 2 / 6H
○
10-15



AVAILABILITY

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d1 X P	Code no.	d2	SW	dk	l1	l2
	mm	mm	mm	mm	mm	mm
M3X0.35	3.002	2.20		2.65	56.00	7.00
M4 X0.50	4.003	2.80	2.10	3.50	63.00	8.00
M5 X0.50	5.003	3.50	2.70	4.50	70.00	10.00
M6 X0.50	6.003	4.50	3.40	5.50	80.00	13.00
M6 X0.75	6.004	4.50	3.40	5.25	80.00	13.00
M8 X0.50	8.003	6.00	4.90	7.50	80.00	14.00
M8 X0.75	8.004	6.00	4.90	7.25	80.00	14.00
M8 X1	8.005	6.00	4.90	7.00	90.00	18.00
M10 X0.75	10.004	7.00	5.50	9.25	90.00	18.00
M10 X1	10.005	7.00	5.50	9.00	90.00	18.00
M10 X1.25	10.006	7.00	5.50	8.80	100.00	20.00
M12 X1	12.005	9.00	7.00	11.00	100.00	20.00
M12 X1.25	12.006	9.00	7.00	10.80	100.00	20.00
M12 X1.50	12.007	9.00	7.00	10.50	100.00	20.00
M14 X1	14.005	11.00	9.00	13.00	100.00	20.00
M14 X1.25	14.006	11.00	9.00	12.80	100.00	20.00
M14 X 1.50	14.007	11.00	9.00	12.50	100.00	20.00
M16 X1	16.005	12.00	9.00	15.00	100.00	22.00
M16 X1.50	16.007	12.00	9.00	14.50	100.00	22.00
M18 X1	18.005	14.00	11.00	17.00	110.00	25.00
M18 X1.50	18.007	14.00	11.00	16.50	110.00	25.00
M20 X1	20.005	16.00	12.00	19.00	125.00	25.00
M20 X1.50	20.007	16.00	12.00	18.50	125.00	25.00
M20 X2	20.008	16.00	12.00	18.00	140.00	32.00
M22 X1.50	22.007	18.00	14.50	20.50	125.00	25.00
M20 x2	20.008	16.00	12.00	18.00	140.00	32.00
M24 X1	24.005	18.00	14.50	23.00	140.00	28.00
M24 X1.50	24.007	18.00	14.50	22.50	140.00	28.00
M24 X2	24.008	18.00	14.50	22.00	140.00	28.00
M30 X1.50	30.007	22.00	18.00	28.50	150.00	28.00
M32 X1.50	32.007	22.00	18.00	30.50	150.00	28.00
M34 X1.50	34.007	28.00	22.00	32.50	170.00	30.00



METRIC FINE SPIRAL TAPS THROUGH & BLIND HOLES



Through hole and blind hole

Guhring no.
Standard
Tool material
Surface
Cutting direction
Tolerance
Application
Cutting Speed m/min

834
DIN 374
HSS-E
○
RH
ISO 2 / 6H
⊙
10-15

d1 X P	Code no.	d2	SW	dk	l1	l2
	mm	mm	mm	mm	mm	mm
M3 X0.35	3.002	2.20		2.65	56.00	4.00
M4 X0.50	4.003	2.80	2.10	3.50	63.00	5.00
M5 X0.50	5.003	3.50	2.70	4.50	70.00	5.00
M6X 0.50	6.003	4.50	3.40	5.50	80.00	5.00
M6 X0.75	6.004	4.50	3.40	5.25	80.00	8.00
M8 X0.75	8.004	6.00	4.90	7.25	80.00	8.00
M8 X1	8.005	6.00	4.90	7.00	90.00	11.00
M10 X1	10.005	7.00	5.50	9.00	90.00	11.00
M10 X1.25	10.006	7.00	5.50	8.80	100.00	14.00
M12 X1	12.005	9.00	7.00	11.00	100.00	11.00
M12 X1.25	12.006	9.00	7.00	10.80	100.00	15.00
M12 X1.50	12.007	9.00	7.00	10.50	100.00	15.00
M14 X1	14.005	11.00	9.00	13.00	100.00	11.00
M14 X1.25	14.006	11.00	9.00	12.80	100.00	15.00
M14 X1.50	14.007	11.00	9.00	12.50	100.00	15.00
M16 X1	16.005	12.00	9.00	15.00	100.00	11.00
M16 X1.50	16.007	12.00	9.00	14.50	100.00	15.00
M18 X1	18.005	14.00	11.00	17.00	110.00	12.00
M18 X1.50	18.007	14.00	11.00	16.50	110.00	16.00
M20 X1.50	20.007	16.00	12.00	18.50	125.00	16.00
M22 X1.50	22.007	18.00	14.50	20.50	125.00	16.00
M24 X1.50	24.007	18.00	14.50	22.50	140.00	16.00
M24 X2	24.008	18.00	14.50	22.00	140.00	22.00
M30 X1.50	30.007	22.00	18.00	28.50	150.00	20.00

AVAILABILITY	
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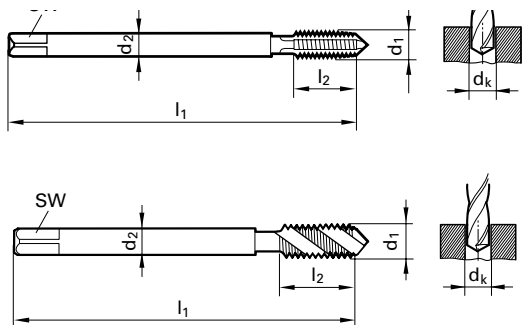
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Bright	Steam Tempered	Nitrided Lands	S-Coated (TiN)	A-Coated (TiAlN)	C-Coated (TiCN)	F-Coated (FIRE)

METRIC RECOIL TAPS THROUGH & BLIND HOLES



Guhring no.
Standard
Tool material
Surface
Cutting direction
Tolerance
Application
Cutting Speed m/min

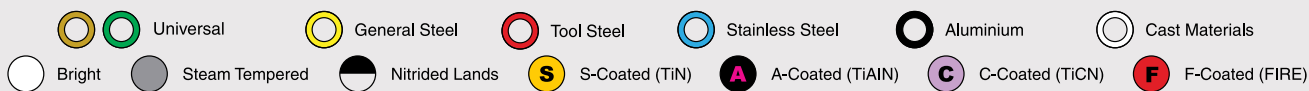
1010	1011
DIN 40435	
HSS-E	
S	S
RH	RH
6H	6H
10-15	10-15



d1	P	d2	SW	dk	l1	l2
	mm	mm	mm	mm	mm	mm
M 4	0.70	6.00	4.90	4.20	70.00	12.00
M 5	0.80	6.00	4.90	5.25	80.00	14.00
M 6	1.00	8.00	6.20	6.30	90.00	17.00
M 8	1.25	10.00	8.00	8.40	100.00	20.00
M10	1.50	9.00	7.00	10.50	100.00	20.00
M12	1.75	11.00	9.00	12.50	110.00	30.00
M14	2.00	12.00	9.00	14.50	110.00	26.00
M16	2.00	14.00	11.00	16.50	125.00	33.00
M 4	0.70	6.00	4.90	4.20	70.00	7.50
M 5	0.80	6.00	4.90	5.25	80.00	8.50
M 6	1.00	8.00	6.20	6.30	90.00	11.00
M 8	1.25	10.00	8.00	8.40	100.00	14.00
M10	1.50	9.00	7.00	10.50	100.00	16.00
M12	1.75	11.00	9.00	12.50	110.00	18.50
M14	2.00	12.00	9.00	14.50	110.00	20.00
M16	2.00	14.00	11.00	16.50	125.00	20.00

AVAILABILITY

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HIGH PERFORMANCE TAPS

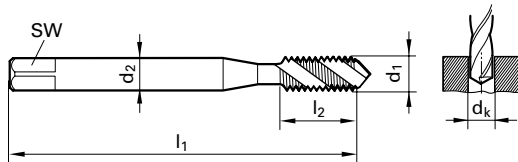
METRIC TAPS SYNCHRO TAPPING

ALL MATERIALS






 Through hole and blind hole

Guhring no.
Standard
Tool material
Surface
Cutting direction
Tolerance
Application

Cutting speed m/min



d1	P	d2	SW	dk	l1	l2
	mm	mm	mm	mm	mm	mm
M 3	0.50	3.500	2.70	2.500	56.00	2.50
M 4	0.70	4.500	3.40	3.300	63.00	3.50
M 5	0.80	6.000	4.90	4.200	70.00	4.00
M 6	1.00	6.000	4.90	5.000	80.00	5.00
M 8	1.25	8.000	6.20	6.800	90.00	6.30
M10	1.50	10.000	8.00	8.500	100.00	7.50
M12	1.75	9.000	7.00	10.200	110.00	8.80
M14	2.00	11.000	9.00	12.000	110.00	10.00
M16	2.00	12.000	9.00	14.000	110.00	10.00
M20	2.50	16.000	12.00	17.500	140.00	12.50

761	763
DIN 371	DIN 376
HSS-E-PM	HSS-E-PM
	
rh	
6HX	
	
10-25	
	

AVAILABILITY

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**METRIC CARBIDE TAPS
HARDENED MATERIALS <62 HRC**

 **Through hole and
blind hole**

Guhring no.

Standard

Tool material

Surface

Cutting direction

Tolerance

Application

Cutting speed m/min

2944

Guhring std.

Solid carbide

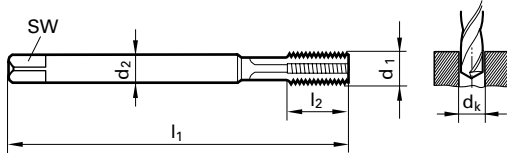
C

rh

ISO 2 / 6H

Hardened Materials

2-4





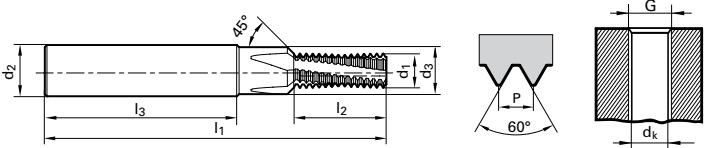
AVAILABILITY

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d1	P	d2	SW	dk	l1	l2
	mm	mm	mm	mm	mm	mm
M 3	0.50	3.500	2.70	2.600	56.00	12.00
M 4	0.70	4.500	3.40	3.400	63.00	14.00
M 5	0.80	6.000	4.90	4.300	70.00	17.00
M 6	1.00	6.000	4.90	5.100	80.00	20.00
M 8	1.25	8.000	6.20	6.900	90.00	20.00
M10	1.50	10.000	8.00	8.600	100.00	24.00
M12	1.75	12.000	9.00	10.400	110.00	28.00

METRIC THREAD MILLING CUTTERS - CARBIDE

<p>Guhring no. 4133</p> <p>Standard Guhring std.</p> <p>Tool material Solid carbide</p> <p>Surface C</p> <p>Cutting direction rh</p> <p>Tolerance</p> <p>Application</p> <p>Cutting speed m/min 50-100</p>	<p style="text-align: center;">4133</p> <p style="text-align: center;">Guhring std.</p> <p style="text-align: center;">Solid carbide</p> <p style="text-align: center;">C</p> <p style="text-align: center;">rh</p> <p style="text-align: center;"></p> <p style="text-align: center;">50-100</p> <p style="text-align: center;"></p>
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Thread	Code no.	P	d1	d2	dk	l1	l2	z
	mm	mm	mm	mm	mm	mm	mm	
M 6	6.000	1.00	4.80	6.00	5.00	54.00	13.50	3
M 8	8.000	1.25	6.40	8.00	6.80	62.00	18.10	3
M10	10.000	1.50	7.95	10.00	8.50	74.00	21.80	3
M12	12.000	1.75	9.95	10.00	10.20	74.00	25.40	4
M14	14.000	2.00	11.20	12.00	12.00	90.00	31.00	4
M16	16.000	2.00	12.80	14.00	14.00	90.00	35.00	4
M20	20.000	2.50	14.95	16.00	17.50	102.00	41.30	4

AVAILABILITY

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Standard	Type	Tool illustration	Tool material	Surface	Thread length	Sizes	Guhring no.
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Thread milling cutters for UNC-threads

Guhring std.	TM SP		Solid Carbide	C	2 x D	10-24 - 1-8	4128
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Thread milling cutters for UNF-threads

Guhring std.	TM SP		Solid Carbide	C	2 x D	10-32 - 1-12	4129
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Thread milling cutters for NPT-threads

Guhring std.	TM SP		Solid Carbide	C		1/16 - 1/2	4130
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Thread milling cutters for BSP-threads

Guhring std.	TM SP		Solid Carbide	C	2 x D	G 1/8 - G 3/8	3748
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** Other thread milling cutters are available on request.

  Universal	 General Steel	 Tool Steel	 Stainless Steel	 Aluminium	 Cast Materials	
 Bright	 Steam Tempered	 Nitrided Lands	 S-Coated (TiN)	 A-Coated (TiAlN)	 C-Coated (TiCN)	 F-Coated (FIRE)

UNF GUN NOSE TAPS THROUGH HOLES



Through hole

Guhring no.
Standard
Tool material
Surface
Cutting direction
Tolerance
Application
Cutting speed m/min

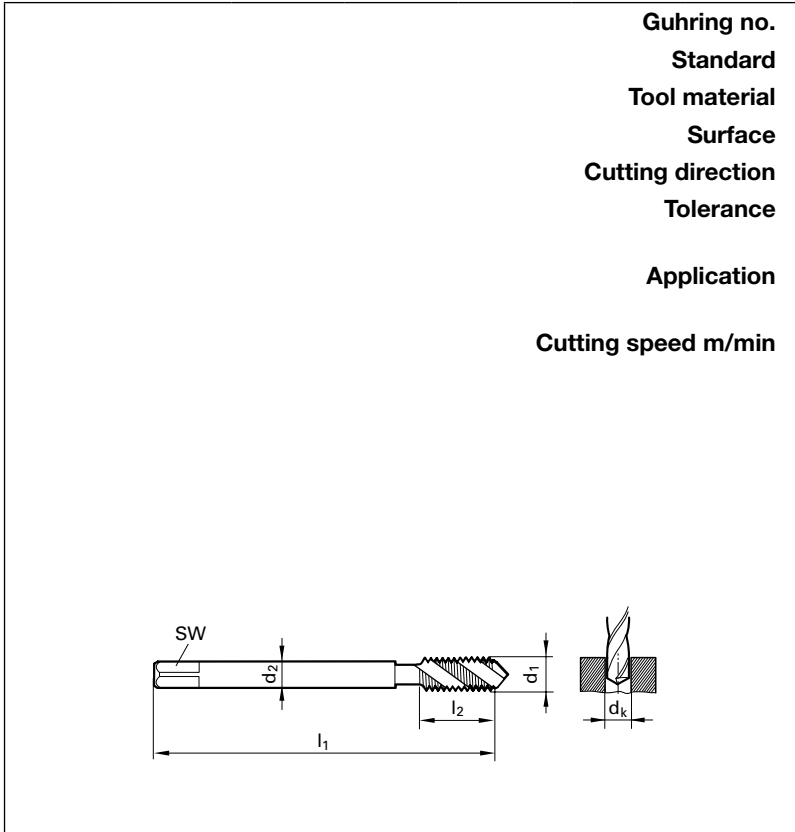
5727	908	2874
DIN 374		
HSS-E		
rh	rh	rh
2B		
10-15	10-15	6-12

d1 X P	Code no.	d2	SW	dk	l1	l2
inch	mm	mm	mm	mm	mm	mm
No. 4-48	2.845	2.20		2.40	56.00	10.00
No. 6-40	3.505	2.50	2.10	2.95	56.00	11.00
No. 8-36	4.166	2.80	2.10	3.50	63.00	12.00
No.10-32	4.826	3.50	2.70	4.10	70.00	14.00
1/4-28	6.350	4.50	3.40	5.50	80.00	16.00
5/16-24	7.938	6.00	4.90	6.90	90.00	18.00
3/8-24	9.525	7.00	5.50	8.50	90.00	18.00
7/16-20	11.113	8.00	6.20	9.90	100.00	22.00
1/2-20	12.700	9.00	7.00	11.50	100.00	20.00
9/16-18	14.288	11.00	9.00	12.90	100.00	22.00
5/8-18	15.875	12.00	9.00	14.50	100.00	22.00
3/4-16	19.050	14.00	11.00	17.50	110.00	25.00
7/8-14	22.225	18.00	14.50	20.45	125.00	25.00
1-12	25.400	18.00	14.50	23.25	140.00	28.00
1 1/8-12	28.575	22.00	18.00	26.50	150.00	28.00
1 1/4-12	31.750	22.00	18.00	29.50	150.00	28.00
1 1/2-12	38.100	28.00	22.00	36.00	170.00	30.00

AVAILABILITY

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UNF SPIRAL TAPS THROUGH & BLIND HOLES



5728	911	1991
DIN 374		
HSS-E		
rh	rh	rh
2B		
10-15	10-15	6-12

d1 X P	Code no.	d2	SW	dk	l1	l2
inch	mm	mm	mm	mm	mm	mm
No. 4-48	2.845	2.20		2.40	56.00	6.00
No. 6-40	3.505	2.50	2.10	2.95	56.00	11.00
No. 8-36	4.166	2.80	2.10	3.50	63.00	10.00
No. 10-32	4.826	3.50	2.70	4.10	70.00	12.00
1/4-28	6.350	4.50	3.40	5.50	80.00	14.00
5/16-24	7.938	6.00	4.90	6.90	90.00	18.00
3/8-24	9.525	7.00	5.50	8.50	90.00	18.00
7/16-20	11.113	8.00	6.20	9.90	90.00	18.00
1/2-20	12.700	9.00	7.00	11.50	100.00	20.00
9/16-18	14.288	11.00	9.00	12.90	100.00	22.00
5/8-18	15.875	12.00	9.00	14.50	100.00	22.00
3/4-16	19.050	14.00	11.00	17.50	110.00	25.00
7/8-14	22.225	18.00	14.50	20.40	125.00	25.00

AVAILABILITY

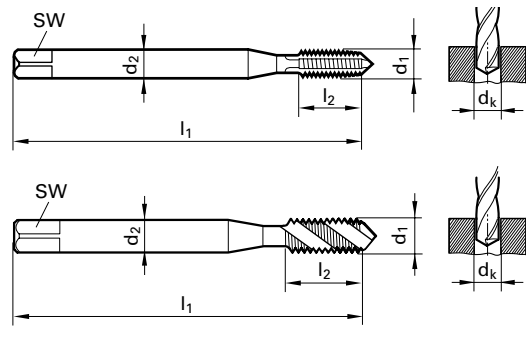
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- Universal
- General Steel
- Tool Steel
- Stainless Steel
- Aluminium
- Cast Materials
- Bright
- Steam Tempered
- Nitrided Lands
- S-Coated (TiN)
- A-Coated (TiAlN)
- C-Coated (TiCN)
- F-Coated (FIRE)

BSW GUN NOSE & SPIRAL TAPS THROUGH & BLIND HOLES

 Through hole and blind hole

Guhring no.
Standard
Tool material
Surface
Cutting direction
Tolerance
Application
Cutting speed m/min
















2892	2893	2847	2848
DIN 371	DIN 376	DIN 371	DIN 376
HSS-E			
			
rh	rh	rh	rh
			
10-15			
			

d1	Code no.	P	d2	SW	dk	l1	l2
inch	mm	TPI	mm	mm	mm	mm	
W 1/8	3.175	40.00	3.500	2.70	2.500	56.00	6.50
W 5/32	3.969	32.00	4.50	3.40	3.200	63.00	13.00
W 3/16	4.762	24.00	6.000	4.90	3.600	70.00	11.00
W 1/4	6.350	20.00	7.000	5.50	5.100	80.00	13.00
W 5/16	7.938	18.00	8.000	6.20	6.500	90.00	14.00
W 3/8	9.525	16.00	7.000	5.50	7.900	100.00	16.00
W 3/8	9.525	16.00	10.000	8.00	7.900	100.00	16.00
W 7/16	11.113	14.00	8.000	6.20	9.200	100.00	22.00
W 1/2	12.700	12.00	9.000	7.00	10.50	110.00	25.00
W 9/16	14.287	12.00	11.000	9.00	12.00	110.00	30.00
W 5/8	15.876	11.00	12.000	9.00	13.50	110.00	30.00
W 3/4	19.051	10.00	14.000	11.00	16.50	125.00	33.00
W 7/8	22.226	9.00	18.000	14.50	19.25	140.00	35.00
W 1	25.401	8.00	18.000	14.50	22.00	160.00	38.00

AVAILABILITY

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 Universal
  General Steel
  Tool Steel
  Stainless Steel
  Aluminium
  Cast Materials
  Bright
  Steam Tempered
  Nitrided Lands
  S-Coated (TiN)
  A-Coated (TiAlN)
  C-Coated (TiCN)
  F-Coated (FIRE)

BSP GUN NOSE & SPIRAL TAPS THROUGH & BLIND HOLES



Guhring no.
Standard
Tool material
Surface
Cutting direction
Tolerance
Application
Cutting speed m/min

962	965	5732	5731
DIN 5156			
HSS-E			
○	○	●	●
rh	rh	rh	rh
10-15	10-15	8-10	8-10

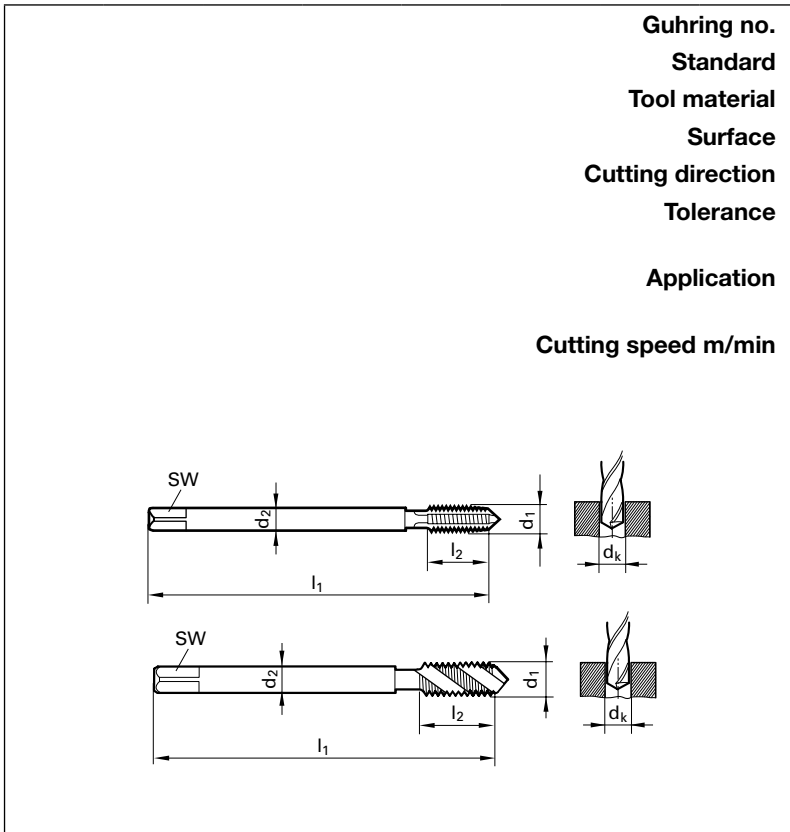
d1	Code no.	P	d2	SW	dk	l1	l2
inch	mm	TPI	mm	mm	mm	mm	mm
G 1/16	7.723	28.00	6.00	4.90	6.80	90.00	18.00
G 1/8	9.728	28.00	7.00	5.50	8.80	90.00	18.00
G 1/4	13.157	19.00	11.00	9.00	11.80	100.00	20.00
G 3/8	16.662	19.00	12.00	9.00	15.25	100.00	22.00
G 1/2	20.955	14.00	16.00	12.00	19.00	125.00	25.00
G 3/4	26.441	14.00	20.00	16.00	24.50	140.00	28.00
G 1"	33.249	11.00	25.00	20.00	30.75	160.00	30.00

AVAILABILITY

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Universal
 General Steel
 Tool Steel
 Stainless Steel
 Aluminium
 Cast Materials
 Bright
 Steam Tempered
 Nitrided Lands
 S-Coated (TIN)
 A-Coated (TiAlN)
 C-Coated (TiCN)
 F-Coated (FIRE)

BSP GUN NOSE & SPIRAL TAPS THROUGH & BLIND HOLES



Guhring no.

Standard

Tool material

Surface

Cutting direction

Tolerance

Application

Cutting speed m/min

967	968
DIN 5156	
HSS-E	
○	○
rh	rh
○	
8-10	8-10

d1	Code no.	P	d2	SW	dk	l1	l2
inch	mm	TPI	mm	mm	mm	mm	mm
G 1/16	7.723	28.00	6.00	4.90	6.80	90.00	18.00
G 1/8	9.728	28.00	7.00	5.50	8.80	90.00	18.00
G 1/4	13.157	19.00	11.00	9.00	11.80	100.00	20.00
G 3/8	16.662	19.00	12.00	9.00	15.25	100.00	22.00
G 1/2	20.955	14.00	16.00	12.00	19.00	125.00	25.00
G 3/4	26.441	14.00	20.00	16.00	24.50	140.00	28.00
G 1"	33.249	11.00	25.00	20.00	30.75	160.00	30.00

AVAILABILITY

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○ Universal
○ General Steel
○ Tool Steel
○ Stainless Steel
○ Aluminium
○ Cast Materials
○ Bright
○ Steam Tempered
○ Nitrided Lands
S S-Coated (TiN)
A A-Coated (TiAlN)
C C-Coated (TiCN)
F F-Coated (FIRE)

**BSPT TAPS
THROUGH & BLIND HOLES**



**Through hole and
blind hole**

Guhring no.
Standard
Tool material
Surface
Cutting direction
Tolerance

Application

Cutting speed m/min

5007

Guhring std.

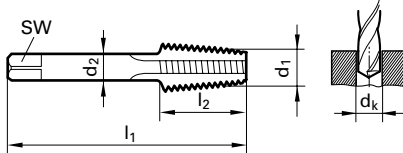
HSS-E



rh



5-10



d1	Code no.	P	d2	SW	dk	l1	l2
inch	mm	TPI	mm	mm	mm	mm	mm
1/8	9.728	28	7.00	5.50	8.40	63.00	15.00
1/4	13.157	19	11.00	9.00	11.20	63.00	21.00
3/8	16.662	19	12.00	9.00	14.75	70.00	21.00
1/2	20.955	14	16.00	12.00	18.25	80.00	27.00
3/4	26.441	14	20.00	16.00	23.75	100.00	27.00
1	33.249	11	25.00	20.00	30.00	110.00	32.00

AVAILABILITY

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Universal
 General Steel
 Tool Steel
 Stainless Steel
 Aluminium
 Cast Materials
 Bright
 Steam Tempered
 Nitrided Lands
 S S-Coated (TiN)
 A A-Coated (TiAlN)
 C C-Coated (TiCN)
 F F-Coated (FIRE)

NPT GUN NOSE & SPIRAL TAPS THROUGH & BLIND HOLES



Through hole and blind hole

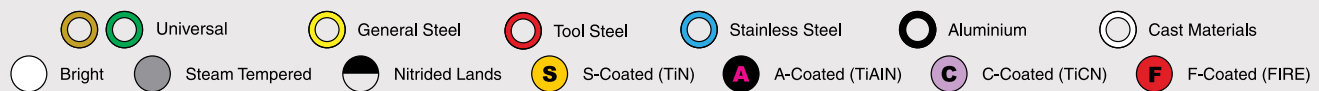
Guhring no.
Standard
Tool material
Surface
Cutting direction
Tolerance
Application
Cutting speed m/min

973	1087
Guhring std.	
HSS-E	
○	●
rh	rh
5-10	3-8

d1	Code no.	P	d2	SW	dk	l1	l2
inch	mm	TPI	mm	mm	mm	mm	mm
1/16	8.190	27.00	6.00	4.90	6.15	56.00	14.00
1/8	10.620	27.00	7.00	5.50	8.40	63.00	15.00
1/4	14.140	18.00	11.00	9.00	11.10	63.00	21.00
3/8	17.570	18.00	12.00	9.00	14.30	70.00	21.00
1/2	21.900	14.00	16.00	12.00	17.90	80.00	27.00
3/4	27.230	14.00	20.00	16.00	23.30	100.00	27.00
1	34.180	11.50	25.00	20.00	29.00	110.00	32.00
1 1/4	42.900	11.50	32.00	24.00	37.70	125.00	33.00
1 1/2	48.940	11.50	36.00	29.00	43.70	140.00	33.00
2	61.000	11.50	36.00	29.00	55.60	160.00	33.00
1/8	10.620	27.00	11.00	9.00	8.50	90.00	15.00
1/4	14.140	18.00	14.00	11.00	11.20	100.00	21.00
3/8	17.570	18.00	16.00	12.00	14.40	110.00	21.00
1/2	21.900	14.00	18.00	14.50	18.00	125.00	27.00
3/4	27.230	14.00	22.00	18.00	23.40	140.00	27.00

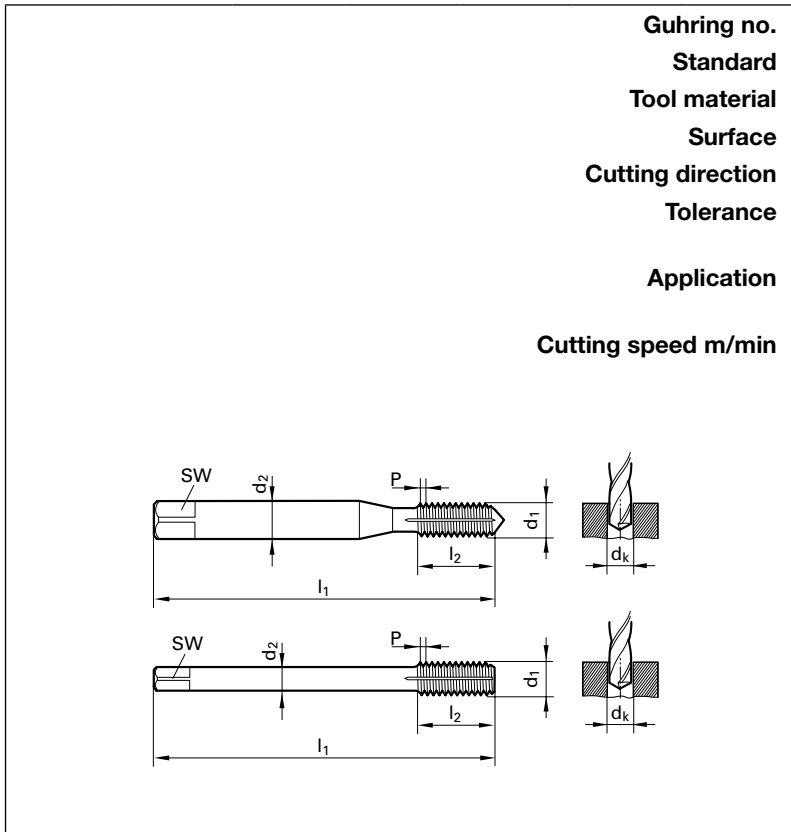
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METRIC FLUTELESS TAPS (THREAD FORMERS) THROUGH & BLIND HOLES

 Through hole and blind hole



Guhring no.
Standard
Tool material
Surface
Cutting direction
Tolerance
Application
Cutting speed m/min

782	793	921	5598	5599
DIN 371				DIN 376
HSS-E				
				
rh	rh	rh	rh	rh
6HX				
				
12-18	12-18	10-15	10-15	10-15
				

d1	P	d2	SW	dk	l1	l2
mm	mm	mm	mm	mm	mm	mm
M 2	0.40	2.80	2.10	1.80	45.00	8.00
M 2.5	0.45	2.80	2.10	2.30	50.00	9.00
M 3	0.50	3.50	2.70	2.80	56.00	10.00
M 3.5	0.60	4.00	3.00	3.25	56.00	12.00
M 4	0.70	4.50	3.40	3.70	63.00	12.00
M 5	0.80	6.00	4.90	4.65	70.00	14.00
M 6	1.00	6.00	4.90	5.50	80.00	16.00
M 8	1.25	8.00	6.20	7.40	90.00	18.00
M10	1.50	10.00	8.00	9.25	100.00	20.00
M12	1.75	9.00	7.00	11.25	110.00	24.00
M14	2.00	11.00	9.00	13.10	110.00	26.00
M16	2.00	12.00	9.00	15.10	110.00	26.00

AVAILABILITY

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METRIC FLUTELESS TAPS (THREAD FORMERS) THROUGH & BLIND HOLES

  **Through hole**
Blind hole

Guhring no.

Standard

Tool material

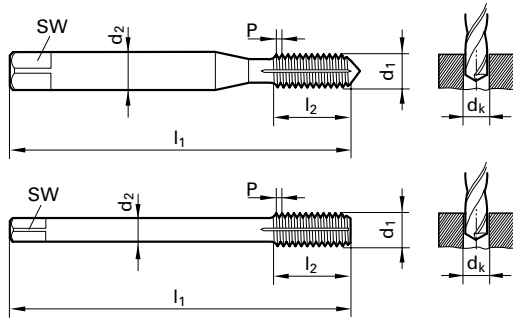
Surface

Cutting direction







Tolerance

Application

Cutting speed m/min



d1	P	d2	SW	dk	l1	l2
inch	mm	mm	mm	mm	mm	mm
M 3	0.50	3.50	2.70	2.80	56.00	10.00
M 4	0.70	4.50	3.40	3.70	63.00	12.00
M 5	0.80	6.00	4.90	4.65	70.00	14.00
M 6	1.00	6.00	4.90	5.50	80.00	16.00
M 8	1.25	8.00	6.20	7.40	90.00	18.00
M10	1.50	10.00	8.00	9.25	100.00	20.00
M12	1.75	9.00	7.00	11.25	110.00	24.00
M16	2.00	12.00	9.00	15.10	110.00	26.00

1587	1589
DIN 371	DIN 376
HSS-E	
	
rh	rh
6HX	
	
6-12	6-12
	

AVAILABILITY

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UNF FLUTELESS TAPS (THREAD FORMERS) THROUGH & BLIND HOLES



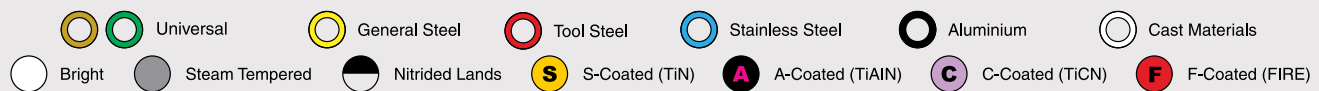
Guhring no.							
Standard							
Tool material							
Surface							
Cutting direction							
Tolerance							
Application							
Cutting speed m/min							
d1	Code No	P	d2	SW	dk	l1	l2
inch		TPI	mm	mm	mm	mm	mm
NR. 10 - 32	4.826	32.00	6.000	4.90	4.450	70.00	14.00
NR. 12 - 28	5.486	28.00	6.000	4.90	5.100	80.00	16.00
1/4 - 28	6.350	28.00	7.000	5.50	5.950	80.00	16.00
5/16 - 24	7.938	24.00	8.000	6.20	7.450	90.00	18.00
3/8 - 24	9.525	24.00	10.000	8.00	9.050	100.00	18.00
7/16 - 20	11.113	20.00	8.000	6.20	10.500	100.00	22.00
1/2 - 20	12.700	20.00	9.000	7.00	12.100	100.00	20.00
9/16 - 18	14.288	18.00	11.000	9.00	13.650	100.00	22.00
5/8 - 18	15.875	18.00	12.000	9.00	15.250	100.00	22.00
3/4 - 16	19.050	16.00	14.000	11.00	18.300	110.00	25.00

1584	1585
DIN 2184-1	DIN 2184-1
HSS-E	
S	S
rh	rh
2BX	

AVAILABILITY	
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UNF FLUTELESS TAPS (THREAD FORMERS) - HSS-E

TAPS

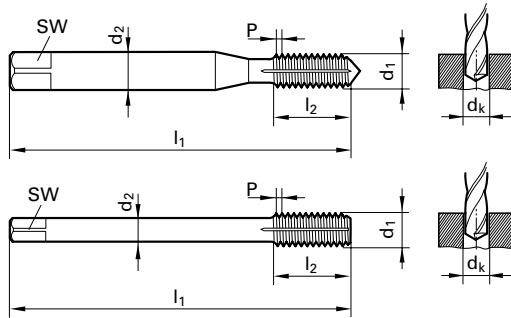


**UNC FLUTELESS TAPS (THREAD FORMERS)
THROUGH & BLIND HOLES**

Through hole and blind hole

Guhring no.
Standard
Tool material
Surface
Cutting direction
Tolerance
Application
Cutting speed m/min

1582	1583
DIN 371	DIN 376
HSS-E	
S	S
rh	rh
2BX	
10-15	10-15



d1	Code no.	P	d2	SW	dk	l1	l2
inch	mm	TPI	mm	mm	mm	mm	mm
No.10-24	4.826	24.00	6.00	4.90	4.35	70.00	14.00
No.12-24	5.486	24.00	6.00	4.90	5.00	80.00	16.00
1/4 - 20	6.350	20.00	7.00	5.50	5.75	80.00	16.00
5/16 - 18	7.938	18.00	8.00	6.20	7.30	90.00	18.00
3/8 - 16	9.525	16.00	10.00	8.00	8.80	100.00	20.00
7/16 - 14	11.113	14.00	8.00	6.20	10.30	100.00	22.00
1/2 - 13	12.700	13.00	9.00	7.00	11.80	110.00	25.00
9/16 - 12	14.288	12.00	11.00	9.00	13.30	110.00	30.00
5/8 - 11	15.875	11.00	12.00	9.00	14.80	110.00	30.00
3/4 - 10	19.050	10.00	14.00	11.00	17.90	125.00	33.00

AVAILABILITY

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Universal
 General Steel
 Tool Steel
 Stainless Steel
 Aluminium
 Cast Materials
 Bright
 Steam Tempered
 Nitrided Lands
 S-Coated (TiN)
 A-Coated (TiAlN)
 C-Coated (TiCN)
 F-Coated (FIRE)

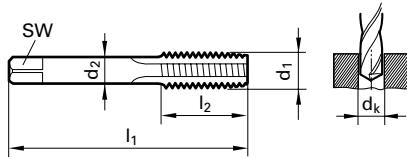
**METRIC HAND TAPS
THROUGH & BLIND HOLES**



SERIES TAPS
1st, 2nd TAP IS UNDERSIZE.

- Guhring no.
- Standard
- Tool material
- Surface
- Cutting direction
- Tolerance
- Application

861	862	863	864
DIN 352			
HSS			
○	○	○	○
rh	rh	rh	rh
ISO 2 / 6H			
3pce Hand Tap Set	1st	2nd	Bottoming



d1	P	d2	SW	dk	l1	l2
	mm	mm	mm	mm	mm	mm
M 3	0.50	3.50	2.70	2.50	40.00	10.00
M 4	0.70	4.50	3.40	3.30	45.00	12.00
M 5	0.80	6.00	4.90	4.20	50.00	14.00
M 6	1.00	6.00	4.90	5.00	56.00	16.00
M 8	1.25	6.00	4.90	6.80	63.00	18.00
M10	1.50	7.00	5.50	8.50	70.00	20.00
M12	1.75	9.00	7.00	10.20	75.00	24.00
M14	2.00	11.00	9.00	12.00	80.00	26.00
M16	2.00	12.00	9.00	14.00	80.00	26.00
M18	2.50	14.00	11.00	15.50	95.00	30.00
M20	2.50	16.00	12.00	17.50	95.00	32.00
M24	3.00	18.00	14.50	21.00	110.00	36.00

AVAILABILITY

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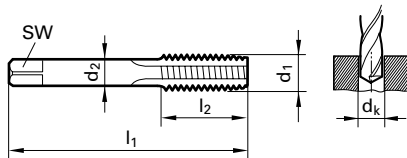
○ Universal
 ○ General Steel
 ○ Tool Steel
 ○ Stainless Steel
 ○ Aluminium
 ○ Cast Materials
○ Bright
 ○ Steam Tempered
 ○ Nitrided Lands
S S-Coated (TiN)
A A-Coated (TiAlN)
C C-Coated (TiCN)
F F-Coated (FIRE)

BSW HAND TAPS THROUGH & BLIND HOLES



SERIES TAPS
 1st, 2nd TAP IS UNDERSIZE.

Guhring no.
Standard
Tool material
Surface
Cutting direction
Tolerance
Application



954	957
DIN 352	
HSS	
○	○
rh	rh
3pce Hand Tap Set	Bottoming

AVAILABILITY

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•	•
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d1	Code no.	P	d2	SW	dk	l1	l2
inch	mm	TPI	mm	mm	mm	mm	mm
W 3/16	4.762	24.00	6.00	4.90	3.60	50.00	14.00
W 1/4	6.350	20.00	6.00	4.90	5.10	56.00	16.00
W 5/16	7.938	18.00	6.00	4.90	6.50	63.00	18.00
W 3/8	9.525	16.00	7.00	5.50	7.90	70.00	20.00
W 1/2	12.700	12.00	9.00	7.00	10.50	75.00	25.00

UNC BUTTON DIES

Guhring no.

Standard

Tool material

Surface

Cutting direction

Tolerance

Application

Cutting speed m/min

182

DIN EN 22568

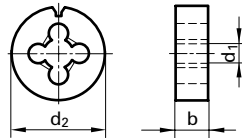
HSS



rh



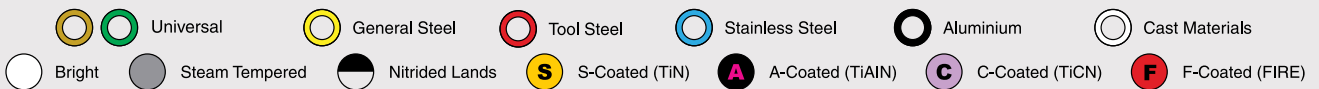
6-10



AVAILABILITY

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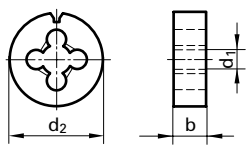
d1 - P	Code no.	d2	b	workpiece Ø
	mm	mm	mm	mm
1/4-20	6.350	20.00	7.00	6.220
5/16-18	7.938	25.00	9.00	7.800
3/8-16	9.525	30.00	11.00	9.370
7/16-14	11.113	30.00	11.00	10.950
1/2-13	12.700	38.00	14.00	12.520
5/8-11	15.875	45.00	18.00	15.680
3/4-10	19.050	45.00	18.00	18.840



BSW BUTTON DIES

Guhring no.
Standard
Tool material
Surface
Cutting direction
Tolerance

Application
Cutting speed m/min



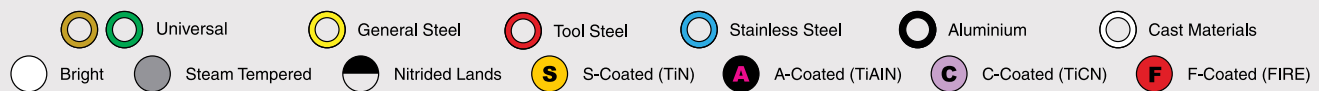
172
DIN EN 22568
HSS
○
rh
○
6-10




d1	Code no.	P	d2	b	workpiece Ø
inch	mm	TPI	mm	mm	mm
W 1/4	6.350	20.00	20.00	7.00	6.180
W 3/8	9.525	16.00	30.00	11.00	9.350
W 1/2	12.700	12.00	38.00	14.00	12.470

AVAILABILITY















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RECOMMENDATION CHART FOR TAPS

Colour Ring	Material Groups	Tens Strength Mpa (N/mm ²)	Hardness HB	Cutting Speed Vc m/min *		
				HSS-E	HSS-E-PM	Solid Carbide
	Structural Steels - Mild Steel, 250 and 350 plate	≤ 850	-	10 - 15	15 - 20	30 - 50
	Free Cutting Steels - 1020, S1214, S1213, S12L13, S12L14	≤ 1000	-	10 - 20	15 - 25	30 - 50
	Unalloyed Case Hardened Steels - 1010, 1015	≤ 750	-	10 - 15	15 - 20	30 - 50
	Un9/9/2008d Heat Treatable Steels - 1035, 1045, 1055, 1060, 1025	≤ 850	-	10 - 15	15 - 20	30 - 50
	Alloyed Case Hardened Steels - 3310, 3415, 5115, 4615, 4620, 5120, 8617, 8620, N33, EN36A	850 - 1200	-	8 - 12	10 - 15	25 - 40
	Alloyed Heat Treatable Steels - 3140, 4130, 4140, 4150, 4340, 6150, EN16, EN26	850 - 1200	-	8 - 12	10 - 15	25 - 40
	Alloyed Tool Steels - H11, H13, P20, D2, D3	≤ 1000	-	6 - 10	8 - 12	25 - 40
	High Speed Tool Steels M2, M3, M35, M45	650 - 1000	-	6 - 10	8 - 12	25 - 40
	Stainless and Acid resistant Steels - Sulphured - 410S, 430F, 630	≤ 850	-	6 - 12	8 - 15	30 - 50
	- Austenitic -302, 303, 304, 310, 316, 316Ti, 321	≤ 850	-	6 - 12	8 - 15	30 - 50
	- Martensitic - 410, 410X, 416, 420, 420C, 431, 440C	≤ 850	-	6 - 12	8 - 15	30 - 50
 	Structural Steels - Mild Steel, 250 and 350 plate	≤ 800	-	10 - 15	15 - 20	30 - 50
	Free Cutting Steels - 1020, S1214, S1213, S12L13, S12L14	≤ 1000	-	10 - 20	15 - 25	30 - 50
	Case Hardened Steels	≤ 1000	-	10 - 15	15 - 20	30 - 50
	Heat Treatable Steels	≤ 1200	-	10 - 15	15 - 20	30 - 50
	Nitriding Steels	≤ 1200	-	10 - 15	15 - 20	30 - 50
	Spheroidal Graphite Cast Iron - GGG40, GGG50, GGG60, GGG70	-	≤ 240	10 - 20	15 - 25	30 - 50
	Aluminium and Al-Alloys	≤ 400	-	15 - 20	20 - 25	30 - 50
	Al Wrought Alloys	≤ 400	-	15 - 20	20 - 25	30 - 50
	Alcast Alloys ≤ 10 % Si	≤ 600	-	15 - 20	20 - 25	30 - 50
	> 10 % Si	≤ 600	-	15 - 20	20 - 25	25 - 40
	Cast Iron - GG10, GG15, GG20, GG25, GG30, GG35, GG40	-	≤ 240	15 - 20	20 - 25	30 - 40
	Spheroidal Graphite Cast Iron - GGG40, GGG50, GGG60, GGG70	-	≤ 240	15 - 20	20 - 25	30 - 40
	Malleable Cast Iron - 32510, 50005, Nodular Iron	-	≤ 240	15 - 20	20 - 25	30 - 40
	Brass Short Chipping	≤ 600	-	10 - 15	15 - 20	25 - 30
	Long Chipping	≤ 600	-	10 - 15	15 - 20	25 - 30
	Plastics	-	-	5 - 10	15 - 20	25 - 30
	Magnesium Alloys	≤ 450	-	30 - 50		40 - 60
	Titanium and Ti-Alloys	≤ 1200			2 - 8	
	Ni Alloys				2 - 8	

* With Coated Tools Cutting Speed May Be Increased Up To 50%

  Universal
  General Steel
  Tool Steel
  Stainless Steel
  Aluminium
  Cast Materials
 Bright
  Steam Tempered
  Nitrided Lands
  S S-Coated (TiN)
  A A-Coated (TiAlN)
  C C-Coated (TiCN)
  F F-Coated (FIRE)