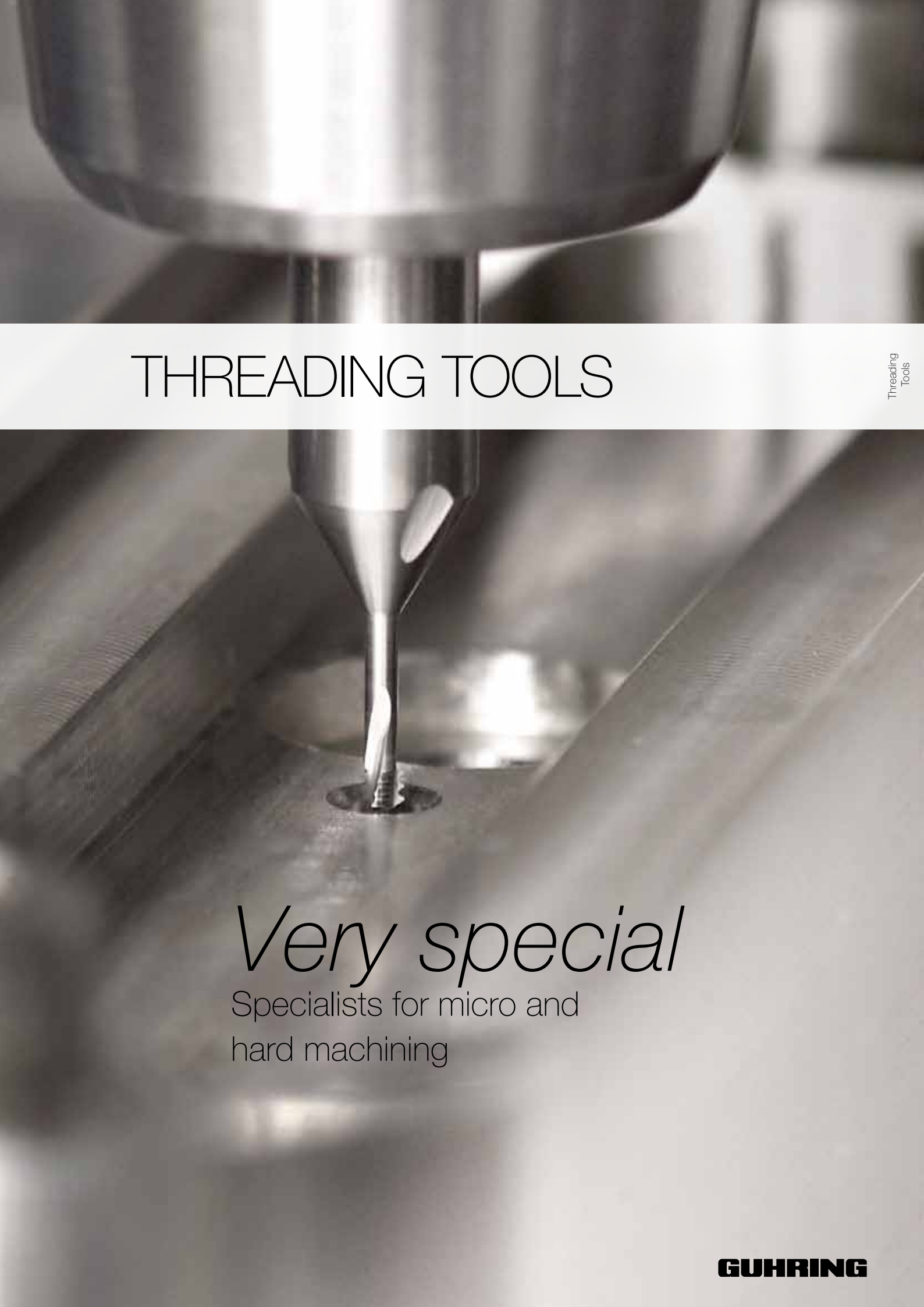
Complete Program

Tapping, fluteless tapping
and thread milling

GUHRING



THREADING TOOLS

Very special

Specialists for micro and hard machining

GUHRING

The Guhring colour code

The Guhring colour-code simplifies the selection of the optimal Guhring threading tool for the workpiece material.
The structure of the compass pages for taps and thread milling cutters is corresponding to this colour-code.

General steels

Material no. to DIN EN 10 027	Abbreviation
Common structural steels	
1.0035	S 185 (St 33)
1.0039	S 235 JRH
1.0036	S 235JRG1+CR
1.0060	E 335 (St 60-2)
Free-cutting steels	
1.0718	11SMnPb30
1.0721	10S20
1.0758	60SPb20
1.0726	35S20
Case hardened steels	
1.0401	(C 15)
1.7016	17 CR3
1.7131	16MnCr5
1.5919	15CrNi6
Unalloyed heat-treatable steels	
1.0402	C 22
1.1151	C22E (Ck 22)
1.0503	C 45
1.1191	C45E (Ck 45)

High tensile steels

Material no. to DIN EN 10 027	Abbreviation
Alloyed heat-treatable steels	
1.6511	36 CrNiMo 4
1.7033	34 Cr 4
1.7225	42 CrMo 4
Tool steels	
1.2316	X 36 CrMo 17
1.2067	10 S20
High speed steels	
1.3343	HS 6-5-2
1.3344	HS 6-5-3
1.3243	HS 6-5-2-5
1.3247	HS 2-19-1-8
Hardened steels	
The above mentioned materials hardened to 45…62 HRC	

Acid-/stainl. resist. steels

Material no. to DIN EN 10 027	Abbreviation
Sulphured stainless steels	
1.4005	X 12 CrS 13
1.4104	X 14 CrMo S 17
1.4105	X 6 CrMo S 17
1.4305	X 8CrNi S 18-9
Austenitic stainless steels	
1.4300	X 12 CrNi 18-8
1.4301	X 5 CrNi 18-10
1.4541	X 6 CrNiTi 18-10
Martensitic stainless steels	
1.4057	X 17 CrNi 16-2
1.4112	X 90 CrMoV 18
1.4006	X 12 Cr 13

Universell

Material no. to DIN EN 10 027	Abbreviation
Common structural steels	
1.0035	S185 (St33)
1.0421	St 52.0
1.0067	RSt 37-1
1.0425	P265GH
Free-cutting steels	
1.0711	9S20
1.0718	11SMnPb30
1.0727	46S20
1.0728	(60 S 20)
Case hardened steels	
1.7131	16MnCr5
1.6523	21NiCrMo2-2
1.7321	20MoCr4
1.7325	25MoCr4
Unalloyed heat-treatable steels	
1.0402	C22
1.1151	C22E
1.0503	C45
1.0601	C60
Nitriding steels	
1.8504	34CrAl6
1.8507	34CrAlMo5
1.8509	41CrAlMo7
1.8515	31CrMo12
1.8550	34CrAlNi4
Spher. graphite iron	
0.7040	EN-GJS-400-15
0.7060	EN-GJS-600-3

Al and Al-alloys

Material no.	Abbreviation
Al and al-alloys	
3.0250	Al 99,5H
3.0280	AL 99,8H
3.3308	Al99,9Mg0.5
Al wrought alloys	
3.2315	AlMgSi1
3.1655	AlCuMgPb
3.4335	AlZn4,5Mg1
Al cast alloys ≤ 10% Si	
3.2134	GD-AlSi5Cu1Mg
3.2162	GD-AlSi8Cu3
3.2373	G-AlSi9Mg
Al cast alloys > 10% Si	
3.2581	G-AlSi12
3.2583	G-AlSi12Cu
3.2581	G-AlSi10Mg

Cast materials

Material no.	Abbreviation
Cast iron	
0.6015 (GG15)	EN-GJL-150
0.6025 (GG25)	EN-GJL-250
0.6040 (GG40)	EN-JLZ
Spheroidal grahpite iron and malleable cast iron	
0.7040 (GGG40)	EN-GJS-400-15
0.7060 (GGG60)	EN-GJS-600-3
0.8035	EN-GJMW-350-4
0.8135	EN-GJMB-350-10
Compacted graphite iron	
–	EN-GJV250
	EN-GJV350
	EN-GJV400
	EN-GJV500

Non-ferrous metals

Material no.	Abbreviation
Brass, short-chipping	
2.0380	CuZn39Pb2
2.0401	CuZn39Pb3
2.0410	CuZn43Pb2
Brass, long-chipping	
2.0250	CuZn20
2.0280	CuZn33
2.0332	CuZn37Pb0,5

Plastics

Material no.	Abbreviation
Duroplastics	
–	Bakelite
	Resopal
	Pertinax
	Moltopren
Thermoplastics	
–	Plexiglass
	Hostalen
	Novodur
	Makralon
Glass/carbon re-inforced	
–	Polypropylene
	glass fibre
	carbon fibre

Magnesium-alloys

Material no.	Abbreviation
Magnesium-alloys	
3.5200	MgMn2
3.5612	MgAl6Zn
3.5812	MgAl8Zn
3.5812.05	GDMgAl8Zn1
3.5612.05	GDMgAl6Zn1
3.5662.01	GMgAl6

Special-alloys

Material no.	Abbreviation
Titanium	
3.7025	Ti
3.7065	Ti
Titanium-alloys	
3.7115	TiAl 5Sn2
3.7165	TiAl 6 V4
Special-alloys	
2.4610	Hastelloy C4
2.4876	Incoloy 800
2.4816	Inconel 600
2.4668	Inconel 718
2.4634	Nimonic 105
	CuNi12Zn24
	CuNi18Zn20

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Hand taps for ISO metric threads

Standard	Type	Form	Tolerance	Tool illustration	Tool material	Surface	d1	Guhring no.	Discount group	Standard range page
DIN 352	N		ISO 2 / 6H		HSS	○	M 1 - M45	861	118	822
DIN 352	N	A	ISO 2 / 6H		HSS	○	M 1 - M68	862	118	822
DIN 352	N	D	ISO 2 / 6H		HSS	○	M 1 - M68	863	118	822
DIN 352	N	C	ISO 2 / 6H		HSS	○	M 1 - M36	864	118	822
DIN 352	N		ISO 2 / 6H		HSS	○	M 2 - M 9	882	118	824
DIN 352	N	D	ISO 2 / 6H		HSS	○	M 2 - M12	883	118	824
DIN 352	N	C	ISO 2 / 6H		HSS	○	M 1 - M36	864	118	822
DIN 352	N-LH		ISO 2 / 6H		HSS	○	M 2,2 - M22	904	118	825
DIN 352	N-LH	A	ISO 2 / 6H		HSS	○	M14 - M16	905	118	825
DIN 352	N-LH	D	ISO 2 / 6H		HSS	○	M14 - M16	906	118	825
DIN 352	N-LH	C	ISO 2 / 6H		HSS	○	M 2 - M20	907	118	825
DIN 352	VA		ISO 2 / 6H		HSS-E	○	M 2 - M20	853	118	826
DIN 352	VA	A	ISO 2 / 6H		HSS-E	○	M 2 - M20	854	118	826
DIN 352	VA	D	ISO 2 / 6H		HSS-E	○	M 2 - M20	855	118	826
DIN 352	VA	C	ISO 2 / 6H		HSS-E	○	M 2 - M20	856	118	826

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Standard	Type	Form	Tolerance	Tool illustration	Tool material	Surface	d1	Guhring no.	Discount group	Standard range page
Hand taps for ISO metric threads										
DIN 352	H		ISO 2 / 6H		HSS-E	●	M 2 - M20	857	118	827
DIN 352	H	A	ISO 2 / 6H		HSS-E	●	M 2 - M20	858	118	827
DIN 352	H	D	ISO 2 / 6H		HSS-E	●	M 2,2 - M20	859	118	827
DIN 352	H	C	ISO 2 / 6H		HSS-E	●	M 2,2 - M20	860	118	827
DIN 352	H		ISO 2 / 6H		HSS-E-PM	●	M 3 - M12	1818	118	828
DIN 352	H	A	ISO 2 / 6H		HSS-E-PM	●	M 8 - M10	1819	118	828
DIN 352	H	D	ISO 2 / 6H		HSS-E-PM	●	M 4 - M12	1820	118	828
Hand taps for ISO metric fine threads										
DIN 2181	N		ISO 2 / 6H		HSS	○	M 2,3X0,25 - M36 X1,5	884	118	829
DIN 2181	N	D	ISO 2 / 6H		HSS	○	M 2 X0,25 - M52 X1,5	885	118	829
DIN 2181	N	C	ISO 2 / 6H		HSS	○	M 2 X0,25 - M34 X1,5	886	118	829
Hand taps for UNC-threads										
~ DIN 352	N		2B		HSS	○	NR. 1 -64 - 2 -4,5	981	118	831
~ DIN 352	N	A	2B		HSS	○	NR. 1 -64 - 2 -4,5	982	118	831
~ DIN 352	N	D	2B		HSS	○	NR. 1 -64 - 2 -4,5	983	118	831

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Standard	Type	Form	Tolerance	Tool illustration	Tool material	Surface	d1	Guhring no.	Discount group	Standard range page
Hand taps for UNC-threads										
~ DIN 352	N	C	2B		HSS	◯	NR. 1 -64 - 2 -4,5	984	118	831
Hand taps for UNF-threads										
~ DIN 2181	N		2B		HSS	◯	NR. 1 -72 - 1 3/8 -1	985	118	832
~ DIN 2181	N	D	2B		HSS	◯	NR. 0 -80 - 1 1/2 -1	986	118	832
~ DIN 2181	N	C	2B		HSS	◯	NR. 2 -64 - 1 1/2 -1	987	118	832
Hand taps for BSW-threads										
~ DIN 352	N				HSS	◯	W 1/8 - W2	954	118	833
~ DIN 352	N	A			HSS	◯	W 1/16 - W2	955	118	833
~ DIN 352	N	D			HSS	◯	W 3/32 - W2	956	118	833
~ DIN 352	N	C			HSS	◯	W 1/8 - W2	957	118	833
Hand taps for BSP-threads										
DIN 5157	N				HSS	◯	G 1/8 - G2	958	118	834
DIN 5157	N	D			HSS	◯	G 1/8 - G2	959	118	834
DIN 5157	N	C			HSS	◯	G 1/8 - G2	960	118	834

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Standard	Type	Form	Tolerance	Tool illustration	Tool material	Surface	d1	Guhring no.	Discount group	Standard range page
Machine taps for ISO metric threads										
DIN 352	N R15	C	ISO 2 / 6H		HSS-E	○	M 2,2 - M20	992	103	835
DIN 352	N R40	C	ISO 2 / 6H		HSS-E	○	M 2 - M22	993	103	835
DIN 352	N	C	ISO 2 / 6H		HSS-E	○	M 2 - M24	995	103	836
DIN 352	N	B	ISO 2 / 6H		HSS-E	○	M 2 - M24	991	103	837
Machine taps for ISO metric fine threads										
DIN 2181	N	C	ISO 2 / 6H		HSS-E	○	M 5 X0,5 - M10 X1	997	103	838
DIN 2181	N R40	C	ISO 2 / 6H		HSS-E	○	M 6 X0,75 - M12 X1,5	1970	103	838
Machine taps for PG-threads for electr. conduits										
DIN 40432	N	B			HSS-E	○	PG 7 - PG 16	980	103	839
DIN 40432	N	C			HSS-E	○	PG 7 - PG 29	979	103	839
Machine taps for NPT-threads										
Guhring std.	N	C			HSS-E	○	1/16 - 2	973	103	840

○ bright ● steam tempered ◓ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

Machine taps for ISO metric threads

Standard	Type	Form	Tolerance	Tool illustration	Tool material	Surface	d1	Guhring no.	Discount group	Standard range page
DIN 371	Ti	B	4HX	NEW	HSS-E-PM	C	MJ 3X0,5 - MJ 16X2	1057	103	841
DIN 371/ DIN 376	Ti R15	C	4HX	NEW	HSS-E-PM	C	MJ 3X0,5 - MJ 16X2	1061	103	841
DIN 371/ DIN 376	Ni R10	C	4HX	NEW	HSS-E-PM	A	MJ 3X0,5 - MJ 16X2	1065	103	841
DIN 371	N R40	C(K)	ISO 2 / 6H		HSS-E	S	M 5 - M10	174	103	842
DIN 371	H R40	C	ISO 2 / 6H		HSS-E	S	M 2 - M10	361	103	842
DIN 371	N R40	C	ISO 2 / 6H		HSS-E		M 2 - M10	783	103	842
DIN 371	N L40-LH	C	ISO 2 / 6H		HSS-E		M 3 - M10	786	103	842
DIN 371	N	C	ISO 3 / 6G		HSS-E		M 3 - M10	795	103	843
DIN 371	N R15	C	ISO 3 / 6G		HSS-E		M 2 - M10	799	103	843
DIN 371	N	C	ISO 2 / 6H		HSS-E		M 1 - M10	806	103	843
DIN 371	N R15	C	ISO 2 / 6H		HSS-E		M 2 - M10	809	103	843
DIN 371	N R40	C	ISO 2 / 6H		HSS-E		M 2 - M10	810	103	843
DIN 371	H R40	C	ISO 2 / 6H		HSS-E		M 2 - M10	811	103	843
DIN 371	Al R45	C	ISO 2 / 6H		HSS-E		M 1,6 - M10	812	103	843
DIN 371	VA R40	C	ISO 2 / 6H		HSS-E		M 3 - M10	814	103	843

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Machine taps for ISO metric threads

Standard	Type	Form	Tolerance	Tool illustration	Tool material	Surface	d1	Guhring no.	Discount group	Standard range page
DIN 371	N R40	C	ISO 2 / 6H		HSS-E	steam tempered	M 2 - M10	836	103	844
DIN 371	VA R15	C	ISO 2 / 6H		HSS-E	steam tempered	M 2 - M10	843	103	844
DIN 371	N R40	C	ISO 3 / 6G		HSS-E	bright	M 3 - M10	844	103	844
DIN 371	N R40	C	ISO 2 / 6H		HSS-E	bright	M 2 - M10	889	103	844
DIN 371	N R15	C	ISO 2 / 6H		HSS-E	S	M 2 - M10	913	103	845
DIN 371	N R40	C	ISO 2 / 6H		HSS-E	S	M 2 - M10	914	103	845
DIN 371	N R15	C	ISO 2 / 6H		HSS-E	steam tempered	M 2 - M10	946	103	845
DIN 371	H R40	C	ISO 2 / 6H		HSS-E	nitrided	M 2 - M10	947	103	845
DIN 371	N R40	C	ISO 2 / 6H		HSS-E	C	M 3 - M10	1252	103	845
DIN 371	H R40	C	ISO 2 / 6H		HSS-E	C	M 2 - M10	1916	103	845
DIN 371	N R40	C	ISO 2 / 6H		HSS-E	M	M 3 - M10	2425	103	845
DIN 371	N R40	C	ISO 2 / 6H		HSS-E	S	M 2 - M10	2440	103	845
DIN 371	N R40	E	ISO 2 / 6H		HSS-E	bright	M 3 - M10	2790	103	846
DIN 371	H R40	C	ISO 2 / 6H		HSS-E	steam tempered	M 2 - M10	2850	103	846
DIN 371	VA R40	C	ISO 2 / 6H		HSS-E	steam tempered	M 3 - M10	2862	103	846

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Machine taps for ISO metric threads

Standard	Type	Form	Tolerance	Tool illustration		Tool material	Surface	d1	Guhring no.	Discount group	Standard range page
DIN 371	VA R15	C	ISO 2 / 6H			HSS-E	S	M 3 - M10	2896	103	847
DIN 371	H R40	C	ISO 3 / 6G			HSS-E	○	M 2 - M10	2984	103	847
DIN 371	H R40	C	ISO 3 / 6G			HSS-E	●	M 2 - M10	2985	103	847
DIN 371	H R40	C	ISO 3 / 6G			HSS-E	S	M 2 - M10	2986	103	847
DIN 371	N R40	C	ISO 3 / 6G			HSS-E	●	M 3 - M10	2994	103	847
DIN 371	N R40	C	ISO 3 / 6G			HSS-E	S	M 3 - M10	2995	103	847
DIN 371	N R15	C	ISO 2 / 6H		NEW	HSS-E	C	M 3 - M20	4154	103	847
DIN 371	N R15	E	ISO 2 / 6H		NEW	HSS-E	C	M 3 - M20	4155	103	847
DIN 371	VA R40	C	ISO 2 / 6H			HSS-E-PM	S	M 3 - M10	59	103	848
DIN 371	N R50	C	ISO 2 / 6H			HSS-E-PM	S	M 3 - M10	767	103	848
DIN 371	H R15	C	ISO 2 / 6H			HSS-E-PM	○	M 3 - M10	872	103	849
DIN 371	VA R40	C	ISO 2 / 6H			HSS-E-PM	○	M 3 - M10	909	103	849
DIN 371	N R40	C	ISO 2 / 6H			HSS-E-PM	S	M 2 - M10	1288	103	849
DIN 371	N R40	C	ISO 2 / 6H			HSS-E-PM	C	M 2 - M20	1290	103	849
DIN 371	H R15	C	ISO 2 / 6H			HSS-E-PM	A	M 3 - M10	1577	103	849

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Machine taps for ISO metric threads

Standard	Type	Form	Tolerance	Tool illustration	Tool material	Surface	d1	Guhring no.	Discount group	Standard range page
DIN 376	H	C	6HX	NEW	HSS-E	C	M16 - M39	778	103	850
DIN 376	VA R15	C	ISO 2 / 6H		HSS-E		M12 - M24	785	103	850
DIN 376	N L40-LH	C	ISO 2 / 6H		HSS-E		M12 - M20	787	103	850
DIN 376	VA R40	C	ISO 2 / 6H		HSS-E		M12 - M30	825	103	850
DIN 376	N R40	C	ISO 2 / 6H		HSS-E	C	M12 - M16	1254	103	851
DIN 376	VA R40	C	ISO 2 / 6H		HSS-E		M12 - M24	2863	103	851
DIN 376	VA R15	C	ISO 2 / 6H		HSS-E	S	M12 - M24	2895	103	851
DIN 376	VA R40	C	ISO 2 / 6H		HSS-E-PM	S	M12 - M20	60	103	851
DIN 376	VA R40	C	ISO 2 / 6H		HSS-E-PM		M12 - M24	910	103	851
DIN 376	H R15	C	ISO 2 / 6H		HSS-E-PM		M12 - M20	935	103	851
DIN 376	N R50	C	ISO 2 / 6H		HSS-E-PM	S	M12 - M20	1098	103	851
DIN 376	N R40	C	ISO 2 / 6H		HSS-E-PM	S	M12 - M20	1289	103	851
DIN 376	H R15	C	ISO 2 / 6H		HSS-E-PM	A	M12 - M20	1578	103	851
DIN 371	VA R50	C	6HX		HSS-E-PM	S	M 3 - M10	761	103	852
DIN 376	VA R50	C	6HX		HSS-E-PM	S	M12 - M20	763	103	852

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Machine taps for ISO metric threads

Standard	Type	Form	Tolerance	Tool illustration	Tool material	Surface	d1	Guhring no.	Discount group	Standard range page
~ DIN 371	N	B	6HX		Solid carbide	C	M 5 - M12	942	103	853
DIN 371	N	B	ISO 2 / 6H		HSS-E	S	M 3 - M10	313	103	854
DIN 371	H	B	ISO 2 / 6H		HSS-E		M 2 - M10	733	103	854
DIN 371	H AZ	C	ISO 2 / 6H		HSS-E	●	M 2 - M10	788	103	854
DIN 371	N-LH	B	ISO 2 / 6H		HSS-E	○	M 3 - M10	789	103	854
DIN 371	H AZ	B	ISO 2 / 6H		HSS-E	○	M 2 - M10	791	103	855
DIN 371	N	B	ISO 1 / 4H		HSS-E	○	M 2 - M10	794	103	855
DIN 371	N	B	ISO 3 / 6G		HSS-E	○	M 2 - M10	796	103	855
DIN 371	N	B	ISO 3 / 6G		HSS-E	○	M 4 - M 8	797	103	855
DIN 371	Ms	E	ISO 2 / 6H		HSS-E	○	M 3 - M10	800	103	855
DIN 371	N	D	ISO 2 / 6H		HSS-E	○	M 2 - M10	801	103	855
DIN 371	N	B	ISO 2 / 6H		HSS-E	○	M 2 - M10	802	103	855
DIN 371	N	B	ISO 2 / 6H		HSS-E	○	M 1,4 - M10	803	103	855
DIN 371	H	B	ISO 2 / 6H		HSS-E	○	M 2 - M10	804	103	855
DIN 371	Al	B	ISO 2 / 6H		HSS-E	○	M 2 - M10	805	103	855

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Machine taps for ISO metric threads

Standard	Type	Form	Tolerance	Tool illustration	Tool material	Surface	d1	Guhring no.	Discount group	Standard range page
DIN 371	GG	C	6HX		HSS-E	●	M 3 - M10	807	103	856
DIN 371	N L15	D	ISO 2 / 6H		HSS-E	○	M 3 - M10	808	103	856
DIN 371	N	B	ISO 3 / 6G		HSS-E	○	M 1,4 - M10	837	103	856
DIN 371	N	B	ISO 2 / 6H		HSS-E	○	M 1,4 - M10	838	103	856
DIN 371	N	B	ISO 2 / 6H		HSS-E	○	M 1 - M 7	839	103	857
DIN 371	N	B	ISO 3 / 6G		HSS-E	○	M 3 - M 8	869	103	857
DIN 371	N	B	ISO 2 / 6H		HSS-E	S	M 1,4 - M10	912	103	857
DIN 371	GG	C	6HX		HSS-E	S	M 3 - M10	930	103	857
DIN 371	N	B	ISO 2 / 6H		HSS-E	●	M 1 - M10	945	103	857
DIN 371	N	B	ISO 2 / 6H		HSS-E	C	M 3 - M10	1246	103	857
DIN 371	VA	B	ISO 2 / 6H		HSS-E	○	M 2 - M10	1870	103	857
DIN 371	VA AZ	B	ISO 2 / 6H		HSS-E	○	M 3 - M10	1871	103	857
DIN 371	GGT	C	ISO 2 / 6H		HSS-E	S	M 3,5 - M10	1875	103	857
DIN 371	H	B	ISO 2 / 6H		HSS-E	C	M 2 - M10	1914	103	857
DIN 371	GG	C	6HX		HSS-E	A	M 3 - M10	1918	103	858

○ bright ● steam tempered ◐ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

Machine taps for ISO metric threads

Standard	Type	Form	Tolerance	Tool illustration	Tool material	Surface	d1	Guhring no.	Discount group	Standard range page
DIN 371	VA	B	ISO 2 / 6H		HSS-E	S	M 3 - M10	2086	103	858
DIN 371	N	B	ISO 2 / 6H		HSS-E	A + M	M 3 - M10	2427	103	858
DIN 371	H	B	ISO 3 / 6G		HSS-E	○	M 2 - M10	2465	103	859
DIN 371	H	B	ISO 3 / 6G		HSS-E	S	M 2 - M10	2710	103	859
DIN 371	VA	B	ISO 2 / 6H		HSS-E	●	M 3 - M10	2869	103	859
DIN 371	N	B	ISO 2 / 6H		HSS-E	●	M 2 - M10	2876	103	859
DIN 371	H	B	ISO 2 / 6H		HSS-E	●	M 2 - M10	2941	103	859
DIN 371	N	B	ISO 3 / 6G		HSS-E	●	M 2 - M10	2990	103	859
DIN 371	N	B	ISO 3 / 6G		HSS-E	S	M 3 - M10	2991	103	859
DIN 371	H	B	ISO 2 / 6H		HSS-E-PM	S	M 3 - M10	57	103	860
DIN 371	H	B	ISO 2 / 6H		HSS-E-PM	○	M 3 - M10	875	103	860
DIN 371	VA	B	ISO 2 / 6H		HSS-E-PM	○	M 2 - M10	877	103	861
DIN 371	VA	B	ISO 2 / 6H	NEW	HSS-E-PM	C	M 2 - M12	1002	103	861
DIN 371	Ms	E	ISO 3 / 6G		HSS-E-PM	○	M 3 - M10	1084	103	861
DIN 371	N	B	ISO 2 / 6H		HSS-E-PM	S	M 2 - M10	1285	103	861

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

Machine taps for ISO metric threads

Standard	Type	Form	Tolerance	Tool illustration	Tool material	Surface	d1	Guhring no.	Discount group	Standard range page
DIN 371	N	B	ISO 2 / 6H		HSS-E-PM	C	M 3 - M20	1287	103	861
DIN 371	H	B	ISO 2 / 6H		HSS-E-PM	A	M 3 - M10	1575	103	861
DIN 376	N-LH	B	ISO 2 / 6H		HSS-E	○	M12 - M20	790	103	862
DIN 376	VA AZ	B	ISO 2 / 6H		HSS-E	○	M12 - M16	792	103	862
DIN 376	Al	B	ISO 2 / 6H		HSS-E	○	M12 - M24	817	103	862
DIN 376	H AZ	B	ISO 2 / 6H		HSS-E	○	M12 - M18	849	103	862
DIN 376	N	B	ISO 2 / 6H		HSS-E	C	M12 - M16	1249	103	863
DIN 376	H	B	ISO 2 / 6H		HSS-E-PM	S	M12 - M24	58	103	863
DIN 376	VA	B	ISO 2 / 6H		HSS-E-PM	○	M12 - M20	879	103	863
DIN 376	N	B	ISO 2 / 6H		HSS-E-PM	S	M12 - M20	1286	103	863
DIN 376	H	B	ISO 2 / 6H		HSS-E-PM	A	M12 - M30	1576	103	863
DIN 371/ DIN 376	Ti	B	6HX		HSS-E-PM	C	M 3 - M16	2901	103	863
DIN 371/ DIN 376	Ti R15	C	6HX		HSS-E-PM	C	M 3 - M16	2909	103	863
DIN 371/ DIN 376	Ni	B	6HX		HSS-E-PM	A	M 3 - M16	2916	103	863
DIN 371/ DIN 376	Ni R10	C	6HX		HSS-E-PM	A	M 3 - M16	2920	103	863

○ bright ● steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

Machine taps for ISO metric threads

Standard	Type	Form	Tolerance	Tool illustration	Tool material	Surface	d1	Guhring no.	Discount group	Standard range page
Guhring std.	N R40	C	ISO 2 / 6H		HSS-E	○	M 3 - M20	888	103	864
DIN 376	N R40	C(K)	ISO 2 / 6H		HSS-E	S	M 5 - M30	196	103	865
DIN 376	N R15	C	ISO 2 / 6H		HSS-E	S	M 3,5 - M24	916	103	865
DIN 376	N R40	E	ISO 2 / 6H		HSS-E	○	M 4 - M16	2791	103	865
DIN 376	H R40	C	ISO 2 / 6H		HSS-E	●	M 4 - M30	2851	103	865
DIN 376	N	B	ISO 2 / 6H		HSS-E	○	M 4 - M16	846	103	866
DIN 376	GGT	C	ISO 2 / 6H		HSS-E	S	M 4 - M18	1876	103	866
DIN 376	VA	B	ISO 2 / 6H		HSS-E	●	M 4 - M24	2870	103	866
Guhring std.	N R40	C	6HX	NEW	HSS-E	S	M 3 - M20	4153	103	867
DIN 371/ DIN 376	H	D	6HX		HSS-E-PM	C	M 3 - M16	1201	103	868
~ DIN 371	H	D	ISO 2 / 6H		Solid carbide	C	M 3 - M16	2944	103	869
DIN 376	H R40	C	ISO 2 / 6H		HSS-E	S	M 3 - M30	362	103	870
DIN 376	N R40	C	ISO 2 / 6H		HSS-E	●	M 3 - M30	784	103	870
DIN 376	N	C	ISO 2 / 6H		HSS-E	○	M 1,6 - M48	818	103	870
DIN 376	N R15	C	ISO 2 / 6H		HSS-E	○	M 3 - M30	821	103	870

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

Machine taps for ISO metric threads

Standard	Type	Form	Tolerance	Tool illustration	Tool material	Surface	d1	Guhring no.	Discount group	Standard range page
DIN 376	N R40	C	ISO 2 / 6H		HSS-E	bright	M 3 - M30	822	103	870
DIN 376	H R40	C	ISO 2 / 6H		HSS-E	bright	M 3 - M30	823	103	871
DIN 376	Al R45	C	ISO 2 / 6H		HSS-E	bright	M 3 - M24	824	103	871
DIN 376	N R40	C	ISO 2 / 6H		HSS-E	steam tempered	M 3 - M36	826	103	871
DIN 376	N R40	C	ISO 3 / 6G		HSS-E	bright	M 3 - M24	848	103	871
DIN 376	N R40	C	ISO 2 / 6H		HSS-E	bright	M 3 - M24	890	103	871
DIN 376	N R40	C	ISO 2 / 6H		HSS-E	S	M 3 - M30	917	103	871
DIN 376	N R15	C	ISO 2 / 6H		HSS-E	steam tempered	M 3 - M20	949	103	871
DIN 376	H R40	C	ISO 2 / 6H		HSS-E	nitrided	M 3 - M30	950	103	871
DIN 376	H R40	C	ISO 2 / 6H		HSS-E	C	M 3 - M30	1917	103	871
DIN 376	N R40	C	ISO 2 / 6H		HSS-E	A + M	M 3 - M16	2426	103	871
DIN 376	N R40	C	6HX		HSS-E	S	M 3 - M24	2441	103	871
DIN 376	N	B	ISO 2 / 6H		HSS-E	S	M 3 - M24	315	103	872
DIN 376	H	B	ISO 2 / 6H		HSS-E	steam tempered	M 3 - M24	734	103	872
DIN 376	N	D	ISO 2 / 6H		HSS-E	bright	M 2 - M27	813	103	872

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Machine taps for ISO metric threads

Standard	Type	Form	Tolerance	Tool illustration	Tool material	Surface	d1	Guhring no.	Discount group	Standard range page
DIN 376	N	B	ISO 2 / 6H		HSS-E	○	M 1,6 - M48	815	103	873
DIN 376	H	B	ISO 2 / 6H		HSS-E	○	M 3 - M24	816	103	873
DIN 376	GG	C	6HX		HSS-E	●	M 3 - M30	819	103	873
DIN 376	N L15	D	ISO 2 / 6H		HSS-E	○	M 3 - M22	820	103	873
DIN 376	N	B	ISO 3 / 6G		HSS-E	○	M 2 - M45	845	103	873
DIN 376	N	B	ISO 2 / 6H		HSS-E	○	M 3 - M10	847	103	873
DIN 376	N	B	ISO 2 / 6H		HSS-E	S	M 1,8 - M52	915	103	873
DIN 376	GG	C	6HX		HSS-E	S	M 3 - M24	931	103	874
DIN 376	N	B	ISO 2 / 6H		HSS-E	●	M 2,5 - M36	948	103	874
DIN 376	VA	B	ISO 2 / 6H		HSS-E	○	M 3 - M30	1872	103	874
DIN 376	H	B	ISO 2 / 6H		HSS-E	C	M 3 - M24	1915	103	875
DIN 376	GG	C	6HX		HSS-E	A	M 3 - M20	1919	103	875
DIN 376	VA	B	6HX		HSS-E	S	M 3 - M30	2087	103	875
DIN 376	N	B	ISO 2 / 6H		HSS-E	A + M	M 3 - M16	2428	103	875
DIN 376	N	B	ISO 2 / 6H		HSS-E	●	M 3 - M36	2877	103	875

C TiCN Cb Carbo D Cristall F FIRE/nanoFIRE P AlCrN S TiN S+ TiN+ M MolyGlide Y Signum

Standard	Type	Form	Tolerance	Tool illustration	Tool material	Surface	d1	Guhring no.	Discount group	Standard range page
Machine taps for ISO metric threads										
DIN 376	H	B	ISO 2 / 6H		HSS-E	●	M 3 - M24	2942	103	875
Guhring std.	N	B	ISO 2 / 6H		HSS-E	○	M 3 - M20	998	103	876
Machine taps for ISO metric fine threads										
DIN 374	VA R50	C	6HX		HSS-E-PM	S	M 8 X1 - M20 X1,5	764	103	877
DIN 374	N R40	C(K)	ISO 2 / 6H		HSS-E	S	M 6 X0,7 - M24 X1,5	273	103	878
DIN 374	N	C	ISO 3 / 6G		HSS-E	○	M 6 X0,75 - M63 X1,5	829	103	878
DIN 374	N	C	ISO 2 / 6H		HSS-E	○	M 3 X0,35 - M38 X1,5	830	103	878
DIN 374	N R15	C	ISO 2 / 6H		HSS-E	○	M 5 X0,5 - M30 X2	833	103	878
DIN 374	N R40	C	ISO 2 / 6H		HSS-E	○	M 3 X0,35 - M30 X2	834	103	878
DIN 374	H R40	C	ISO 2 / 6H		HSS-E	○	M 8 X0,75 - M24 X1,5	835	103	879
DIN 374	N R40	C	ISO 2 / 6H		HSS-E	S	M 3 X0,35 - M24 X2	852	103	879
DIN 374	N R40	C	ISO 3 / 6G		HSS-E	S	M 8 X1 - M20 X1,5	1049	103	879
DIN 374	VA R15	C	ISO 2 / 6H		HSS-E	●	M 4 X0,5 - M20 X2	1874	103	879
DIN 374	N R15	C	ISO 2 / 6H		HSS-E	S	M 4 X0,5 - M30 X2	1971	103	879
DIN 374	N R40	C	ISO 2 / 6H		HSS-E	○	M 6 X0,75 - M24 X2	2424	103	879

○ bright ● steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

Machine taps for ISO metric fine threads

Standard	Type	Form	Tolerance	Tool illustration	Tool material	Surface	d1	Guhring no.	Discount group	Standard range page
DIN 374	N R40	E	ISO 2 / 6H		HSS-E	○	M10 X1 - M14 X1,5	2792	103	879
DIN 374	N R15	C	ISO 2 / 6H		HSS-E	●	M 4 X0,5 - M30 X2	2838	103	879
DIN 374	N R40	C	ISO 2 / 6H		HSS-E	●	M 5 X0,5 - M30 X1,5	2843	103	879
DIN 374	H R40	C	ISO 2 / 6H		HSS-E	●	M 6 X0,75 - M24 X1,5	2852	103	879
DIN 374	N R40	C	ISO 2 / 6H		HSS-E	●	M 5 X0,5 - M30 X2	2853	103	879
DIN 374	VA R40	C	ISO 2 / 6H		HSS-E	●	M 3 X0,35 - M24 X1,5	2864	103	882
DIN 374	VA R15	C	ISO 2 / 6H		HSS-E	(S)	M 4 X0,5 - M24 X1,5	2897	103	882
DIN 374	H R40	C	ISO 2 / 6H		HSS-E	●	M 6 X0,75 - M20 X1,5	2940	103	882
DIN 374	H R40	C	ISO 3 / 6G		HSS-E	○	M 8 X1 - M20 X1,5	2987	103	882
DIN 374	H R40	C	ISO 3 / 6G		HSS-E	●	M 8 X1 - M20 X1,5	2988	103	882
DIN 374	H R40	C	ISO 3 / 6G		HSS-E	(S)	M 8 X1 - M20 X1,5	2989	103	883
DIN 374	N R40	C	ISO 3 / 6G		HSS-E	○	M 8 X1 - M20 X1,5	2998	103	883
DIN 374	N R40	C	ISO 3 / 6G		HSS-E	●	M 8 X1 - M18 X1,5	2999	103	883
DIN 374	N R15	C	ISO 2 / 6H	NEW	HSS-E	(C)	M 8 X1 - M16 X1,5	4156	103	883
DIN 374	N R15	E	ISO 2 / 6H	NEW	HSS-E	(C)	M 8 X1 - M16 X1,5	4157	103	883

(C) TiCN (Cb) Carbo (D) Cristall (F) FIRE/nanoFIRE (P) AlCrN (S) TiN (S+) TiN+ (M) MolyGlide (Y) Signum

Machine taps for ISO metric fine threads

Standard	Type	Form	Tolerance	Tool illustration	Tool material	Surface	d1	Guhring no.	Discount group	Standard range page
DIN 374	H R15	C	ISO 2 / 6H		HSS-E-PM	bright	M 8 X1 - M16 X1,5	874	103	883
DIN 374	VA R40	C	ISO 2 / 6H		HSS-E-PM	bright	M 8 X1 - M20 X1,5	936	103	883
DIN 374	VA R40	C	ISO 2 / 6H	NEW	HSS-E-PM	S	M12 X1,5 - M20 X1,5	1004	103	883
DIN 374	N R50	C	ISO 2 / 6H		HSS-E-PM	S	M 8 X1 - M20 X1,5	1100	103	883
DIN 374	N R40	C	ISO 2 / 6H		HSS-E-PM	S	M 8 X1 - M24 X2	1292	103	883
DIN 374	GG	C	6HX		HSS-E	A	M 3 X0,3 - M24 X1,5	169	103	884
DIN 374	N	B	ISO 3 / 6G		HSS-E	bright	M 6 X0,7 - M20 X1,5	316	103	884
DIN 374	H	B	ISO 2 / 6H		HSS-E	bright	M 3 X0,35 - M30 X1,5	828	103	884
DIN 374	GG	C	6HX		HSS-E	nitrided	M 3 X0,35 - M30 X1,5	831	103	884
DIN 374	VA	B	ISO 2 / 6H		HSS-E	bright	M 6 X0,75 - M24 X2	1873	103	884
DIN 374	VA	B	ISO 2 / 6H		HSS-E	steam tempered	M 3 X0,35 - M24 X1,5	2871	103	885
DIN 374	N	B	ISO 2 / 6H		HSS-E	A + M	M 5 X0,5 - M24 X1,5	2878	103	885
DIN 374	N	B	ISO 2 / 6H		HSS-E	steam tempered	M 3 X0,35 - M50 X1,5	2879	103	885
DIN 374	H	B	ISO 2 / 6H		HSS-E	nitrided	M 3 X0,35 - M20 X1,5	2943	103	885
DIN 374	H	B	ISO 3 / 6G		HSS-E	steam tempered	M 8 X1 - M20 X1,5	2982	103	885

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Machine taps for ISO metric fine threads

Standard	Type	Form	Tolerance	Tool illustration		Tool material	Surface	d1	Guhring no.	Discount group	Standard range page
DIN 374	H	B	ISO 3 / 6G			HSS-E	S	M 8 X1 - M20 X1,5	2983	103	885
DIN 374	N	B	ISO 3 / 6G			HSS-E		M 8 X1 - M18 X1,5	2992	103	885
DIN 374	N	B	ISO 3 / 6G			HSS-E	S	M 8 X1 - M18 X1,5	2993	103	885
DIN 374	VA	B	ISO 2 / 6H			HSS-E-PM		M 8 X1 - M14 X1,5	887	103	885
DIN 374	VA	B	ISO 2 / 6H		NEW	HSS-E-PM	S	M 4 X0,5 - M20 X1,5	1001	103	885
DIN 374	N	B	6HX			Solid carbide	C	M14 X1,25 - M16 X1,5	944	103	886
DIN 374	N	B	ISO 2 / 6H			HSS-E		M 3 X0,35 - M45 X1,5	827	103	887
DIN 374	N	B	ISO 2 / 6H			HSS-E	S	M 3 X0,35 - M36 X1,5	832	103	887
DIN 374	GG	C	6HX			HSS-E	S	M 3 X0,35 - M22 X1,5	932	103	887
DIN 374	N	B	ISO 2 / 6H			HSS-E		M 3 X0,35 - M32 X1,5	2888	103	889
DIN 374	N	B	ISO 2 / 6H			HSS-E-PM	S	M 8 X1 - M24 X2	1291	103	889
~ DIN 371	N	B	6HX			Solid carbide	C	M 5 X0,5 - M12 X1,5	943	103	890
DIN 371	Ti	B	4HX		NEW	HSS-E-PM	C	MJ 6X0,5 - MJ 10X1,25	1058	103	891
DIN 371	Ti R15	C	4HX		NEW	HSS-E-PM	C	MJ 6X0,5 - MJ 10X1,25	1062	103	891
DIN 371	Ni R10	C	4HX		NEW	HSS-E-PM	A	MJ 6X0,5 - MJ 10X1,25	1066	103	891

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

Standard	Type	Form	Tolerance	Tool illustration		Tool material	Surface	d1	Guhring no.	Discount group	Standard range page
Machine taps for ISO metric fine threads											
DIN 371	Ti	B	6HX		NEW	HSS-E-PM	C	M 3 X0,35 - M10 X1	2903	103	892
DIN 371	Ti R15	C	6HX		NEW	HSS-E-PM	C	M 3 X0,35 - M10 X1	2910	103	892
DIN 371	Ni	B	6HX			HSS-E-PM	A	M 3 X0,35 - M10 X1,25	2917	103	892
DIN 371	Ni R10	C	6HX			HSS-E-PM	A	M 3 X0,35 - M10 X1,25	2921	103	892
DIN 371	H	D	6HX		NEW	HSS-E-PM	C	M 8 X1 - M12 X1,5	4161	103	893
~ DIN 371	H	D	ISO 2 / 6H			Solid carbide	C	M 6 X0,5 - M12 X1,5	1161	103	894
Machine taps for UNC-threads											
~ DIN 371	N R40	C	2B			HSS-E	○	NR. 2 -56 - 3/8 -16	876	103	895
~ DIN 371	N R40	C(K)	2B			HSS-E	S	NR.10 -24 - 3/8 -16	1837	103	895
~ DIN 371	N	C	2B			HSS-E	○	NR. 3 -48 - 3/8 -16	1977	103	895
~ DIN 371	N R15	C	2B			HSS-E	○	NR. 3 -48 - 3/8 -16	1978	103	895
~ DIN 371	VA R40	C	2B			HSS-E	○	NR. 2 -56 - 3/8 -16	1981	103	895
~ DIN 371	N R15	C	2B			HSS-E	●	NR. 4 -40 - 3/8 -16	2839	103	896
~ DIN 371	N R40	C	2B			HSS-E	●	NR. 2 -56 - 3/8 -16	2844	103	896
~ DIN 371	N R40	C	2B			HSS-E	○	NR. 3 -48 - 3/8 -16	2854	103	896

○ bright ● steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

Machine taps for UNC-threads

Standard	Type	Form	Tolerance	Tool illustration	Tool material	Surface	d1	Guhring no.	Discount group	Standard range page
~ DIN 371	N R40	C	2B		HSS-E	●	NR. 2 -56 - 3/8 -16	2855	103	896
~ DIN 371	VA R40	C	2B		HSS-E	●	NR. 2 -56 - 3/8 -16	2865	103	896
~ DIN 376	N R40	C	2B		HSS-E	○	7/16-14 - 1 - 8	881	103	897
~ DIN 376	N	C	2B		HSS-E	○	7/16-14 - 1 - 8	1982	103	897
~ DIN 376	N R15	C	2B		HSS-E	○	7/16-14 - 7/8 - 9	1983	103	897
~ DIN 376	VA R40	C	2B		HSS-E	○	7/16-14 - 7/8 - 9	1986	103	897
~ DIN 376	N R15	C	2B		HSS-E	●	1/2 -13 - 1 - 8	2840	103	897
~ DIN 376	N R40	C	2B		HSS-E	●	7/16-14 - 1 - 8	2845	103	898
~ DIN 376	N R40	C	2B		HSS-E	○	7/16-14 - 1 - 8	2856	103	898
~ DIN 376	N R40	C	2B		HSS-E	●	7/16-14 - 7/8 - 9	2857	103	898
~ DIN 376	VA R40	C	2B		HSS-E	●	7/16-14 - 7/8 - 9	2866	103	898
~ DIN 371	N	B	2B		HSS-E	○	NR. 1 -6 - 3/8 -16	873	103	899
~ DIN 371	GG	C	2B		HSS-E	●	NR. 3 -48 - 3/8 -16	1979	103	899
~ DIN 371	VA	B	2B		HSS-E	○	NR. 4 -40 - 3/8 -16	1980	103	899
~ DIN 371	VA	B	2B		HSS-E	●	NR. 4 -40 - 3/8 -16	2872	103	899

C TiCN Cb Carbo D Cristall F FIRE/nanoFIRE P AlCrN S TiN S+ TiN+ M MolyGlide Y Signum

Machine taps for UNC-threads

Standard	Type	Form	Tolerance	Tool illustration	Tool material	Surface	d1	Guhring no.	Discount group	Standard range page
~ DIN 371	N	B	2B		HSS-E	A + M	NR. 4 -40 - NR.12 -2	2880	103	899
~ DIN 371	N	B	2B		HSS-E	steam tempered	NR. 4 -40 - 3/8 -16	2881	103	900
~ DIN 371	N	B	2B		HSS-E	steam tempered	NR. 3 -4 - 3/8 -16	2889	103	900
~ DIN 371	Ti	B	2BX		HSS-E-PM	C	NR. 6 -3 - 3/8 -16	2905	103	900
~ DIN 371	Ni	B	2BX		HSS-E-PM	A	NR. 6 -32 - 3/8 -16	2918	103	900
~ DIN 376	N	B	2B		HSS-E	bright	7/16-14 - 1 1/4 -7	878	103	901
~ DIN 376	GG	C	2B		HSS-E	nitrided	7/16-14 - 3/4 -10	1984	103	901
~ DIN 376	VA	B	2B		HSS-E	bright	1/2 -13 - 1 - 8	1985	103	901
~ DIN 376	VA	B	2B		HSS-E	steam tempered	1/2 -13 - 1 - 8	2873	103	901
~ DIN 376	N	B	2B		HSS-E	steam tempered	7/16-14 - 1 - 8	2883	103	901
~ DIN 376	N	B	2B		HSS-E	steam tempered	1/2 -13 - 1 1/4 -	2890	103	902
~ DIN 371 / ~ DIN 376	Ti R15	C	2BX		HSS-E-PM	C	NR. 4 -40 - 5/8 -11	2912	103	903
~ DIN 371 / ~ DIN 376	Ni R10	C	2BX		HSS-E-PM	A	NR. 4 -40 - 5/8 -11	2922	103	903
~ DIN 371 / ~ DIN 376	Ti	B	3BX	NEW	HSS-E-PM	C	NR. 6 -32 - 5/8 -11	1059	103	904
~ DIN 371 / ~ DIN 376	Ti R15	C	3BX	NEW	HSS-E-PM	C	NR. 6 -32 - 5/8 -11	1063	103	904

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Standard	Type	Form	Tolerance	Tool illustration		Tool material	Surface	d1	Guhring no.	Discount group	Standard range page
Machine taps for UNC-threads											
~ DIN 371 / ~ DIN 376	Ni R10	C	3BX		NEW	HSS-E-PM	A	NR. 6 -32 - 5/8 -11	1067	103	904
Machine taps for UNF-threads											
~ DIN 374	N R40	C	2B			HSS-E		NR. 3 -56 - 1 -12	911	103	905
~ DIN 374	N R40	C(K)	2B			HSS-E	S	NR.10 -32 - 1 -12	1838	103	905
~ DIN 374	N	C	2B			HSS-E		NR. 3 -56 - 1 -12	1987	103	905
~ DIN 374	N R15	C	2B			HSS-E		NR. 3 -56 - 1 -12	1988	103	905
~ DIN 374	VA R15	C	2B			HSS-E		NR.10 -32 - 5/8 -18	1991	103	905
~ DIN 374	N R15	C	2B			HSS-E		3/8 -24 - 3/4 -16	2841	103	906
~ DIN 374	N R40	C	2B			HSS-E		NR.10 -32 - 7/8 -14	2846	103	906
~ DIN 374	N R40	C	2B			HSS-E		NR. 8 -36 - 7/8 -14	2858	103	907
~ DIN 374	N R40	C	2B			HSS-E		NR. 4 -48 - 7/8 -14	2859	103	907
~ DIN 374	VA R40	C	2B			HSS-E		1/4 -28 - 1 -12	2867	103	907
~ DIN 374	VA R40	C	2B			HSS-E		NR. 3 -56 - 7/8 -14	2868	103	907
~ DIN 374	VA R15	C	2B			HSS-E	S	NR. 4 -48 - 1 -12	2898	103	907
~ DIN 374	N	B	2B			HSS-E		NR. 3 -56 - 1 1/4 -12	908	103	908

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Standard	Type	Form	Tolerance	Tool illustration		Tool material	Surface	d1	Guhring no.	Discount group	Standard range page
Machine taps for UNF-threads											
~ DIN 374	GG	C	2B			HSS-E	●	NR. 3 -56 - 1 -12	1989	103	908
~ DIN 374	VA	B	2B			HSS-E	○	NR. 3 -56 - 3/8 -24	1990	103	909
~ DIN 374	VA	B	2B			HSS-E	◐	NR. 6 -40 - 7/8 -14	2874	103	909
~ DIN 374	N	B	2B			HSS-E	A + M	NR. 4 -48 - 1 -12	2884	103	909
~ DIN 374	N	B	2B			HSS-E	◐	NR. 4 -48 - 7/8 -14	2885	103	909
~ DIN 374	N	B	2B			HSS-E	◐	NR. 3 -56 - 1 1/8 -1	2891	103	909
~ DIN 371	Ti	B	2BX			HSS-E-PM	C	NR. 6 -4 - 3/8 -24	2907	103	910
~ DIN 371	Ni	B	2BX			HSS-E-PM	A	NR. 6 -40 - 3/8 -24	2919	103	910
~ DIN 371 / ~ DIN 374	Ti R15	C	2BX			HSS-E-PM	C	NR. 4 -48 - 5/8 -18	2914	103	910
~ DIN 371 / ~ DIN 374	Ni R10	C	2BX			HSS-E-PM	A	NR. 4 -48 - 5/8 -18	2923	103	910
~ DIN 371 / ~ DIN 374	Ti	B	3BX		NEW	HSS-E-PM	C	NR. 6 -40 - 5/8 -18	1060	103	911
~ DIN 371 / ~ DIN 374	Ti R15	C	3BX		NEW	HSS-E-PM	C	NR. 6 -40 - 5/8 -18	1064	103	911
~ DIN 371 / ~ DIN 374	Ni R10	C	3BX		NEW	HSS-E-PM	A	NR. 6 -40 - 5/8 -18	1068	103	911
Machine taps for BSW-threads											
~ DIN 376	N R40	C				HSS-E	◐	W 3/8 - W1	2848	103	912

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Standard	Type	Form	Tolerance	Tool illustration	Tool material	Surface	d1	Guhring no.	Discount group	Standard range page
Machine taps for BSW-threads										
~ DIN 371	N R40	C			HSS-E		W 1/8 - W 3/8	2847	103	913
~ DIN 376	N	B			HSS-E		W 7/16 - W1	2893	103	913
~ DIN 371	N	B			HSS-E		W 1/8 - W 3/8	2892	103	914
Machine taps for BSP-threads										
DIN 5156	VA R40	C		NEW	HSS-E-PM	S	G 1/16 - G 1/2	4159	103	915
DIN 5156	N R40	C(K)			HSS-E	S	G 1/8 - G1 1/2	937	103	916
DIN 5156	N	C			HSS-E		G 1/16 - G2	963	103	916
DIN 5156	N R15	C			HSS-E		G 1/8 - G1	964	103	916
DIN 5156	N R40	C			HSS-E		G 1/16 - G1 1/2	965	103	917
DIN 5156	VA R40	C			HSS-E		G 1/16 - G1 1/2	968	103	917
DIN 5156	N R15	C			HSS-E		G 1/8 - G1	2842	103	917
DIN 5156	N R40	C			HSS-E		G 1/8 - G1	2849	103	917
DIN 5156	N R40	C			HSS-E		G 1/8 - G1	2860	103	917
DIN 5156	N R40	C			HSS-E		G 1/8 - G2	2861	103	917
DIN 5156	N R15	E		NEW	HSS-E	C	G 1/16 - G1	4158	103	917

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Standard	Type	Form	Tolerance	Tool illustration	Tool material	Surface	d1	Guhring no.	Discount group	Standard range page
Machine taps for BSP-threads										
DIN 5156	VA R40	C			HSS-E-PM	○	G 1/8 - G 1/2	939	103	917
DIN 5156	GG	C			HSS-E	●	G 1/16 - G2	961	103	918
DIN 5156	N	B			HSS-E	○	G 1/8 - G2	962	103	918
DIN 5156	VA	B			HSS-E	○	G 1/16 - G 7/8	967	103	919
DIN 5156	VA	B			HSS-E	◐	G 1/8 - G1	2875	103	919
DIN 5156	N	B			HSS-E	A + M	G 1/8 - G 5/8	2886	103	919
DIN 5156	N	B			HSS-E	◐	G 1/8 - G2	2887	103	919
DIN 5156	N	B			HSS-E	◐	G 1/8 - G1	2894	103	919
DIN 5156	VA	B			HSS-E-PM	○	G 1/8 - G 1/8	938	103	919
Machine taps for NPT-threads										
Guhring std.	VA R25	C			HSS-E	S	1/8 - 3/4	1088	103	920
Guhring std.	VA R25	C			HSS-E	◐	1/8 - 3/4	1087	103	920
Machine taps for NPTF-threads										
Guhring std.	VA R25	C		NEW	HSS-E	S	1/16 - 1	4127	103	921

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Standard	Type	Form	Tolerance	Tool illustration	Tool material	Surface	d1	Guhring no.	Discount group	Standard range page
Machine taps for EG-threads										
DIN 40435	N R40	C	6H mod	NEW	HSS-E	S	EG M 4 - EG M16	1011	103	922
DIN 40435	N	B	6H mod	NEW	HSS-E	S	EG M 4 - EG M16	1010	103	923
Oil feed taps for ISO metric threads										
DIN 371	N R15	C	ISO 2 / 6H		HSS-E		M 5 - M10	1891	103	924
DIN 371	VA R40	C	ISO 2 / 6H		HSS-E		M 5 - M10	1892	103	924
DIN 371	N R40	C	ISO 2 / 6H		HSS-E		M 5 - M10	1893	103	924
DIN 371	H R40	C	ISO 2 / 6H		HSS-E		M 5 - M10	1894	103	925
DIN 371	N R15	C	ISO 2 / 6H		HSS-E	S	M 5 - M10	2436	103	925
DIN 371	N R40	C	ISO 2 / 6H		HSS-E	S	M 5 - M10	2438	103	925
DIN 371	N R40	C	ISO 2 / 6H		HSS-E	A + M	M 5 - M10	2514	103	925
DIN 371	N R50	C	ISO 2 / 6H		HSS-E-PM	C	M 5 - M10	1152	103	925
DIN 371	H R15	C	6HX		HSS-E-PM	C	M 6 - M10	1188	103	925
DIN 376	N R15	C	ISO 2 / 6H		HSS-E		M12 - M16	1898	103	926
DIN 376	VA R40	C	ISO 2 / 6H		HSS-E		M12 - M20	1899	103	926
DIN 376	H R40	C	ISO 2 / 6H		HSS-E		M12 - M20	1901	103	927

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Oil feed taps for ISO metric threads

Standard	Type	Form	Tolerance	Tool illustration	Tool material	Surface	d1	Guhring no.	Discount group	Standard range page
DIN 376	N R15	C	ISO 2 / 6H		HSS-E	S	M12 - M20	2437	103	927
DIN 376	N R40	C	ISO 2 / 6H		HSS-E	S	M12 - M20	2439	103	927
DIN 376	H R15	C	6HX		HSS-E-PM	C	M12 - M24	1194	103	927
DIN 376	N R50	C	ISO 2 / 6H		HSS-E-PM	S	M12 - M20	1293	103	927
DIN 371	H	C	6HX		Solid carbide	bright	M 3 - M10	969	103	928
DIN 371	N R15	C	6HX		Solid carbide	bright	M 3 - M10	971	103	928
DIN 371	H	E	6HX	NEW	Solid carbide	bright	M 3 - M10	1008	103	929
DIN 371	H	C	6HX		Solid carbide	bright	M 5 - M10	1858	103	929
DIN 371	H	C	6HX		Solid carbide	A	M 5 - M10	2311	103	929
DIN 371	H	C	6HX		Solid carbide	A	M 5 - M10	2506	103	929
DIN 371	N R15	C	6HX		Solid carbide	A	M 5 - M10	2510	103	929
DIN 371	N R15	C	6HX		Solid carbide	M	M 5 - M10	2516	103	929
DIN 376	H	C	6HX		Solid carbide	bright	M12 - M20	1859	103	930
DIN 376	H	C	6HX		Solid carbide	bright	M12 - M20	1883	103	930
DIN 371	GG	C	6HX		HSS-E	A	M 5 - M10	318	103	931

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Oil feed taps for ISO metric threads

Standard	Type	Form	Tolerance	Tool illustration	Tool material	Surface	d1	Guhring no.	Discount group	Standard range page
DIN 371	GG	C	6HX		HSS-E	●	M 5 - M10	1890	103	931
DIN 371	N	B	ISO 2 / 6H		HSS-E	A + M	M 5 - M10	2517	103	931
DIN 371	H	C	6HX		HSS-E-PM	C	M 5 - M10	302	103	931
DIN 371	H	E	6HX		HSS-E-PM	C	M 5 - M10	1091	103	931
DIN 376	GG	C	6HX		HSS-E	A	M12 - M20	319	103	932
DIN 376	GG	C	6HX		HSS-E	●	M12 - M20	1897	103	932
DIN 376	N AZ	E	ISO 2 / 6H		HSS-E	A + M	M 5 - M12	2899	103	933
DIN 376	H	C	6HX		HSS-E-PM	C	M10 - M14	297	103	933
DIN 376	H	E	6HX	NEW	HSS-E-PM	C	M10 - M20	4165	103	933
DIN 371	VA R50	C	6HX		HSS-E-PM	C	M 5 - M10	1139	103	934
DIN 376	VA R50	C	6HX		HSS-E-PM	C	M12 - M20	1142	103	934

Oil feed taps for ISO metric fine threads

DIN 374	VA R50	C	6HX		HSS-E-PM	C	M 8 X1 - M20 X1,5	1144	103	935
DIN 374	N R15	C	ISO 2 / 6H		HSS-E	○	M 5 X0,5 - M20 X1,5	1905	103	936
DIN 374	VA R40	C	ISO 2 / 6H		HSS-E	○	M 5 X0,5 - M16 X1,5	1906	103	936

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Oil feed taps for ISO metric fine threads

Standard	Type	Form	Tolerance	Tool illustration	Tool material	Surface	d1	Guhring no.	Discount group	Standard range page
DIN 374	H R40	C	ISO 2 / 6H		HSS-E	bright	M 6 X0,75 - M20 X1,5	1907	103	936
DIN 374	H R15	C	6HX		HSS-E-PM	C	M 6 X0,75 - M24 X1,5	1200	103	936
DIN 374	N R50	C	ISO 2 / 6H		HSS-E-PM	S	M 8 X1 - M20 X1,5	1294	103	936
DIN 374	GG	C	6HX		HSS-E	A	M 8 X1 - M24 X1,5	347	103	937
DIN 374	GG	C	6HX		HSS-E	bright	M 8 X1 - M20 X1,5	1904	103	937
DIN 374	H	E	6HX	NEW	HSS-E-PM	C	M 5 X0,5 - M16 X1,5	1007	103	937
DIN 374	H	C	6HX		HSS-E-PM	C	M 5 X0,5 - M16 X1,5	1090	103	937
DIN 371	H	C	6HX		Solid carbide	bright	M 5 X0,5 - M10 X1	972	103	938
DIN 371	N L15	D	6HX		Solid carbide	bright	M 4 X0,5 - M 8 X1	975	103	938
DIN 371	N R15	C	6HX		Solid carbide	bright	M 4 X0,5 - M10 X1	977	103	938
DIN 371	H	C	6HX		Solid carbide	bright	M 5 X0,5 - M10 X1	1861	103	939
DIN 374	H	C	6HX		Solid carbide	bright	M12 X1,5 - M20 X1,5	974	103	939
DIN 374	N L15	D	6HX		Solid carbide	bright	M12 X1,5 - M18 X1,5	976	103	939
DIN 374	N R15	C	6HX		Solid carbide	bright	M12 X1,5 - M20 X1,5	978	103	939
DIN 374	H	E	6HX	NEW	Solid carbide	bright	M10 X1 - M16 X1,5	1009	103	939

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Standard	Type	Form	Tolerance	Tool illustration	Tool material	Surface	d1	Guhring no.	Discount group	Standard range page
Oil feed taps for ISO metric fine threads										
DIN 374	H	C	6HX		Solid carbide	○	M12 X1,5 - M20 X1,5	1860	103	939
Oil feed taps for UNC threads										
~ DIN 371	GG	C	2B		HSS-E	A	NR.10 -24 - 3/8 -16	1085	103	940
~ DIN 376	GG	C	2B		HSS-E	A	7/16-14 - 7/8 - 9	1086	103	940
Oil feed taps for UNF threads										
~ DIN 374	GG	C	2B		HSS-E	A	NR.10 -32 - 7/8 -14	1082	103	941
Machine nut taps for ISO metric threads										
DIN 357	N		ISO 2 / 6H		HSS-E	○	M 3 - M30	851	103	942
Machine combination drill taps for ISO metric threads										
Guhring std.	N	D	ISO 2 / 6H		HSS-E	○	M 3 - M12	1839	103	943

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Standard	Type	Form	Tolerance	Tool illustration	Tool material	Surface	d1	Guhring no.	Discount group	Standard range page
Fluteless machine taps for ISO metric threads										
~ DIN 371	N	C	6HX		HSS-E	S	M 2 - M10	921	103	944
~ DIN 371	N	C	6GX		HSS-E	S	M 2 - M10	920	103	944
~ DIN 371	N	C	6HX		HSS-E-PM	S	M 2 - M10	1255	103	944
~ DIN 371	N	C	6HX		HSS-E-PM	Cb	M 2 - M10	1347	103	945
~ DIN 371	N	C	6GX		HSS-E-PM	S	M 2 - M10	903	103	945
~ DIN 371	N	C	6GX		HSS-E-PM	Cb	M 2,5 - M 8	1565	103	945
~ DIN 376	N	C	6HX		HSS-E	S	M12 - M18	925	103	945
~ DIN 376	N	C	6GX		HSS-E	S	M12 - M20	924	103	945
~ DIN 376	N	C	6HX		HSS-E-PM	S	M12 - M20	1256	103	945
~ DIN 376	N	C	6GX		HSS-E-PM	S	M12 - M20	952	103	945
~ DIN 376	N	C	6GX		HSS-E-PM	Cb	M14 - M20	1567	103	945
Fluteless machine taps for ISO metric fine threads										
~ DIN 371	N	C	6GX		HSS-E	S	M10 X1 - M10 X1	1280	103	946
~ DIN 371	N	C	6HX		HSS-E-PM	S	M 8 X1 - M10 X1	1257	103	946
~ DIN 371	N	C	6HX		HSS-E-PM	Cb	M 8 X1 - M10 X1	1568	103	947

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Standard	Type	Form	Tolerance	Tool illustration	Tool material	Surface	d1	Guhring no.	Discount group	Standard range page
Fluteless machine taps for ISO metric fine threads										
~ DIN 371	N	C	6GX		HSS-E-PM	S	M 8 X1 - M10 X1,2	1740	103	947
~ DIN 371	N	C	6GX		HSS-E-PM	Cb	M 8 X1 - M10 X1	1569	103	947
~ DIN 374	N	C	6HX		HSS-E-PM	S	M12 X1 - M24 X2	1258	103	947
~ DIN 374	N	C	6GX		HSS-E-PM	Cb	M12 X1 - M24 X1,5	1580	103	947
~ DIN 374	N	C	6HX		HSS-E	S	M 8 X1 - M24 X1,5	929	103	948
~ DIN 374	N	C	6GX		HSS-E	S	M 8 X1 - M18 X1,5	928	103	948
Fluteless machine taps for UNC-threads										
~ DIN 371	N	C	2BX		HSS-E	S	NR.10 -24 - 3/8 -16	2273	103	949
~ DIN 376	N	C	2BX		HSS-E	S	7/16-14 - 7/8 - 9	2274	103	949
Fluteless machine taps for UNF-threads										
~ DIN 371	N	C	2BX		HSS-E	S	NR.10 -32 - 3/8 -24	1283	103	950
~ DIN 374	N	C	2BX		HSS-E	S	NR.10 -32 - 1 -12	2275	103	951
Fluteless machine taps for BSP-threads										
DIN 2189	N	C			HSS-E	S	G 1/8 - G1 1/4	966	103	952

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Standard	Type	Form	Tolerance	Tool illustration	Tool material	Surface	d1	Guhring no.	Discount group	Standard range page
Oil feed fluteless taps f. ISO metric threads										
~ DIN 371	N	C	6HX		Solid carbide	S	M 5 - M16	2518	103	953

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Fluteless machine taps for ISO metric threads

Standard	Type	Form	Tolerance	Tool illustration	Tool material	Surface	d1	Guhring no.	Discount group	Standard range page
~ DIN 371	N	C	6HX		HSS-E-PM	S	M 3 - M10	322	103	954
~ DIN 376	N	C	6HX		HSS-E-PM	S	M12 - M16	339	103	954
~ DIN 371	N	C	6HX		HSS-E	C	M 3 - M10	2012	103	955
~ DIN 371	N	C	6HX		HSS-E	S	M 3 - M10	919	103	956
~ DIN 371	N	C	6HX		HSS-E	P	M 3 - M10	1587	103	956
~ DIN 371	N	C	6GX		HSS-E	S	M 3 - M10	918	103	956
~ DIN 371	N	C	6GX		HSS-E	P	M 3 - M10	1588	103	956
~ DIN 371	N	C	6HX		HSS-E-PM	S	M 3 - M10	1266	103	957
~ DIN 371	N	C	6HX		HSS-E-PM	P	M 3 - M10	1599	103	957
~ DIN 371	N	C	6GX		HSS-E-PM	P	M 3 - M10	1705	103	957
~ DIN 376	N	C	6HX		HSS-E	C	M12 - M20	2013	103	957
~ DIN 376	N	C	6GX		HSS-E	P	M12 - M20	1590	103	957
~ DIN 376	N	C	6HX		HSS-E-PM	S	M12 - M20	1267	103	957
~ DIN 376	N	C	6HX		HSS-E-PM	P	M12 - M20	1707	103	957
~ DIN 376	N	C	6GX		HSS-E-PM	P	M12 - M20	1708	103	957

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Standard	Type	Form	Tolerance	Tool illustration	Tool material	Surface	d1	Guhring no.	Discount group	Standard range page
Fluteless machine taps for ISO metric threads										
~ DIN 376	N	C	6HX		HSS-E	S	M 6 - M39	923	103	958
~ DIN 376	N	C	6HX		HSS-E	P	M 6 - M20	1589	103	958
~ DIN 376	N	C	6GX		HSS-E	S	M 6 - M20	922	103	958
Fluteless machine taps for ISO metric fine threads										
~ DIN 371	N	C	6HX		HSS-E-PM	S	M 6 X0,75 - M10 X1,25	1284	103	959
~ DIN 374	N	C	6HX		HSS-E	P	M12 X1 - M24 X1,5	1593	103	960
~ DIN 374	N	C	6GX		HSS-E	P	M12 X1 - M24 X1,5	1594	103	960
~ DIN 374	N	C	6HX		HSS-E-PM	S	M12 X1 - M24 X2	1269	103	960
~ DIN 374	N	C	6HX		HSS-E-PM	P	M12 X1 - M24 X1,5	1711	103	960
~ DIN 374	N	C	6GX		HSS-E-PM	P	M12 X1 - M24 X1,5	1712	103	960
~ DIN 371	N	C	6HX		HSS-E	S	M 6 X0,75 - M10 X1,25	1275	103	961
~ DIN 371	N	C	6HX		HSS-E	P	M 8 X1 - M10 X1	1591	103	961
~ DIN 371	N	C	6GX		HSS-E	S	M 8 X1 - M10 X1	1277	103	961
~ DIN 371	N	C	6GX		HSS-E	P	M 8 X1 - M10 X1	1592	103	961
~ DIN 371	N	C	6HX		HSS-E-PM	S	M 8 X1 - M10 X1,25	1268	103	961

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Standard	Type	Form	Tolerance	Tool illustration	Tool material	Surface	d1	Guhring no.	Discount group	Standard range page
Fluteless machine taps for ISO metric fine threads										
~ DIN 371	N	C	6GX		HSS-E-PM	P	M 8 X1 - M10 X1	1710	103	962
~ DIN 374	N	C	6HX		HSS-E-PM	S	M 8 X1 - M20 X1,5	333	103	963
~ DIN 374	N	C	6HX		HSS-E	S	M 6 X0,75 - M24 X1,5	927	103	964
~ DIN 374	N	C	6HX		HSS-E	C	M 6 X0,75 - M20 X1,5	2008	103	964
~ DIN 374	N	C	6GX		HSS-E	S	M 8 X1 - M22 X1,5	926	103	964
Fluteless machine taps for UNC-threads										
~ DIN 376	N	C	2BX		HSS-E	S	1/2 -13 - 3/4 -10	1583	103	965
~ DIN 371	N	C	2BX		HSS-E	S	NR. 4 -40 - 3/8 -16	1582	103	965
Fluteless machine taps for UNF-threads										
~ DIN 371	N	C	2BX		HSS-E	S	NR. 4 -48 - 3/8 -24	1584	103	966
~ DIN 374	N	C	2BX		HSS-E	S	7/16-20 - 3/4 -16	1585	103	966
Fluteless machine taps for BSP-threads										
DIN 2189	N	C			HSS-E	S	G 1/16 - G 3/4	1586	103	967
Oil feed fluteless taps f. ISO metric threads										
~ DIN 371	N	E	6HX		Solid carbide	A	M 3 - M10	1927	103	968

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Oil feed fluteless taps f. ISO metric threads

Standard	Type	Form	Tolerance	Tool illustration	Tool material	Surface	d1	Guhring no.	Discount group	Standard range page
~ DIN 371	N	C	6HX		Solid carbide	A	M 3 - M10	1972	103	968
~ DIN 371	N	C	6GX	NEW	HSS-E	Cb	M 5 - M20	4146	103	969
~ DIN 371	N	C	6HX		HSS-E	S	M 5 - M10	2442	103	969
~ DIN 371	N	C	6HX		HSS-E	C	M 5 - M10	2446	103	969
~ DIN 371	N	C	6HX		HSS-E	Cb	M 5 - M20	2515	103	969
~ DIN 371	N	C	6GX		HSS-E	S	M 5 - M10	2443	103	969
~ DIN 371	N	C	6GX		HSS-E	C	M 5 - M10	2447	103	970
~ DIN 371	N	C	6HX		HSS-E-PM	S+	M 5 - M10	323	103	970
~ DIN 376	N	C	6HX		Solid carbide	A	M12 - M20	1931	103	971
~ DIN 376	N	C	6HX		HSS-E	S	M12 - M16	2444	103	971
~ DIN 376	N	C	6HX		HSS-E	C	M12 - M16	2448	103	971
~ DIN 376	N	C	6GX		HSS-E	S	M12 - M16	2445	103	971
~ DIN 376	N	C	6HX		HSS-E-PM	S+	M12 - M16	342	103	971
~ DIN 371	N	E	6HX		HSS-E-PM	S	M 3 - M10	1725	103	972
~ DIN 371	N	C	6HX		HSS-E-PM	C	M 5 - M10	1270	103	972

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Oil feed fluteless taps f. ISO metric threads

Standard	Type	Form	Tolerance	Tool illustration	Tool material	Surface	d1	Guhring no.	Discount group	Standard range page
~ DIN 371	N	C	6HX		HSS-E-PM	A	M 5 - M10	1717	103	972
~ DIN 371	N	E	6GX		HSS-E-PM	S	M 3 - M10	1726	103	972
~ DIN 371	N	C	6GX		HSS-E-PM	C	M 5 - M10	1713	103	973
~ DIN 371	N	C	6GX		HSS-E-PM	A	M 5 - M10	1718	103	973
~ DIN 376	N	E	6HX		HSS-E-PM	S	M12 - M20	1727	103	973
~ DIN 376	N	C	6HX		HSS-E-PM	C	M12 - M20	1271	103	973
~ DIN 376	N	C	6HX		HSS-E-PM	A	M12 - M20	1719	103	973
~ DIN 376	N	E	6GX		HSS-E-PM	S	M12 - M20	1728	103	973
~ DIN 376	N	C	6GX		HSS-E-PM	C	M12 - M20	1714	103	973
~ DIN 376	N	C	6GX		HSS-E-PM	A	M12 - M20	1720	103	973
Guhring std.	N	C	6HX	NEW ≤M5	HSS-E-PM	S	M 3 - M20	4143	103	974

Oil feed fluteless taps f. ISO metric fine threads

Standard	Type	Form	Tolerance	Tool illustration	Tool material	Surface	d1	Guhring no.	Discount group	Standard range page
~ DIN 371	N	C	6HX	NEW	HSS-E	Cb	M 8 X1 - M16 X1,5	4147	103	975
~ DIN 371	N	C	6GX	NEW	HSS-E	Cb	M 8 X1 - M16 X1,5	4151	103	975
~ DIN 371	N	E	6HX		HSS-E-PM	S	M 8 X1 - M10 X1,2	1729	103	976

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Standard	Type	Form	Tolerance	Tool illustration	Tool material	Surface	d1	Guhring no.	Discount group	Standard range page
Oil feed fluteless taps f. ISO metric fine threads										
~ DIN 371 / ~ DIN 376	N	C	6HX		Solid carbide	A	M10 X1 - M24 X1,5	1581	103	977
~ DIN 371	N	C	6HX		HSS-E-PM	C	M 8 X1 - M10 X1,25	1272	103	978
~ DIN 371	N	C	6HX		HSS-E-PM	A	M 8 X1 - M10 X1,2	1721	103	978
~ DIN 371	N	E	6GX		HSS-E-PM	S	M 8 X1 - M10 X1,2	1730	103	978
~ DIN 371	N	C	6GX		HSS-E-PM	C	M 8 X1 - M10 X1,2	1715	103	979
~ DIN 374	N	E	6HX		HSS-E-PM	S	M12 X1 - M24 X1,5	1731	103	979
~ DIN 374	N	C	6HX		HSS-E-PM	C	M12 X1 - M24 X2	1273	103	979
~ DIN 374	N	C	6HX		HSS-E-PM	A	M12 X1,25 - M24 X1,5	1723	103	979
~ DIN 374	N	E	6GX		HSS-E-PM	S	M12 X1 - M24 X1,5	1732	103	979
~ DIN 374	N	C	6GX		HSS-E-PM	C	M12 X1 - M24 X1,5	1716	103	979
~ DIN 374	N	C	6HX		HSS-E-PM	S+	M 8 X1 - M16 X1,5	338	103	980
Guhring std.	N	C	6HX	NEW	HSS-E-PM	S	M 8 X1 - M16 X1,5	4145	103	981
Oil feed fluteless taps f. BSP-threads										
DIN 2189	N	C		NEW	HSS-E	Cb	G 1/16 - G1	4152	103	982

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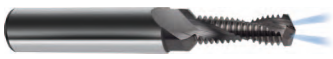
Standard	Type	Tool illustration	Tool material	Surface	Thread length	d1	Guhring no.	Discount group	Standard range page
Thread milling cutters for ISO metric threads									
Guhring std.	DTMC SP		Solid carbide		1,5xD	M 3 - M16	3774	108	984
Guhring std.	DTMC SP		Solid carbide	C	1,5xD	M 3 - M16	3776	108	985
Guhring std.	DTMC SP		Solid carbide		1,5xD	M 4 - M16	3775	108	985
Guhring std.	DTMC SP		Solid carbide	C	1,5xD	M 4 - M16	3777	108	985
Guhring std.	DTMC SP		Solid carbide		2xD	M 3 - M16	3778	108	986
Guhring std.	DTMC SP		Solid carbide	C	2xD	M 3 - M16	3780	108	987
Guhring std.	DTMC SP		Solid carbide		2xD	M 4 - M16	3779	108	987
Guhring std.	DTMC SP		Solid carbide	C	2xD	M 4 - M16	3781	108	987
Guhring std.	DTMC SP		Solid carbide		2,5xD	M 4 - M16	3782	108	988
Guhring std.	DTMC SP		Solid carbide	C	2,5xD	M 3 - M16	3784	108	989
Guhring std.	DTMC SP		Solid carbide		2,5xD	M 4 - M16	3783	108	989
Guhring std.	DTMC SP		Solid carbide	C	2,5xD	M 4 - M16	3785	108	989
Thread milling cutters for ISO metric fine threads									
Guhring std.	DTMC SP		Solid carbide	C	1,5xD	M 4 X0,5 - M16 X1,5	3788	108	990
Guhring std.	DTMC SP		Solid carbide		1,5xD	M 6 X0,75 - M16 X1,5	3787	108	991

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Standard	Type	Tool illustration	Tool material	Surface	Thread length	d1	Guhring no.	Discount group	Standard range page
Thread milling cutters for ISO metric fine threads									
Guhring std.	DTMC SP		Solid carbide	C	1,5xD	M 6 X0,75 - M16 X1,5	3789	108	991
Guhring std.	DTMC SP		Solid carbide	○	2xD	M 4 X0,5 - M16 X1,5	3790	108	992
Guhring std.	DTMC SP		Solid carbide	C	2xD	M 4 X0,5 - M 6 X0,75	3792	108	993
Guhring std.	DTMC SP		Solid carbide	○	2xD	M 6 X0,75 - M16 X1,5	3791	108	993
Guhring std.	DTMC SP		Solid carbide	C	2xD	M 6 X0,75 - M16 X1,5	3793	108	993
Thread milling cutters for UNC-threads									
Guhring std.	DTMC SP	NEW	Solid carbide	○	2xD	1/4 -20 - 5/8 -11	4138	108	994
Guhring std.	DTMC SP	NEW	Solid carbide	C	2xD	1/4 -20 - 5/8 -11	4139	108	994
Thread milling cutters for UNF-threads									
Guhring std.	DTMC SP	NEW	Solid carbide	○	2xD	1/4 -28 - 5/8 -18	4140	108	995
Guhring std.	DTMC SP	NEW	Solid carbide	C	2xD	1/4 -28 - 5/8 -18	4141	108	995

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Thread milling cutters for ISO metric threads

Standard	Type	Tool illustration	Tool material	Surface	Thread length	d1	Guhring no.	Discount group	Standard range page
Guhring std.	TM SP		Solid carbide		2xD	M 6 - M20 X1,5	3734	108	996
Guhring std.	TM SP		Solid carbide	C	2xD	M 6 - M20 X1,5	3737	108	996
Guhring std.	TM SP		Solid carbide	A	2xD	M 6 - M20	3743	108	996
Guhring std.	TM SP	NEW	Solid carbide		2xD	M 6 - M20	4132	108	997
Guhring std.	TM SP	NEW	Solid carbide	C	2xD	M 6 - M20	4133	108	997
Guhring std.	TM SP		Solid carbide		2,5xD	M 6 - M20	3735	108	998
Guhring std.	TM SP		Solid carbide	C	2,5xD	M 6 - M20	3740	108	998
Guhring std.	TM SP		Solid carbide	A	2,5xD	M 6 - M20	3744	108	998

Thread milling cutters for BSP-threads

Standard	Type	Tool illustration	Tool material	Surface	Thread length	d1	Guhring no.	Discount group	Standard range page
Guhring std.	TM SP		Solid carbide		2xD	G 1/8 - G 3/8	3745	108	999
Guhring std.	TM SP		Solid carbide	C	2xD	G 1/8 - G 3/8	3748	108	999
Guhring std.	TM SP		Solid carbide	A	2xD	G 1/8 - G 3/8	3751	108	999
Guhring std.	TM SP		Solid carbide		2,5xD	G 1/8 - G 3/8	3746	108	1000
Guhring std.	TM SP		Solid carbide	C	2,5xD	G 1/8 - G 3/8	3750	108	1000
Guhring std.	TM SP		Solid carbide	A	2,5xD	G 1/8 - G 3/8	3752	108	1000

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Standard	Type	Tool illustration	Tool material	Surface	Thread length	d1	Guhring no.	Discount group	Standard range page
Thread milling cutters for NPT-threads									
Guhring std.	TM SP		Solid carbide	○		1/16 - 3/8	3753	108	1001
Guhring std.	TM SP		Solid carbide	C		1/16 - 3/8	3754	108	1001
Guhring std.	TM SP		Solid carbide	A		1/16 - 3/8	3755	108	1001
Thread milling cutters for NPTF-threads									
Guhring std.	TM SP		Solid carbide	○		1/16 - 3/8	3756	108	1002
Guhring std.	TM SP		Solid carbide	C		1/16 - 3/8	3757	108	1002
Guhring std.	TM SP		Solid carbide	A		1/16 - 3/8	3758	108	1002
Thread milling cutters for UNC-threads									
Guhring std.	TM SP	NEW	Solid carbide	○	2xD	NR.10 -24 - 5/8 -11	4134	108	1003
Guhring std.	TM SP	NEW	Solid carbide	C	2xD	NR.10 -24 - 5/8 -11	4135	108	1003
Thread milling cutters for UNF-threads									
Guhring std.	TM SP	NEW	Solid carbide	○	2xD	NR.10 -32 - 5/8 -18	4136	108	1004
Guhring std.	TM SP	NEW	Solid carbide	C	2xD	NR.10 -32 - 5/8 -18	4137	108	1004

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Standard	Type	Tool illustration	Tool material	Surface	Thread length	d1	Guhring no.	Discount group	Standard range page
Thread milling cutters for ISO metric threads									
Guhring std.	TMC SP		Solid carbide		1,5xD	M 3 - M20	3510	108	1006
Guhring std.	TMC SP		Solid carbide	C	1,5xD	M 3 - M20	3525	108	1007
Guhring std.	TMC SP		Solid carbide	A	1,5xD	M 3 - M20	3543	108	1007
Guhring std.	TMC SP		Solid carbide		2xD	M 3 - M20	3511	108	1008
Guhring std.	TMC SP		Solid carbide	C	2xD	M 3 - M20	3526	108	1009
Guhring std.	TMC SP		Solid carbide	A	2xD	M 3 - M20	3544	108	1009
Guhring std.	TMC SP		Solid carbide		2,5xD	M 3 - M16	3759	108	1010
Guhring std.	TMC SP		Solid carbide	C	2,5xD	M 3 - M20	3760	108	1011
Guhring std.	TMC SP		Solid carbide	A	2,5xD	M 3 - M20	3761	108	1011
Thread milling cutters for ISO metric fine threads									
Guhring std.	TMC SP		Solid carbide		1,5xD	M 4 X0,5 - M16 X1,5	3512	108	1012
Guhring std.	TMC SP		Solid carbide	C	1,5xD	M 4 X0,5 - M16 X1,5	3527	108	1012
Guhring std.	TMC SP		Solid carbide	A	1,5xD	M 4 X0,5 - M16 X1,5	3545	108	1012
Guhring std.	TMC SP		Solid carbide		2xD	M 4 X0,5 - M16 X1,5	3513	108	1013
Guhring std.	TMC SP		Solid carbide	C	2xD	M 4 X0,5 - M16 X1,5	3528	108	1013

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Standard	Type	Tool illustration	Tool material	Surface	Thread length	d1	Guhring no.	Discount group	Standard range page
Thread milling cutters for ISO metric fine threads									
Guhring std.	TMC SP		Solid carbide	A	2xD	M 4 X0,5 - M16 X1,5	3546	108	1013
Guhring std.	TMC SP		Solid carbide	○	2,5xD	M 4 X0,5 - M16 X1,5	3762	108	1014
Guhring std.	TMC SP		Solid carbide	C	2,5xD	M 4 X0,5 - M16 X1,5	3763	108	1014
Guhring std.	TMC SP		Solid carbide	A	2,5xD	M 4 X0,5 - M16 X1,5	3764	108	1014
Thread milling cutters for UNC-threads									
Guhring std.	TMC SP		Solid carbide	○	1,5xD	1/4 -20 - 1/2 -13	3516	108	1015
Guhring std.	TMC SP		Solid carbide	C	1,5xD	1/4 -20 - 1/2 -13	3534	108	1015
Guhring std.	TMC SP		Solid carbide	○	2xD	1/4 -20 - 1/2 -13	3517	108	1016
Guhring std.	TMC SP		Solid carbide	C	2xD	1/4 -20 - 1/2 -13	3535	108	1016
Guhring std.	TMC SP		Solid carbide	A	2xD	1/4 -20 - 1/2 -13	3550	108	1016
Thread milling cutters for UNF-threads									
Guhring std.	TMC SP		Solid carbide	○	1,5xD	1/4 -28 - 1/2 -20	3518	108	1017
Guhring std.	TMC SP		Solid carbide	C	1,5xD	1/4 -28 - 1/2 -20	3536	108	1017
Guhring std.	TMC SP		Solid carbide	A	1,5xD	1/4 -28 - 1/2 -20	3551	108	1017
Guhring std.	TMC SP		Solid carbide	○	2xD	1/4 -28 - 1/2 -20	3519	108	1018

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Standard	Type	Tool illustration	Tool material	Surface	Thread length	d1	Guhring no.	Discount group	Standard range page
Thread milling cutters for UNF-threads									
Guhring std.	TMC SP		Solid carbide	C	2xD	1/4 -28 - 1/2 -20	3537	108	1018
Guhring std.	TMC SP		Solid carbide	A	2xD	1/4 -28 - 1/2 -20	3552	108	1018
Thread milling cutters for BSP-threads									
Guhring std.	TMC SP		Solid carbide		1,5xD	G 1/8 - G 3/8	3514	108	1020
Guhring std.	TMC SP		Solid carbide	C	1,5xD	G 1/4 - G 3/8	3529	108	1021
Guhring std.	TMC SP		Solid carbide	A	1,5xD	G 1/8 - G 3/8	3547	108	1021
Guhring std.	TMC SP		Solid carbide		2xD	G 1/8 - G 3/8	3515	108	1022
Guhring std.	TMC SP		Solid carbide	C	2xD	G 1/8 - G 3/8	3533	108	1023
Guhring std.	TMC SP		Solid carbide	A	2xD	G 1/8 - G 3/8	3548	108	1023
Guhring std.	TMC SP		Solid carbide		2,5xD	G 1/8 - G 1/4	3765	108	1024
Thread milling cutters for NPT-threads									
Guhring std.	TMC SP		Solid carbide			1/8 - 3/8	3520	108	1026
Guhring std.	TMC SP		Solid carbide	C		1/8 - 3/8	3538	108	1027
Guhring std.	TMC SP		Solid carbide	A		1/8 - 3/8	3553	108	1027

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Standard	Type	Tool illustration	Tool material	Surface	Thread length	d1	Guhring no.	Discount group	Standard range page
Thread milling cutters for NPTF-threads									
Guhring std.	TMC SP		Solid carbide	bright		1/8 - 3/8	3521	108	1028
Guhring std.	TMC SP		Solid carbide	C		1/8 - 3/8	3539	108	1029
Guhring std.	TMC SP		Solid carbide	A		1/8 - 3/8	3554	108	1029

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Standard	Type	Tool illustration	Tool material	Surface	Thread length	d1	Guhring no.	Discount group	Standard range page
Thread milling cutters for ISO metric threads									
Guhring std.	TMU SP		Solid carbide			M 1 - M 3,5	3523	108	1030
Guhring std.	TMU SP		Solid carbide	C		M 1 - M 3,5	3541	108	1030
Guhring std.	TMU SP		Solid carbide	A		M 1 - M 3,5	3556	108	1030
Thread milling cutters for UN-threads									
Guhring std.	TMU UN		Solid carbide			UN 12 - UN 24	3595	108	1031
Guhring std.	TMU UN		Solid carbide	C		UN 10 - UN 9	3596	108	1031
Guhring std.	TMU UN		Solid carbide	A		UN 12 - UN 24	3597	108	1031
Thread milling cutters for BSP-threads									
Guhring std.	TMU SP		Solid carbide			G 11 - G 19	3524	108	1032
Guhring std.	TMU SP		Solid carbide	C		G 11 - G 19	3542	108	1032
Guhring std.	TMU SP		Solid carbide	A		G 11 - G 19	3557	108	1032
Thread milling cutters for NPT-threads									
Guhring std.	TMU SP		Solid carbide			NPT 11,5 - NPT 14	3768	108	1033
Guhring std.	TMU SP		Solid carbide	C		NPT 11,5 - NPT 14	3769	108	1033
Guhring std.	TMU SP		Solid carbide	A		NPT 11,5 - NPT 14	3770	108	1033

C TiCN Cb Carbo D Cristall F FIRE/nanoFIRE P AlCrN S TiN S+ TiN+ M MolyGlide Y Signum

Standard	Type	Tool illustration	Tool material	Surface	Thread length	d1	Guhring no.	Discount group	Standard range page
Thread milling cutters for NPTF-threads									
Guhring std.	TMU SP		Solid carbide	C		NPTF 11,5 - NPTF 14	3772	108	1034
Guhring std.	TMU SP		Solid carbide	A		NPTF 11,5 - NPTF 14	3773	108	1034

bright | steam tempered | nitrided lands | nitrided | golden brown | A TiAlN | a TiAlN nanoA | A TiAlN SuperA

Standard	Type	Tool illustration	Tool material	Surface	Thread length	d1	Guhring no.	Discount group	Standard range page
Thread milling cutters for ISO metric threads									
Guhring std.	TMU SP	NEW	Solid carbide	○		0,500 - 3,000	4162	108	1035
Guhring std.	TMU SP	NEW	Solid carbide	C		0,500 - 3,000	4163	108	1035

C TiCN | Cb Carbo | D Cristall | F FIRE/nanoFIRE | P AlCrN | S TiN | S+ TiN+ | M MolyGlide | Y Signum

Standard	Form	Tool illustration	Tool material	Surface		d1	Guhring no.	Discount group	Standard range page
Die nuts for ISO metric threads									
Guhring std.	B		HSS	○	lapped	M 1 - M10	125	103	1036
Guhring std.	B		HSS	○		M 2,2 - M12	121	103	1037
Dies for ISO metric threads									
DIN 382			HSS	○		M 5 - M52	139	103	1038
DIN EN 22568	B		HSS-E	●	lapped	M 2 - M22	130	103	1039
DIN 382			HSS	○		M 3 - M16	140	103	1040
DIN EN 22568	B		HSS	○		M 1 - M30	151	103	1041
DIN EN 22568	B		HSS	○	lapped	M 4 - M12	153	103	1041
DIN EN 22568	B		HSS	○	lapped	M 4 - M27	155	103	1041
DIN EN 22568	B		HSS	○		M 3 - M33	156	103	1041
DIN EN 22568	B		HSS	○		M 3 - M30	152	103	1042
Dies for ISO metric fine threads									
DIN EN 22568	B		HSS	○		M 2,6X0,25 - M22 X1,5	161	103	1043
DIN EN 22568	B		HSS	○		M 3 X0,3 - M30 X2	162	103	1043
DIN EN 22568	B		HSS	○	lapped	M 4,5X0,5 - M27 X1,5	163	103	1043

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

Standard	Form	Tool illustration	Tool material	Surface	d1	Guhring no.	Discount group	Standard range page
Dies for UNC-threads								
DIN EN 22568	B		HSS	○	NR. 4 -40 - 7/16-14	181	103	1045
DIN EN 22568	B		HSS	○	NR. 8 -32 - 3/4 -10	182	103	1045
Dies for UNF-threads								
DIN EN 22568	B		HSS	○	NR.10 -32 - 7/8 -14	185	103	1046
Dies for BSW-threads								
DIN EN 22568	B		HSS	○	W 1/8 - W1 5/8	172	103	1047
Dies for BSP-threads								
DIN EN 24231	B		HSS	○	G 1/8 - G1	175	103	1048
DIN EN 24231	B		HSS	○	G 1/8 - G1 1/2	176	103	1048
Dies for R-threads BSPT								
DIN EN 24230	B		HSS	○	R 1/8 - R2	198	103	1049
Dies for NPT-threads								
DIN EN 22568	B		HSS	○	1/8 - 1	190	103	1050
DIN EN 22568	B		HSS	○	1/8 - 3/4	191	103	1050

C TiCN Cb Carbo D Cristall F FIRE/nanoFIRE P AlCrN S TiN S+ TiN+ M MolyGlide Y Signum

The Guhring colour code

The Guhring colour-code simplifies the selection of the optimal Guhring threading tool for the workpiece material.
The structure of the compass pages for taps and thread milling cutters is corresponding to this colour-code.

General steels

Material no. to DIN EN 10 027	Abbreviation
Common structural steels	
1.0035	S 185 (St 33)
1.0039	S 235 JRH
1.0036	S 235JRG1+CR
1.0060	E 335 (St 60-2)
Free-cutting steels	
1.0718	11SMnPb30
1.0721	10S20
1.0758	60SPb20
1.0726	35S20
Case hardened steels	
1.0401	(C 15)
1.7016	17 CR3
1.7131	16MnCr5
1.5919	15CrNi6
Unalloyed heat-treatable steels	
1.0402	C 22
1.1151	C22E (Ck 22)
1.0503	C 45
1.1191	C45E (Ck 45)

High tensile steels

Material no. to DIN EN 10 027	Abbreviation
Alloyed heat-treatable steels	
1.6511	36 CrNiMo 4
1.7033	34 Cr 4
1.7225	42 CrMo 4
Tool steels	
1.2316	X 36 CrMo 17
1.2067	10 S20
High speed steels	
1.3343	HS 6-5-2
1.3344	HS 6-5-3
1.3243	HS 6-5-2-5
1.3247	HS 2-19-1-8
Hardened steels	
The above mentioned materials hardened to 45…62 HRC	

Acid-/stainl. resist. steels

Material no. to DIN EN 10 027	Abbreviation
Sulphured stainless steels	
1.4005	X 12 CrS 13
1.4104	X 14 CrMo S 17
1.4105	X 6 CrMo S 17
1.4305	X 8CrNi S 18-9
Austenitic stainless steels	
1.4300	X 12 CrNi 18-8
1.4301	X 5 CrNi 18-10
1.4541	X 6 CrNiTi 18-10
Martensitic stainless steels	
1.4057	X 17 CrNi 16-2
1.4112	X 90 CrMoV 18
1.4006	X 12 Cr 13

Universell

Material no. to DIN EN 10 027	Abbreviation
Common structural steels	
1.0035	S185 (St33)
1.0421	St 52.0
1.0067	RSt 37-1
1.0425	P265GH
Free-cutting steels	
1.0711	9S20
1.0718	11SMnPb30
1.0727	46S20
1.0728	(60 S 20)
Case hardened steels	
1.7131	16MnCr5
1.6523	21NiCrMo2-2
1.7321	20MoCr4
1.7325	25MoCr4
Unalloyed heat-treatable steels	
1.0402	C22
1.1151	C22E
1.0503	C45
1.0601	C60
Nitriding steels	
1.8504	34CrAl6
1.8507	34CrAlMo5
1.8509	41CrAlMo7
1.8515	31CrMo12
1.8550	34CrAlNi4
Spher. graphite iron	
0.7040	EN-GJS-400-15
0.7060	EN-GJS-600-3

Al and Al-alloys

Material no.	Abbreviation
Al and al-alloys	
3.0250	Al 99,5H
3.0280	AL 99,8H
3.3308	Al99,9Mg0.5
Al wrought alloys	
3.2315	AlMgSi1
3.1655	AlCuMgPb
3.4335	AlZn4,5Mg1
Al cast alloys ≤ 10% Si	
3.2134	GD-AlSi5Cu1Mg
3.2162	GD-AlSi8Cu3
3.2373	G-AlSi9Mg
Al cast alloys > 10% Si	
3.2581	G-AlSi12
3.2583	G-AlSi12Cu
3.2581	G-AlSi10Mg

Cast materials

Material no.	Abbreviation
Cast iron	
0.6015 (GG15)	EN-GJL-150
0.6025 (GG25)	EN-GJL-250
0.6040 (GG40)	EN-JLZ
Spheroidal grahpite iron and malleable cast iron	
0.7040 (GGG40)	EN-GJS-400-15
0.7060 (GGG60)	EN-GJS-600-3
0.8035	EN-GJMW-350-4
0.8135	EN-GJMB-350-10
Compacted graphite iron	
–	EN-GJV250
	EN-GJV350
	EN-GJV400
	EN-GJV500

Non-ferrous metals

Material no.	Abbreviation
Brass, short-chipping	
2.0380	CuZn39Pb2
2.0401	CuZn39Pb3
2.0410	CuZn43Pb2
Brass, long-chipping	
2.0250	CuZn20
2.0280	CuZn33
2.0332	CuZn37Pb0,5

Plastics

Material no.	Abbreviation
Duroplastics	
–	Bakelite
	Resopal
	Pertinax
	Moltopren
Thermoplastics	
–	Plexiglass
	Hostalen
	Novodur
	Makralon
Glass/carbon re-inforced	
–	Polypropylene glass fibre carbon fibre

Magnesium-alloys

Material no.	Abbreviation
Magnesium-alloys	
3.5200	MgMn2
3.5612	MgAl6Zn
3.5812	MgAl8Zn
3.5812.05	GDMgAl8Zn1
3.5612.05	GDMgAl6Zn1
3.5662.01	GMgAl6

Special-alloys

Material no.	Abbreviation
Titanium	
3.7025	Ti
3.7065	Ti
Titanium-alloys	
3.7115	TiAl 5Sn2
3.7165	TiAl 6 V4
Special-alloys	
2.4610	Hastelloy C4
2.4876	Incoloy 800
2.4816	Inconel 600
2.4668	Inconel 718
2.4634	Nimonic 105
	CuNi12Zn24
	CuNi18Zn20

bright · steam tempered · nitrided lands · nitrided · golden brown · A TiAlN · a TiAlN nanoA · A AlTiN SuperA

	Example		
What thread do you want to produce?	M8		
What material do you have to machine?	Free-cutting steel, 1.0718 11SMnPb30		
To which material group does your material belong? Selection see left "colour-ring guide"	Gen. steels ≤ 800 N/mm²	all malleable materials	all millable materials
What tool can you use? Selection see below "Suitablility of threading tools"	Taps	Fluteless taps	Thread milling cutters
Further tool selection:	Taps compass, pages for gen. steels ≤ 800 N/mm²	Taps compass, no further selection necessary	Thread milling cutters compass, pages for "Steels and Ni-alloys"
What hole type do you want to produce? Selection through hole/blind hole	Through hole	with external coolant: no further selection necessary with internal coolant: note radial or axial coolant exit	no further selection necessary
What thread type is required? Selection in column "Thread type"	M	M	M
What thread tolerance is required? Selection in column "Tolerance zone"	ISO 2/6H	6HX	no further selection necessary
What are the tool dimensions? Selection in column "Dimensions to DIN ..."	DIN 371	~DIN 371	no further selection necessary
What thread depth do you want to produce?	2 x D Selection in the head of table	2 x D Table "Fluteless taps with oil grooves"	2 x D Selection in column "Thread depth"
The most suitable tool is:	Guhring no. 945 steam tempered type N/B HSS-E	Guhring no. 919 TiN type N/C HSS-E	Guhring no. 3326 TiCN type TMC SP solid carbide

Suitability of threading tools		Taps	Fluteless taps	Thread milling cutters
Machine	Machining centre	+++	+++	+++
Machining	wide range of application	++	++ (suitable only for malleable materials)	++
	high thread quality	++	+++	++
	high process reliability	++	+++	+++
	simple handling	++	++	+ (3D programming necessary)
Tool	cost-effectiv	+++	++	+*
	tool life	++	++ (no regrinding possible)	++

+++ optimal suitability ++very good suitability + good suitability * only for solid carbide tools

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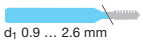
Suitable for conventional machining with quick change tapping chucks

General steels

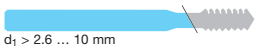
Material no. to DIN EN 10 027	Abbreviation
Structural steels	
1.0035	S 185 (St 33)
1.0039	S 235 JRH
1.0036	S 235JRG1+CR
1.0060	E 335 (St 60-2)
Free-cutting steels	
1.0718	11SMnPb30
1.0721	10S20
1.0758	60SPb20
1.0726	35S20
Case hardened steels	
1.0401	(C 15)
1.7016	17 CR3
1.7131	16MnCr5
1.5919	15CrNi6
Unalloyed heat-treabable steels	
1.0402	C 22
1.1151	C22E (Ck 22)
1.0503	C 45
1.1191	C45E (Ck 45)

Shank designs

DIN 371



d_1 0.9 ... 2.6 mm



d_1 > 2.6 ... 10 mm

DIN 376 / DIN 374 / DIN 5156

* Taps Guhring no. 829 and 316 (DIN 374 MF. tolerance ISO 3/6G) include the diameters for the production of threads for electrical fittings to DIN 60 423. See price section.

Type clarification

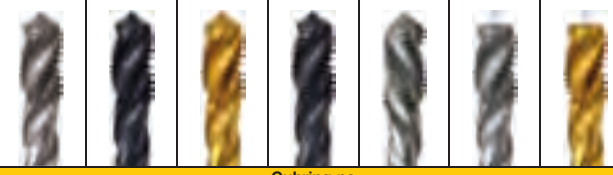
NR15 = Type N, 15° RH spiral
NR40 = Type N, 40° RH spiral
NL15 = Type N, 15° LH spiral
NL40 = Type N, 40° LH spiral

Through holes

Thread depth			≤1,5xD					≤3xD			
Tool material			HSS-E					HSS-E			
Type/form			N/B	N/B	N/B	N/C	N/D	N/B	N/B	N/B	N/B
Surface finish			○	○	○	○	○	○	●	S	C
Cooling			☒	☒	☒	☒	☒	☒	☒	☒	☒
			for machining sheet metal								
Tools with colour-ring								○	○	○	○
Thread type	Tolerance zone	Dim. to DIN 2184-1	Guhring no. Ø-range *Prices on page*					Guhring no. Ø-range *Prices on page*			
M	**ISO 1 4H**	**DIN 371**						**794** M2 – M10 *855*			
	ISO 2 6H		**838** M1,4 – M10 *856*	**839** M1 – M10 *857*	**802** M2 – M8 *855*	**806** M1 – M10 *843*	**801** M2 – M10 *855*	**803** M1,4 – M10 *855*	**945** M1 – M10 *857*	**912** M1,4 – M10 *857*	**1246** M3 – M10 *857*
	ISO 3 6G		**869** M2 – M10 *857*	**796** M2 – M10 *855*	**797** M2 – M8 *855*	**795** M3 – M10 *843*		**837** M1,4 – M10 *856*			
	ISO 2 6H	**DIN 376**	**846** M3 – M20 *866*	**847** M3 – M10 *873*		**818** M1,6 – M52 *870*	**813** M2 – M27 *872*	**815** M1,6 – M36 *873*	**948** M2 – M52 *874*	**915** M1,6 – M52 *873*	**1249** M12 – M16 *863*
	ISO 3 6G							**845** M2 – 48 *873*			
MF	**ISO 2 6H**	**DIN 374**				**830** M3x0,35 – M45x1,5 *878*		**827** M3x0,35 – M45x1,5 *887*	**2888** M3x0,35 – M36x1,5 *889*	**832** M3x0,35 – M36x1,5 *887*	
	ISO 3 6G					**829 *** M6x0,75 – M63x1,5 *878*		**316 *** M6x0,75 – M20x1,5 *884*			
UNC	**2B**	**~ DIN 371**				**1977** Nr.2-56 – 3/8"-16 *895*		**873** Nr.1-64 – 3/8"-16 *899*	**2889** Nr.2-56 – 3/8"-16 *900*		
	2B	**~ DIN 376**				**1982** 7/16"-14 – 1"-8 *897*		**878** 7/16"-14 – 1 1/2"-6 *901*	**2890** 7/16"-14 – 1 1/2"-6 *902*		
UNF	**2B**	**~ DIN 374**				**1987** Nr.3-56 – 1"-12 *905*		**908** Nr.1-72 – 1 1/2"-12 *908*	**2891** Nr.3-56 – 1 1/4"-12 *909*		
BSW	**–**	**~ DIN 371**							**2892** W1/8" – W3/8" *914*		
	–	**~ DIN 376**							**2893** W7/16" – W1" *913*		
G BSP	**–**	**DIN 5156**				**963** G1/16" – G2" *916*		**962** G1/16" – G2" *918*	**2894** G1/8" – G1 1/2" *919*		

○ bright ● steam tempered ◐ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A AlTiN SuperA

Blind holes

≤3xD		≤1,5xD						≤3xD						
HSS-E		HSS-E						HSS-E						
N/B	NL15/D	N/C	NR15/C	NR15/C	NR15/C	NR15/C	NR15/C	NR40/C	NR40/C	NR40/C	NR40/C	NL40/C	NR40/C	NR40/C
○	○	○	○	●	S	○	S	○	●	S	C	○	○	S
☒	☒	☒	☒	☒	☒	a	a	☒	☒	☒	☒	☒	a	a
LH spiral												LH spiral		
○		○	○	○	○	○	○	○	○	○	○	○	○	○
														
Guhring no. Ø-range *Prices on page*		**Guhring no.** Ø-range *Prices on page*						**Guhring no.** Ø-range *Prices on page*						
789 M3 – M10 *854*	**808** M3 – M10 *856*	**806** M1 – M10 *843*	**809** M2 – M10 *843*	**946** M2 – M10 *845*	**913** M2 – M10 *845*	**1891** M5 – M10 *924*	**2436** M5 – M10 *925*	**810** M2 – M10 *843*	**783** M2 – M10 *842*	**914** M2 – M10 *845*	**1252** M3 – M10 *845*	**786** M3 – M10 *842*	**1893** M5 – M10 *924*	**2438** M5 – M10 *925*
		795 M3 – M10 *843*	**799** M2 – M10 *843*					**844** M3 – M10 *844*						
790 M12 – M20 *862*	**820** M3 – M22 *873*	**818** M1,6 – M52 *870*	**821** M3 – M30 *870*	**949** M3 – M22 *871*	**916** M3 – M27 *865*	**1898** M12 – M20 *926*	**2437** M12 – M20 *972*	**822** M3 – M30 *870*	**784** M3 – M30 *870*	**917** M3 – M30 *871*	**1254** M12 – M16 *851*	**787** M12 – M20 *850*		**2439** M12 – M20 *927*
								848 M3 – M27 *871*						
		830 M3x0,35 – M45x1,5 *878*	**833** M4x0,50 – M30x2 *878*	**2838** M4x0,50 – M30x2 *879*	**1971** M4x0,50 – M30x2 *879*	**1905** M5x0,50 – M20x1,5 *936*		**834** M3x0,35 – M30x2 *878*	**2843** M3x0,35 – M30x2 *879*	**852** M3x0,35 – M24x2 *879*				
		829 * M6x0,75 – M63x1,5 *878*												
		1977 Nr.2-56 – $^{3}/_{8}$"-16 *895*	**1978** Nr.2-56 – $^{3}/_{8}$"-16 *895*	**2839** Nr.2-56 – $^{3}/_{8}$"-16 *896*				**876** Nr.2-56 – $^{3}/_{8}$"-16 *895*	**2844** Nr.2-56 – $^{3}/_{8}$"-16 *896*					
		1982 $^{7}/_{16}$"-14 – 1"-8 *897*	**1983** $^{7}/_{16}$"-14 – 1"-8 *897*	**2840** $^{7}/_{16}$"-14 – 1"-8 *897*				**881** $^{7}/_{16}$"-14 – 1"-8 *897*	**2845** $^{7}/_{16}$"-14 – 1"-8 *898*					
		1987 Nr.3-56 – 1"-12 *905*	**1988** Nr.3-56 – 1"-12 *905*	**2841** Nr.10-32 – $^{3}/_{4}$"-16 *906*				**911** Nr.3-56 – 1"-12 *905*	**2846** Nr.6-40 – 1"-12 *906*					
									2847 W$^{1}/_{8}$" – W$^{3}/_{8}$" *913*					
									2848 W$^{3}/_{8}$" – W1" *912*					
		963 G$^{1}/_{16}$" – G2" *916*	**964** G$^{1}/_{16}$" – G1" *916*	**2842** G$^{1}/_{8}$" – G1" *917*				**965** G$^{1}/_{16}$" – G1$^{1}/_{2}$" *917*	**2849** G$^{1}/_{8}$" – G1" *917*					

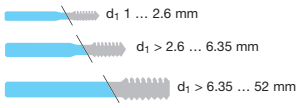
C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

Gerneral steels

Material no. to DIN EN 10 027	Abbreviation
Structural steels	
1.0035	S 185 (St 33)
1.0039	S 235 JRH
1.0036	S 235JRG1+CR
1.0060	E 335 (St 60-2)
Free-cutting steels	
1.0718	11SMnPb30
1.0721	10S20
1.0758	60SPb20
1.0726	35S20
Case hardened steels	
1.0401	(C 15)
1.7016	17 CR3
1.7131	16MnCr5
1.5919	15CrNi6
Unalloyed heat-treabable steels	
1.0402	C 22
1.1151	C22E (Ck 22)
1.0503	C 45
1.1191	C45E (Ck 45)

Shank designs

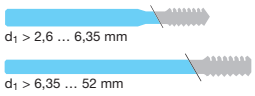
DIN 352 / DIN 2181



DIN 357 / Guhring std. no. 998

DIN 40 432 / Guhring std. no. 973

Guhring std. no. 888



Type clarification

NR15 = Type N, 15° RH spiral
NR28 = Type N, 28° RH spiral
NR40 = Type N, 40° RH spiral
NL15 = Type N, 15° LH spiral

Through holes

Thread depth				≤1,5xD		
Tool material				HSS-E		
Type/form				N/C	N/C	N/-
Surface finish				◯	◯	◯
Cooling				☒	☒	☒
						Machine nut taps
Thread type	Tolerance zone	Dim. to DIN 2184-2	Other dim.	**Guhring no.** Ø-range *Prices on page*		
M	**ISO 2 6H**	**DIN 352**	**–**	**995** M2 – M24 *836*		
	ISO 2 6H	**–**	**DIN 357**			**851** M3 – M30 *943*
	ISO 2 6H	**–**	**Werks-norm**			
MF	**ISO 2 6H**	**DIN 2181**	**–**	**997** M5x0,50 – M12x1,5 *838*		
Pg	**–**	**DIN 40 432**	**–**	**979** Pg7 – Pg48 *839*		
NPT	**–**	**–**	**Werks-norm**		**973** 1/16“ – 2“ *840*	

◯ bright ◯ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A AlTiN SuperA

Blind holes

≤1,5xD	≤3xD		≤1,5xD			≤3xD	
HSS-E	HSS-E		HSS-E			HSS-E	
NR28/D	N/B	N/B	N/C	N/C	NR15/C	NR40/C	NR40/C
○	○	○	○	○	○	○	○
⊠	⊠	⊠	⊠	⊠	⊠	⊠	⊠
combination drill		machine nut tap					extra long tap
Guhring no. Ø-range *Prices on page*	**Guhring no.** Ø-range *Prices on page*		**Guhring no.** Ø-range *Prices on page*			**Guhring no.** Ø-range *Prices on page*	
	991 M2 – M24 *837*		**995** M2 – M24 *836*		**992** M2 – M22 *835*	**993** M2 – M22 *835*	
1839 M3 – M12 *943*		**998** M3 – M20 *876*					**888** M3 – M20 *846*
			997 M5x0,50 – M12x1,5 *838*			**1970** M5x0,50 – M12x1,5 *838*	
	980 Pg7 – Pg21 *839*		**979** Pg7 – Pg48 *839*				
				973 1/16“ – 2“ *840*			

Threading tools

C TiCN Cb Carbo D Cristall F FIRE/nanoFIRE P AlCrN S TiN S+ TiN+ M MolyGlide Y Signum

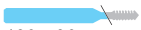
Through holes

High tensile steels

Material no. nach DIN EN 10 027	Kurz-bezeichnung
Alloyed heat-treabable steels	
1.6511	36 CrNiMo 4
1.7033	34 Cr 4
1.7225	42 CrMo 4
Tool steels	
1.2316	X 36 CrMo 17
1.2067	10 S20
High speed steels	
1.3343	HS 6-5-2
1.3344	HS 6-5-3
1.3243	HS 6-5-2-5
1.3247	HS 2-19-1-8
Hardened steels	
All steel examples are hardened to 45 … 62 HRC	

Shank designs

DIN 371



d 0.9 … 2.6 mm

d > 2.6 … 10 mm

DIN 376 / DIN 374

DIN 352

d 1 … 2.6 mm

d > 2.6 … 6.35 mm

d > 6.35 … 52 mm

Type clarification

AZ = with interrupted threads
HR15 = Type H, 15° RH spiral
HR40 = Type H, 40° RH spiral

*Tools also suitable for: short-chipping non-ferrous metals, case hardened and nitriding steels.

a With internal cooling, tools with axial coolant duct are, as a rule, only suitable for the machining of blind holes. Without internal cooling, i.e. external cooling, the tools are also suitable for through holes.

Thread depth			≤1,5xD		≤3xD	
Tool material			HSS-E	HSS-E-PM	HSS-E	
Type/form			H/C	H/C	H/B	H/B
Surface finish			C	C	○	●
Cooling			a	a	⊠	⊠
○ Tools with colour-ring						
Thread type	Tolerance zone	Dim. to DIN 2184-1	Guhring no. Ø-range *Prices on page*		Guhring no. Ø-range *Prices on page*	
M	ISO 2 6H	DIN 371			**804** M2 – M10 *855*	**733** M2 – M10 *854*
	ISO 3 6G				**2465** M2 – M10 *859*	
	6HX			**302** * M5 – M10 *931*		
	ISO 2 6H	DIN 376			**816** M3 – M24 *873*	**734** M3 – M24 *872*
	6HX		**778** M16 – M39 *850* NEW	**297** * M10 – M14 *933*		
MF	ISO 2 6H	DIN 374			**828** M3x0,35 – M26x1,5 *884*	
	ISO 3 6G					**2982** M8x1 – M20x1,5 *885*
	6HX			**1090** * M5x0,5 – M16x1,5 *937*		

○ bright ● steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A AlTiN SuperA

≤3xD						
HSS-E				HSS-E-PM		
H/B	H/B	H/B	H AZ/B	H/B	H/B	H/B
●	S	C	○	○	S	A
☒	☒	☒	☒	☒	☒	☒
Guhring no. Ø-range *Prices on page*						
2941 M2 – M10 *859*		**1914** M2 – M10 *857*	**791** M2 – M10 *855*	**875** M3 – M10 *860*	**57** M3 – M10 *860*	**1575** M6 – M10 *861*
	2710 M2 – M10 *859*					
2942 M3 – M24 *875*		**1915** M3 – M24 *875*	**849** M12 – M20 *862*		**58** M12 – M24 *863*	**1576** M12 – M30 *863*
2943 M3x0,35 – M24x1,5 *885*						
	2983 M8x1 – M20x1,5 *885*					

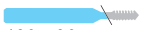
C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

High tensile steels

Material no. to DIN EN 10 027	Abbreviation
Alloyed heat-treatable steels	
1.6511	36 CrNiMo 4
1.7033	34 Cr 4
1.7225	42 CrMo 4
Tool steels	
1.2316	X 36 CrMo 17
1.2067	10 S20
High speed steels	
1.3343	HS 6-5-2
1.3344	HS 6-5-3
1.3243	HS 6-5-2-5
1.3247	HS 2-19-1-8
Hardened steels	
All steel examples are hardened to 45 … 62 HRC	

Shank designs

DIN 371



d 0.9 … 2.6 mm

d > 2.6 … 10 mm

DIN 376 / DIN 374

DIN 352

d 1 … 2.6 mm

d > 2.6 … 6.35 mm

d > 6.35 … 52 mm

Type clarification

AZ = with interrupted threads
HR15 = Type H, 15° RH spiral
HR40 = Type H, 40° RH spiral

*Tools also suitable for: short-chipping non-ferrous metals, case hardened and nitriding steels.

a With internal cooling, tools with axial coolant duct are, as a rule, only suitable for the machining of blind holes. Without internal cooling, i.e. external cooling, the tools are also suitable for through holes.

Blind holes

Thread depth			≤1,5xD			
Tool material			HSS-E	HSS-E-PM		
Type/form			H/C	HR15/C	HR15/C	HR15/C
Surface finish			C	○	A	C
Cooling			a	☒	☒	a
Tools with colour-ring				○	○	blanke Schneiden ○
Thread type	Tolerance zone	Dim. to DIN 2184-1	Guhring no. Ø-range *Prices on page*			
M	ISO 2 6H	DIN 371		**872** M3 – M10 *849*	**1577** M6 – M10 *849*	
	ISO 3 6G					
	6HX					**1188** M6 – M10 *925*
	ISO 2 6H	DIN 376		**935** M12 – M20 *851*	**1578** M12 – M20 *851*	
	6HX		**778** M16 – M39 *850* NEW			**1194** M12 – M24 *927*
MF	ISO 2 6H	DIN 374		**874** M8x1 – M20x1,5 *883*		
	ISO 3 6G					
	6HX					**1200** M6x0,75 – M24x1,5 *936*

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A AlTiN SuperA

Blind holes

≤1,5xD		≤3xD					
HSS-E-PM		HSS-E					
H/C	H/E	HR40/C	HR40/C	HR40/C	HR40/C	HR40/C	HR40/C
C	C	○	●	◐	S	C	○
a	a	☒	☒	☒	☒	☒	a
Art.-Nr. Ø-range *Prices on page*		**Guhring no.** Ø-range *Prices on page*					
		811 M2 – M10 *843*	**947** M2 – M10 *845*	**2850** M2 – M10 *846*	**361** M2 – M10 *842*	**1916** M2 – M10 *845*	**1894** M5 – M10 *925*
		2984 M2 – M10 *847*		**2985** M2 – M10 *847*	**2986** M2 – M10 *847*		
302 * M5 – M10 *931*	**1091** * M5 – M10 *931*						
		823 M3 – M30 *871*	**950** M3 – M30 *871*	**2851** M4 – M30 *865*	**362** M3 – M30 *870*	**1917** M3 – M30 *871*	**1901** M12 – M20 *927*
297 * M10 – M14 *933*	**4165** M10 – M12 *933*						
		835 M6x0,75 – M24x1,5 *879*	**2940** M6x0,75 – M24x1,5 *882*	**2852** M6x0,75 – M24x1,5 *879*			**1907** M6x0,75 – M20x1,5 *936*
		2987 M8x1 – M20x1,5 *882*		**2988** M8x1 – M20x1,5 *882*	**2989** M8x1 – M20x1,5 *883*		
1090 * M5x0,5 – M16x1,5 *937*	**1007** * M5x0,5 – M16x1,5 *937*						

40° spiral flute tap with conical rear clearance

C TiCN Cb Carbo D Cristall F FIRE/nanoFIRE P AlCrN S TiN S+ TiN+ M MolyGlide Y Signum

High tensile steels

Material no. to DIN EN 10 027	Abbreviation
Alloyed heat-treabable steels	
1.6511	36 CrNiMo 4
1.7033	34 Cr 4
1.7225	42 CrMo 4
Tool steels	
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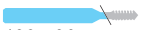
1.2067	10 S20
High speed steels	
1.3343	HS 6-5-2
1.3344	HS 6-5-3
1.3243	HS 6-5-2-5
1.3247	HS 2-19-1-8
Hardened steels	
All steel examples are hardened to 45 … 62 HRC	

Shank designs

DIN 371



d 0.9 … 2.6 mm

d > 2.6 … 10 mm

Through holes and blind holes

Thread depth			≤1,5xD		
Tool material			HSS-E-PM	VHM	
Type/form			H/D	H/D	H/D
Surface finish			C	C	C
Cooling			☒	≤ M12 ☒	☒
Rec. parameters for HSS-E-PM taps Guhring no. 1201 v_c ≤ 2 - 8 m/min; for solid carbide taps Guhring no. 2944 v_c ≤ 2 m/min			45…55 HRC	Shank tolerance h6; ≤ 62 HRC	Shank tolerance h6
Thread type	Tolerance zone	Dim. to	**Guhring no.** Ø-range *Prices on page*		
M	6HX	DIN 371	**1201** M3 – M16 *868*		
	ISO 2 6H	Guhring std.		**2944** M3 – M16 *869*	
MF	ISO 2 6H	Guhring std.			**1161** M6x0,5 – M12x1,5 *894*
MF	6HX	DIN 371	**4161** M8x1 – M12x1,5 *893* NEW		

bright · steam tempered · nitrided lands · nitrided · golden brown · TiAlN · TiAlN nanoA · AlTiN SuperA

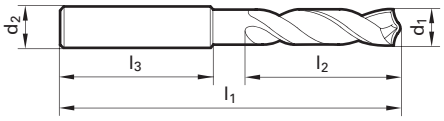
Special tapping size hole diameter for hard machining with Guhring no. 2944

Thread size	Tapping size hole Ø		Core diameter of int. thread			
			min.		max.	
	to DIN 336 mm	with Guh. no. 2944 mm	to DIN 336 mm	with Guh. no. 2944 mm	to DIN 336 mm	with Guh. no. 2944 mm
M3	2.50	2.60	2.495	2.559	2.599	2.699
M4	3.30	3.40	3.242	3.342	3.422	3.522
M5	4.20	4.30	4.134	4.234	4.334	4.434
M6	5.00	5.10	4.917	5.017	5.153	5.253
M8	6.80	6.90	6.647	6.747	6.912	7.012
M10	8.50	8.60	8.376	8.476	8.676	8.776
M12	10.20	10.40	10.106	10.206	10.441	10.541
M16	12.00	14.10	13.835	15.935	14.210	16.310

Special tapping size hole diameter for hard machining with Guhring no. 1161

Thread size	Tapping size hole Ø		Core diameter of int. thread			
			min.		max.	
	to DIN 336 mm	with Guh. no. 1161 mm	to DIN 336 mm	with Guh. no. 1161 mm	to DIN 336 mm	with Guh. no. 1161 mm
M6x0,5	5.50	5.60	5.459	5.559	5.599	5.699
M8x1	7.00	7.10	6.917	7.017	7.153	7.253
M10x1	9.00	9.10	8.917	9.017	9.153	9.253
M12x1	11.00	11.10	10.917	11.017	11.153	11.253
M12x1,5	10.50	10.60	10.376	10.476	10.676	10.776

Tool material	**Solid carbide**
Carbide grade	K
Type	H
Surface finish	A
DIN	DIN 6537
Shank form	HA
Guhring no.	**1946**



d1 mm	d2 mm	l1 mm	l2 mm	l3 mm	Availability
2.600	6.000	62.00	20.00	36.00	●
3.000	6.000	62.00	20.00	36.00	●
3.400	6.000	62.00	20.00	36.00	●
4.000	6.000	66.00	24.00	36.00	●
4.300	6.000	66.00	24.00	36.00	●
5.000	6.000	66.00	28.00	36.00	●
5.100	6.000	66.00	28.00	36.00	●
5.600	6.000	66.00	28.00	36.00	●
6.000	6.000	66.00	28.00	36.00	●
6.900	8.000	79.00	34.00	36.00	●
7.100	8.000	79.00	34.00	36.00	●
8.000	8.000	79.00	41.00	36.00	●
8.600	10.000	89.00	47.00	40.00	●
9.100	10.000	89.00	47.00	40.00	●
10.000	10.000	89.00	47.00	40.00	●
10.400	12.000	102.00	55.00	45.00	●
10.600	12.000	102.00	55.00	45.00	●
11.100	12.000	102.00	55.00	45.00	●
12.000	12.000	102.00	55.00	45.00	●
14.100	16.000	115.00	65.00	48.00	●

The Guhring drill for tapping size holes in hardened materials!

Guhring's hard drill enables the efficient and process reliable production of holes in hardened steels up to 62 HRC. Convex cutting edges give the tool its extremely high rigidity and ensure an optimal chip fracture. The flute profile is optimised for hard machining and evacuates the swarf safely from the hole. The Guhring hard drill is available as standard tool with straight shank to DIN 6535 HA in the diameter range from 2.6 to 14.1 mm.

Cutting rates at 3 x D with Guhring no. 1946

	Hardness	HRC 40…48	HRC 48 … 62
	Cutting speed v_c	40 m/min	30 m/min
	Feed rate	f (mm/rev):	f (mm/rev):
drill Ø in mm	2.6	0.032	0.025
	3.4	0.040	0.032
	4.3	0.050	0.040
	5.1	0.050	0.040
	5.6	0.050	0.040
	6.9	0.070	0.055
	7.1	0.070	0.055
	8.6	0.090	0.070
	9.1	0.090	0.070
	10.4	0.110	0.090
	10.5	0.110	0.090
	11.0	0.120	0.100
	14.1	0.120	0.100

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

Through holes

Stainless/acid.-resist. steels

Material no. to DIN EN 10 027	Abbreviation
Sulphured stainless steels	
1.4005	X 12 CrS 13
1.4104	X 14 CrMo S 17
1.4105	X 6 CrMo S 17
1.4305	X 8CrNi S 18-9
Austenitic stainless steels	
1.4300	X 12 CrNi 18-8
1.4301	X 5 CrNi 18-10
1.4541	X 6 CrNiTi 18-10
Martensitic stainless steels	
1.4057	X 17 CrNi 16-2
1.4112	X 90 CrMoV 18
1.4006	X 12 Cr 13

Shank designs

d_1 0,9 ... 2,6 mm

d_1 > 2,6 ... 10 mm

DIN 376 / DIN 374 / DIN 5156

Type clarification

VA AZ = with interrupted threads
VA R15 = Type VA, 15° RH spiral
VA R40 = Type VA, 40° RH spiral
VA R50 = Type VA, 50° RH spiral

Thread depth			≤3xD					
Tool material			HSS-E				HSS-E-PM	
Type/form			VA/B	VA/B	VA/B	VA AZ/B	VA/B	VA/B
Surface finish			○	●	(S)	○	○	(C)
Cooling			☒	☒	☒	☒	☒	☒
Tools with colour-ring			○	○	○	○	○	○
Thread type	Tolerance zone	Dim. to DIN 2184-1	Guhring no. Ø-range *Prices on page*					
M	ISO 2 6H	DIN 371	**1870** M2 – M10 *857*	**2869** M3 – M10 *859*	**2086** M3 – M10 *858*	**1871** M3 – M10 *857*	**877** M2 – M10 *861*	**1002** M2 – M12 *861*
	6HX							
	ISO 2 6H	DIN 376	**1872** M3 – M30 *874*	**2870** M3 – M30 *866*	**2087** M3 – M30 *875*	**792** M12 – M16 *862*	**879** M12 – M20 *863*	
	6HX							
MF	ISO 2 6H	DIN 374	**1873** M3x0,35 – M24x2 *884*	**2871** M3x0,35 – M24x1,5 *885*	**1001** M4x0,50 – M20x1,5 *885*		**887** M8x1 – M16x1,5 *885*	
	6HX							
UNC	2B	DIN ~ 371	**1980** Nr.3-48 – 3/8"-16 *899*	**2872** Nr.4-40 – 3/8"-16 *899*				
	2B	DIN ~ 376	**1985** 7/16"-14 – 1"-8 *901*	**2873** 1/2"-13 – 1"-8 *901*				
UNF	2B	DIN ~ 374	**1990** Nr.3-56 – 1"-12 *909*	**2874** Nr.4-48 – 1"-12 *909*				
BSP	–	DIN 5156	**967** G 1/16 – G7/8" *919*	**2875** G 1/8 – G1" *919*			**938** G 1/8 – G1/4" *919*	
NPT	-	Werksnorm						
NPTF	-	Werksnorm						

○ bright ● steam tempered ◐ nitrided lands ● nitrided ● golden brown (A) TiAlN (a) TiAlN nanoA (A) AlTiN SuperA

Blind holes

≤1,5xD				≤3xD						
HSS-E				HSS-E			HSS-E-PM			
VA R25/C	VA R15/C	VA R15/C	VA R25/C	VA R40/C	VA R40/C	VA R40/C	VA R40/C	VA R40/C	VA R50/C	VA R50/C
●	●	S	S	○	●	○	○	S	S	C
☒	☒	☒	☒	☒	☒	a	☒	☒	☒	a
									only suitable with synchro tapping shank tolerance h6	
○	○	○	○	○	○	○	○	○	○	○
Art.-Nr. Ø-range *Prices on page*				**Guhring no.** Ø-range *Prices on page*						
	843 M3 – M10 *844*	**2896** M3 – M10 *847*		**814** M3 – M10 *843*	**2862** M3 – M10 *846*	**1892** M5 – M10 *924*	**909** M3 – M10 *849*	**59** M3 – M10 *848*		
									761 M3 – M10 *852*	**1139** M5 – M10 *934*
	785 M12 – M24 *850*	**2895** M12 – M24 *851*		**825** M12 – M24 *850*	**2863** M12 – M24 *851*	**1899** M12 – M20 *926*	**910** M12 – M24 *851*	**60** M12 – M20 *851*		
									763 M12 – M20 *822*	**1142** M12 – M20 *934*
	1874 M4x0,5 – M22x2 *879*	**2897** M4x0,5 – M24x1,5 *882*			**2864** M3x0,35 – M24x1,5 *882*	**1906** M5x0,5 – M20x1,5 *936*	**936** M8x1 – M20x1,5 *883*	**1004** M12x1,5 – M20x1,5 *883* NEW		
									764 M8x1 – M20x1,5 *877*	**1144** M8x1 – M20x1,5 *935*
				1981 Nr.2-56 – 3/8“-16 *895*	**2865** Nr.2-56 – 3/8“-16 *896*			40° spiral flute tap with conical rear clearance		
				1986 7/16“-14 – 7/8“-9 *897*	**2866** 7/16“-14 – 7/8“-9 *898*					
	1991 Nr.3-56 – 1“-12 *905*		**2898** Nr.3-56 – 1“-12 *907*	**2867** Nr.6-56 – 1“-12 *907*	**2868** Nr.3-56 – 1“-12 *907*					
					968 G 1/16 – G1 1/2“ *917*		**939** G 1/8 – G1/2“ *917*		**4159** G 1/16 – G1/2“ *915* NEW	
1087 1/16 – 3/4 *920*			**1088** 1/16 – 3/4 *920*							
			4127 1/16 – 1 NEW *921*							

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

Suitable for CNC machining centres with synchro tapping chucks for extended tool life.

Through holes

Universal

Material no. to DIN EN 10 027 — Abbreviation

Structural steels

1.0035	S185 (St33)
1.0421	St 52.0
1.0067	RSt 37-1
1.0425	P265GH

Free-cutting steels

1.0711	9S20
1.0718	11SMnPb30
1.0727	46S20
1.0728	(60 S 20)

Case hardened steels

1.7131	16MnCr5
1.6523	21NiCrMo2-2
1.7321	20MoCr4
1.7325	25MoCr4

Unalloyed heat-treatable steels

1.0402	C22
1.1151	C22E
1.0503	C45
1.0601	C60

Nitriding steels

1.8504	34CrAl6
1.8507	34CrAlMo5
1.8509	41CrAlMo7
1.8515	31CrMo12
1.8550	34CrAlNi4

Spheroidal graphite iron

0.7040	EN-GJS-400-15
0.7060	EN-GJS-600-3

Shank designs

DIN 371

d_1 0.9 … 2.6 mm

d_1 > 2.6 … 10 mm

DIN 376 / DIN 374 / DIN 5156

Type clarification

(K) = rake angle correction
NR40 = Type N, 40° RH spiral
NR50 = Type N, 50° RH spiral

Thread depth	≤3xD						
Tool material	HSS-E				HSS-E-PM		Solid carbide*
Type/form	N/B	N/B	N/B	N/B	N/B	N/B	N/B
Surface finish		S	A+M	A+M	S	C	C
Cooling	☒	☒	☒	r	☒	☒	☒
					universal		Shank tolerance h6
Tools with colour-ring	○	○	○	○	○	○	

Thread type	Tolerance zone	Dim. to DIN 2184-1	Guhring no. Ø-range *Prices on page*						
M	ISO 2 6H	DIN 371	**2876** M2 – M10 *859*	**313** M3 – M10 *854*	**2427** M3 – M10 *858*	**2517** M5 – M10 *931*	**1285** M2 – M10 *861*	**1287** M3 – M20 *861*	
	ISO 3 6G		**2990** M2 – M10 *859*	**2991** M3 – M10 *859*					
	6HX	~ DIN 371/ *Guhring std.							**942** M5 – M12 *859*
	ISO 2 6H	DIN 376	**2877** M3 – M36 *875*	**315** M3 – M24 *872*	**2428** M3 – M16 *875*		**1286** M12 – M20 *863*		
MF	6HX	~ DIN 371							**943** M5x0,5 – M12x1,5 *890*
	ISO 2 6H	DIN 374	**2879** M3x0,35 – M52x1,5 *885*		**2878** M3x0,35 – M24x1,5 *885*		**1291** M8x1 – M24x2 *889*		
	6HX								**944** M14x1 – M16x1,5 *886*
	ISO 3 6G		**2992** M8x1 – M18x1,5 *885*	**2993** M8x1 – M18x1,5 *885*					
UNC	2B	DIN ~ 371	**2881** Nr.4-40 – 3/8"-16 *900*		**2880** Nr.4-40 – 3/8"-16 *899*				
	2B	DIN ~ 376	**2883** 7/16"-14 – 1"-8 *901*						
UNF	2B	DIN ~ 374	**2885** Nr.4-48 – 1"-12 *909*		**2884** Nr.4-48 – 1"-12 *909*				
G BSP	–	DIN 5156	**2887** G 1/8 – G2" *919*		**2886** G 1/8 – G1" *919*				
EG M	6H mod.	DIN 40435		**1010** M4 – M16 *923*					

bright · steam tempered · nitrided lands · nitrided · golden brown · A TiAlN · a TiAlN nanoA · A AlTiN SuperA

Blind holes

≤3xD

HSS-E									HSS-E-PM			
NR15/C	NR15/E	NR40/C	NR40/C	NR40/C	NR40/C	NR40/C	NR40/E	NR40/C(K)	NR40/C	NR40/C	NR50/C	NR50/C
C	C			S	A+M	A+M		S	S	C	S	C
☒	☒	☒	☒	☒	☒	a	☒	☒	☒	☒	☒	a
											universal	
○	○	○	○	○	○	○	○	○	○	○	○	○
Guhring no. Ø-range *Prices on page*												
4154 M5 – M10 *847*	**4155** NEW M5 – M10 *847*	**889** NEW M2 – M10 *844*	**836** M2 – M10 *844*	**2440** M3 – M10 *845*	**2425** M3 – M10 *845*	**2514** M5 – M10 *945*	**2790** M4 – M10 *846*	**174** M5 – M10 *842*	**1288** M2 – M10 *849*	**1290** M2 – M20 *849*	**767** M3 – M10 *848*	**1152** M5 – M10 *925*
			2994 M3 – M10 *847*	**2995** M3 – M10 *847*								
				4153* NEW M3 – M20 *867*								
		890 M3 – M24 *871*	**826** M3 – M36 *871*	**2441** M3 – M24 *871*	**2426** M3 – M16 *871*		**2791** M4 – M16 *865*	**196** M5 – M30 *865*	**1289** M12 – M20 *851*		**1098** M12 – M20 *851*	**1293** M12 – M20 *927*
4156 NEW M8x1 – M16x1,5 *883*	**4157** NEW M8x1 – M16x1,5 *883*	**2424** M5x0,5 – M24x2 *879*	**2853** M5x0,5 – M30x2 *879*				**2792** M8x1 – M14x1,5 *879*	**273** M5x0,5 – M24x1,5 *878*	**1292** M8x1 – M24x2 *883*		**1100** M8x1 – M20x1,5 *883*	**1294** M8x1 – M20x1,5 *936*
		2998 M8x1 – M20x1,5 *883*	**2999** M10x1 – M20x1,5 *883*	**1049** M8x1 – M20x1,5 *879*								
		2854 Nr.2-56 – 3/8"-16 *896*	**2855** Nr.2-56 – 3/8"-16 *896*					**1837** Nr.10-24 – 3/8"-16 *895*				
		2856 7/16"-14 – 1"-8 *898*	**2857** 7/16"-14 – 7/8"-9 *898*									
		2858 Nr.3-56 – 1"-12 *907*	**2859** Nr.3-56 – 1"-12 *907*					**1838** Nr.10-32 – 1"-12 *905*				
	4158 NEW G 1/16 – G1" *917*	**2860** G 1/16 – G1 1/2" *917*	**2861** G 1/16 – G2" *917*					**937** G 1/8 – G1 1/2" *916*				
				1011 M4 – M16 *922*								

40° spiral flute tap with conical rear clearance

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* Guhring std.

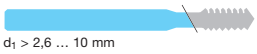
Al and Al-alloys

Material no.	Abbreviation
Al and Al-alloys	
3.0250	Al 99,5H
3.0280	AL 99,8H
3.3308	Al99,9Mg0,5
Al wrought alloys	
3.2315	AlMgSi1
3.1655	AlCuMgPb
3.4335	AlZn4,5Mg1
Al cast alloys ≤ 10% Si	
3.2134	GD-AlSi5Cu1Mg
3.2162	GD-AlSi8Cu3
3.2373	G-AlSi9Mg
Al cast alloys > 10% Si	
3.2581	G-AlSi12
3.2583	G-AlSi12Cu
3.2581	G-AlSi10Mg

Shank designs

DIN 371

d_1 0,9 ... 2,6 mm



d_1 > 2,6 ... 10 mm

DIN 376 / DIN 374 / DIN 5156

Type clarification

Al = for aluminium
AlR15 = for Al, 15° RH spiral
AlR45 = for Al, 45° RH spiral
NR15 = Type N, 15° RH spiral
NL15 = Type N, 15° LH spiral

* < M5 without coolant ducts

			Through holes				Blind holes			
		Thread depth	1,5			≤3xD	1,5			≤3xD
		Tool material	HSS-E			HSS-E	HSS-E			HSS-E
		Type/form	N/B	H/C	H/C	Al/B	H/C	H/C	H/E	AlR45/B
		Surface finish	○	C	C	○	C	C	C	○
		Cooling	☒	a	a	☒	a	a	a	☒
		Tools with colour-ring	for machining sheet metal			○				○
Thread type	Tolerance zone	Dim. to DIN 2184-1	Guhring no. Ø-range *Prices on page*				Guhring no. Ø-range *Prices on page*			
M	ISO 2 6H	DIN 371	**838** M1,4 – M10 *856*			**805** M2 – M10 *855*				**812** M1,6 – M10 *843*
	ISO 3 6G		**869** M2 – M10 *857*							
	6HX				**302** M5 – M10 *931*			**302** M5 – M10 *931*	**1091** M5 – M10 *931*	
	ISO 2 6H	DIN 376	**846** M3 – M20 *866*			**817** M12 – M24 *862*				**824** M3 – M24 *871*
	6HX			**778** M16 – M39 *850* NEW	**297** M10 – M14 *933*		**778** M16 – M39 *850* NEW	**297** M10 – M12 *933*	**4165** M10 – M12 *933*	
MF	ISO 2 6H	DIN 371								
	ISO 2 6H	DIN 374								
	6HX				**1090** M8x1 – M12x1,5 *937*			**1090** M8x1 – M12x1,5 *937*	**1007** M8x1 – M16x1,5 *937*	

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A AlTiN SuperA

			Through holes		Blind holes				
		Thread depth	≤3xD		≤3xD				
		Tool material	Solid carbide		Solid carbide				
		Type/form	H/C	NL15/D	H/C	H/E	H/C	NR15/C	NR15/C
		Surface finish	○	○	○	○	○	○	M
		Cooling	r	r	a	a	r	a	a
			Shank tolerance h6	Shank tolerance h6	Shank tolerance h6	Shank tolerance h6	Shank tolerance h6	Shank tolerance h6	Shank tolerance h6
○ Tools with colour-ring									
Thread type	Tolerance zone	Dim. to DIN 2184-1	Guhring no. Ø-range *Prices on page*		Guhring no. Ø-range *Prices on page*				
M	**6HX**	**DIN 371**	**1858** M5 – M10 *929*		**969 *** M3 – M10 *928*	**1008** M3 – M10 *929*	**1858** M5 – M10 *929*	**971 *** M3 – M10 *928*	**2516** M5 – M10 *929*
	6HX	**DIN 376**	**1859** M12 – M20 *930*		**1883** M12 – M20 *930*		**1859** M12 – M20 *930*		
MF	**6HX**	**DIN 371**	**1861** M5x0,5 – M10x1 *939*	**975 *** M4x0,5 – M10x1 *938*	**972 *** M4x0,5 – M10x1 *938*	**1009** M10x1 – M16x1,5 *939*	**1861** M5x0,5 – M10x1 *939*	**977 *** M4x0,5 – M10x1 *938*	
	6HX	**DIN 374**	**1860** M12x1,5 – M20x1,5 *939*	**976** M12x1,5 – M18x1,5 *939*	**974** M12x1,5 – M16x1,5 *939*		**1860** M12x1,5 – M16x1,5 *939*	**978** M12x1,5 – M20x1,5 *939*	

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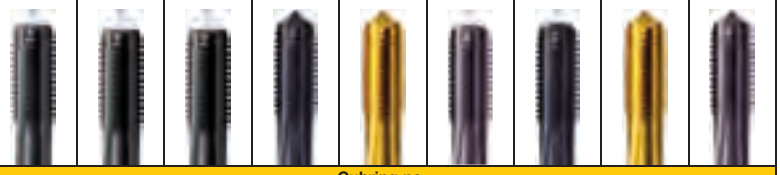
Through holes and blind holes

Cast materials

Material no.	Abbreviation
Cast iron	
0.6015 (GG15)	EN-GJL-150
0.6025 (GG25)	EN-GJL-250
0.6040 (GG40)	EN-JLZ
Spheroidal graphite & malleable cast iron	
0.7040 (GGG40)	EN-GJS-400-15
0.7060 (GGG60)	EN-GJS-600-3
0.8035	EN-GJMW-350-4
0.8135	EN-GJMB-350-10
Cast iron with vermicular graphite	
–	EN-GJV250
	EN-GJV350
	EN-GJV400
	EN-GJV500

Tools with colour-ring



Thread depth	≤3xD								
Tool material	HSS-E								
Type/form	H/C	H/C	H/E	GG/C	GG/C	GG/C	GG/C	GGT/C	GGT/C
Surface finish	C	C	C	●	S	A	●	S	A
Cooling	a	a	a	☒	☒	a	a	☒	☒

Thread type	Tolerance zone	Dim. to DIN 2184-1	Guhring no. Ø-range *Prices on page*								
M	ISO 2 6H	DIN 371								**1875** M3 – M10 *857*	
	6HX			**302** M5 – M10 *931*	**1091** M5 – M10 *931*	**807** M3 – M10 *856*	**930** M3 – M10 *857*	**318** M5 – M10 *931*	**1890** M5 – M10 *931*		**1918** M3 – M10 *858*
	ISO 2 6H	DIN 376								**1876** M3 – M30 *866*	
	6HX		NEW **778** M16 – M39 *850*	**297** M10 – M14 *933*	NEW **4165** M10 – M20 *933*	**819** M3 – M30 *873*	**931** M3 – M30 *874*	**319** M12 – M20 *932*	**1897** M12 – M20 *932*	*875*	**1919** M3 – M20
MF	6HX	DIN 371									
	6HX	DIN 374		**1090** M8x1 – M12x1,5 *937*	**1007** M8x1 – M16x1,5 *937*	**831** M3x0,35 – M30x1,5 *884*	**932** M3x0,35 – M30x1,5 *887*	**347** M8x1 – M24x1,5 *937*	**1904** M8x1 – M20x1,5 *937*		**169** M3x0,35 – M24x1,5 *884*
UNC	2B	~ DIN 371				**1979** Nr.2-56 – 3/8"-16 *899*		**1085** Nr.10-24 – 3/8"-16 *940*			
	2B	~ DIN 376				**1984** 7/16"-14 – 1"-8 *901*		**1086** 7/16"-14 – 7/8"-9 *940*			
UNF	2B	~ DIN 374				**1989** Nr.3-56 – 1"-12 *908*		**1082** Nr.10-32 – 7/8"-14 *941*			
G BSP	–	DIN 5156				**961** G 1/16 – G2" *918*					

Shank designs

DIN 371

d_1 0,9 … 2.6 mm

d_1 > 2.6 … 10 mm

DIN 376 / DIN 374 / DIN 5156

Type clarification

GG = for cast iron
GGT = for dry machining grey cast iron
NR15 = Typ N, 15° RH spiral

a With internal cooling, tools with axial coolant duct are, as a rule, only suitable for the machining of blind holes. Without internal cooling, i.e. external cooling, the tools are also suitable for through holes.

** < M5 without coolant ducts

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≤3xD					
Solid carbide*					
H/C	H/E	H/C	H/C	H/C	NR15/C
○	○	○	A	A	A
a	a	r	r	a	a
Schafttoleranz h6	Schafttoleranz h6	Schafttoleranz h6	Schafttoleranz h6	Schafttoleranz h6	Schafttoleranz h6
Guhring no. Ø-range *Prices on page*					
969 * M3 – M10 *928*	**1008** M3 – M10 *928*	**1858** M5 – M10 *929*	**2311** M5 – M10 *929*	**2506** M5 – M10 *929*	**2510** M5 – M10 *929*
1883 M12 – M20 *930*		**1859** M12 – M20 *930*			
972 * M4x0,5 – M10x1 *938*	**1009** M10x1 – M16x1,5 *939*	**1861** M5x0,5 – M10x1 *939*			
974 M12x1,5 – M20x1,5 *939*		**1860** M12x1,5 – M20x1,5 *939*			

Magnesium-alloys

Material no.	Abbreviation
Magnesium-alloys	
3.5200	MgMn2
3.5612	MgAl6Zn
3.5812	MgAl8Zn
3.5812.05	GDMgAl8Zn1
3.5612.05	GDMgAl6Zn1
3.5662.01	GMgAl6

Shank designs

DIN 376

Type clarification

NAZ = with interrupted threads

a With internal cooling, tools with axial coolant duct are, as a rule, only suitable for the machining of blind holes. Without internal cooling, i.e. external cooling, the tools are also suitable for through holes.

Thread depth	≤3xD
Tool material	HSS-E
Type/form	NAZ/E
Surface finish	A + M
Cooling	a

Thread type	Tolerance zone	Dim. to DIN 2184-1	Guhring no. Ø-range *Prices on page*
M	**ISO 2 6H**	**DIN 371**	
	6HX		
	ISO 2 6H	**DIN 376**	**2899** M5 – M12 **933**
	6HX		

Threading tools

C TiCN Cb Carbo D Cristall F FIRE/nanoFIRE P AlCrN S TiN S+ TiN+ M MolyGlide Y Signum

Special alloys

Material no.	Abbreviation
Titanium	
3.7025	Ti
3.7065	Ti
Titanium-alloys	
3.7115	TiAl 5Sn2
3.7165	TiAl 6 V4
Special alloys	
2.4610	Hastelloy C4
2.4876	Incoloy 800
2.4816	Inconel 600
2.4668	Inconel 718
2.4634	Nimonic 105
	CuNi12Zn24
	CuNi18Zn20

Shank designs

DIN 371

d_1 0.9 … 2.6 mm

d_1 > 2.6 … 10 mm

Type clarification

TiR30 = for titanium, 30° RH spiral
NiR15 = for nickel, 15° RH spiral

			Through holes		Blind holes	
		Thread depth	≤2xD		≤2xD	
		Tool material	HSS-E-PM		HSS-E-PM	
		Type/form	Ti/B	Ni/B	TiR15/C	NiR10/C
		Surface finish	C	A	C	A
		Cooling	☒	☒	☒	☒
Thread type	Tolerance zone	Dim. to	Guhring no. Ø-range *Prices on page*		Guhring no. Ø-range *Prices on page*	
M	**6HX**	**DIN 371**	**2901** M3 – M10 *863*	**2916** M3 – M10 *863*	**2909** M3 – M10 *863*	**2920** M3 – M10 *863*
	6HX	**DIN 376**	**2901** M12 – M16 *863*	**2916** M12 – M16 *863*	**2909** M12 – M16 *863*	**2920** M12 – M16 *863*
MF	**6HX**	**DIN 371**	**2903** M3x0,35 – M10x1 *892*	**2917** M3x0,35 – M10x1,25 *892*	**2910** M3x0,35 – M10x1 *892*	**2921** M3x0,35 – M10x1,25 *892*
UNC	**2BX**	**~ DIN 371**	**2905** Nr.6-32 – 3/8"-16 *900*	**2918** Nr.6-32 – 3/8"-16 *900*	**2912** Nr.4-40 – 3/8"-16 *903*	**2922** Nr.4-40 – 3/8"-16 *903*
	2BX	**~ DIN 376**			**2912** 7/16"-14 – 5/8"-11 *903*	**2922** 7/16"-14 – 5/8"-11 *903*
UNF	**2BX**	**~ DIN 371**	**2907** Nr.6-40 – 3/8"-24 *910*	**2919** Nr.6-40 – 3/8"-24 *910*	**2914** Nr.4-48 – 3/8"-24 *910*	**2923** Nr.4-48 – 3/8"-24 *910*
	2BX	**~ DIN 376**			**2914** 7/16"-20 – 5/8"-18 *910*	**2923** 7/16"-20 – 5/8"-18 *910*

bright · steam tempered · nitrided lands · nitrided · golden brown · A TiAlN · a TiAlN nanoA · A AlTiN SuperA

Special alloys

Material no.	Abbreviation
Titanium	
3.7025	Ti
3.7065	Ti
Titanium-alloys	
3.7115	TiAl 5Sn2
3.7165	TiAl 6 V4
Special alloys	
2.4610	Hastelloy C4
2.4876	Incoloy 800
2.4816	Inconel 600
2.4668	Inconel 718
2.4634	Nimonic 105
	CuNi12Zn24
	CuNi18Zn20

Shank designs

DIN 371

d_1 0.9 … 2.6 mm

d_1 > 2.6 … 10 mm

Type clarification

TiR30 = for titanium, 30° RH spiral
NiR15 = for nickel, 15° RH spiral

			Through holes	Blind holes	
		Thread depth	≤2xD	≤2xD	
		Tool material	HSS-E-PM	HSS-E-PM	
		Type/form	Ti/Ni/B	TiR15/C	NiR10/C
		Surface finish	C	C	A
		Cooling	☒	☒	☒
Thread type	Tolerance zone	Dim. to	Guhring no. Ø-range *Prices on page*	Guhring no. Ø-range *Prices on page*	
MJ	4HX	DIN 371	1057 M3 – M10 *841*	1061 M3 – M10 *841*	1065 M3 – M10 *841*
	4HX	DIN 376	1057 M12 – M16 *841*	1061 M12 – M16 *841*	1065 M12 – M16 *841*
MJF	4HX	DIN 371	1058 M6x0,5 – M10x1,25 *891*	1062 M6x0,5 – M10x1,25 *891*	1066 M6x0,5 – M10x1,25 *891*
UNJC	3BX	~ DIN 371	1059 Nr.6-32 – 3/8"-16 *904*	1063 Nr.6-32 – 3/8"-16 *904*	1067 Nr.6-32 – 3/8"-16 *904*
	3BX	~ DIN 376	1059 7/16"-14 – 5/8"-11 *904*	1063 7/16"-14 – 5/8"-11 *904*	1067 7/16"-14 – 5/8"-11 *904*
UNJF	3BX	~ DIN 371	1060 Nr.6-40 – 3/8"-24 *911*	1064 Nr.6-40 – 3/8"-24 *911*	1068 Nr.4-48 – 3/8"-24 *911*
	3BX	~ DIN 376	1060 7/16"-20 – 5/8"-18 *911*	1064 7/16"-20 – 5/8"-18 *911*	1068 7/16"-20 – 5/8"-18 *911*

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

Non-ferrous metals

Material no.	Abbreviation
Brass, short-chipping	
2.0380	CuZn39Pb2
2.0401	CuZn39Pb3
2.0410	CuZn43Pb2
Brass, long-chipping	
2.0250	CuZn20
2.0280	CuZn33
2.0332	CuZn37Pb0,5

Shank designs

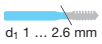
DIN 371

d_1 0.9 … 2.6 mm

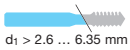
d_1 > 2.6 … 10 mm

DIN 376 / DIN 374

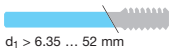
DIN 352



d_1 1 … 2.6 mm



d_1 > 2.6 … 6.35 mm



d_1 > 6.35 … 52 mm

* < M5 without coolant ducts

Type clarification

Ms = for brass
NR15 = Tyep N, 15° RH spiral
NR40 = Type N, 40° RH spiral

			Through holes			Blind holes		
		Thread depth	≤3xD			≤3xD		
		Tool material	HSS-E			HSS-E		
		Type/form	N/B	N/B	N/B	NR15/C	NR40/C	NR15/C
		Surface finish	○	○	○	○	○	○
		Cooling	☒	☒	☒	☒	☒	a
				for machining sheet metal				
Tools with colour-ring							○	○
Thread type	Tolerance zone	Dim. to DIN 2184-1	Guhring no. Ø-range *Prices on page*			Guhring no. Ø-range *Prices on page*		
M	**ISO 2 6H**	**DIN 371**		**839** M1 – M10 *857*	**838** M1,4 – M10 *856*	**809** M2 – M10 *843*	**889** M2 – M10 *844*	**1891** M5 – M10 *924*
	6HX							
	ISO 3 6G			**796** M2 – M10 *855*	**869** M2 – M10 *857*			
	ISO 2 6H	**DIN 376**		**847** M3 – M10 *873*	**846** M3 – M20 *866*	**821** M3 – M30 *870*	**890** M3 – M24 *871*	**1898** M12 – M20 *926*
	6HX							
MF	**6HX**	**DIN 371**						
	6HX	**DIN 374**						
M short version	**ISO 2 6H**	**Dim. to DIN 2184-2 DIN 352**	**991** M2 – M24					

○ bright ○ steam tempered ◐ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A AlTiN SuperA

Through holes

HSS-E	Solid carbide*
Ms/E	H/C
◯	◯
⊠	r
	Shank tolerance h6
Guhring no. Ø-range *Prices on page*	
800 M3 – M10 *855*	
	1858 M5 – M10 *929*
1084 M3 – M10 *861*	

Blind holes

HSS-E	Solid carbide*			
Ms/E	NR15/C	H/C	H/E	H/C
◯	◯	◯	◯	◯
⊠	a	a	a	r
	Shank tolerance h6	Shank tolerance h6	Shank tolerance h6	Shank tolerance h6
Guhring no. Ø-range *Prices on page*				
800 M3 – M10 *855*				
	971* M3 – M10 *928*	**969*** M3 – M10 *928*	**1008** M3 – M10 *929*	**1858** M5 – M10 *929*
1084 M3 – M10 861				
		1883 M12 – M20 *930*		
		972* M4x0,5 – M10x1 *849*	**1009** M10x1 – M16x1,5 *939*	
		974 M12x1,5 – M16x1,5 *883*		

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

Plastics

Material no. Abbreviation

Duroplastics

– Bakelit
Resopal
Pertinax
Moltopren

Thermoplastics

– Plexiglas
Hostalen
Novodur
Makralon

Glass-/carbon-reinforced plastics

– Polypropylen
GFK
CFK

Shank designs

DIN 371

d_1 0.9 ... 2.6 mm

d_1 > 2.6 ... 10 mm

DIN 376 / DIN 374

Type clarification

HAZ = with interrupted threads
NL15 = Type N, 15° LH spiral
NR15 = Type N, 15° RH spiral

* < M5 without coolant ducts

			Through holes			Blind holes				
		Thread depth	≤3xD			≤3xD				
		Tool material	HSS-E	Solid carbide*		HSS-E	Solid carbide*			
		Type/form	HAZ/C	NL15/C	H/C	HAZ/C	NR15/C	H/C	H/E	H/C
		Surface finish	●	○	○	●	○	○	○	○
		Cooling	⊠	r	r	⊠	a	a	a	r
				Shank tolerance h6	Shank tolerance h6		Shank tolerance h6	Shank tolerance h6	Shank tolerance h6	Shank tolerance h6
Thread type	Tolerance zone	Dim. to DIN 2184-1	Guhring no. Ø-range *Prices on page*			Guhring no. Ø-range *Prices on page*				
M	**ISO 2 6H**	**DIN 371**	**788** M2 – M10 *854*			**788** M2 – M10 *854*				
	6HX				**1858** M5 – M10 *929*		**971 *** M3 – M10 *928*	**969 *** M3 – M10 *928*	**1008** M3 – M10 *929*	**1858** M5 – M10 *929*
	6HX	**DIN 376**			**1859** M12 – M20 *930*			**1883** M12 – M20 *930*		**1859** M12 – M20 *930*
MF	**6HX**	**DIN 371**		**975 *** M4x0,5 – M10x1 *938*	**1861** M5x0,5 – M10x1 *939*		**977 *** M4x0,5 – M10x1 *938*	**972 *** M4x0,5 – M10x1 *938*	**1009** M10x1 – M16x1,5 *939*	**1861** M5x0,5 – M10x1 *939*
	6HX	**DIN 374**		**976** M12x1,5 – M18x1,5 *939*	**1860** M12x1,5 – M16x1,5 *939*		**978** M12x1,5 – M20x1,5 *939*	**974** M12x1,5 – M16x1,5 *939*		**1860** M12x1,5 – M20x1,5 *939*

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A AlTiN SuperA

Material group		Tens. strength MPa (N/mm²)	Hardness HB	Cutting speed v_c m/min*		
				HSS-E	HSS-E-PM	Solid carbide
	Structural steels	≤ 850	–	10 - 15	15 - 20	30 - 50
	Free-cutting steels	≤ 1000	–	10 - 20	15 - 25	30 - 50
	Unalloyed case hardened steels	≤ 750	–	10 - 15	15 - 20	30 - 50
	Unalloyed heat-treatable steels	≤ 850	–	10 - 15	15 - 20	30 - 50
	Alloyed case hardened steels	≥ 850 … 1200	–	8 - 12	10 - 15	25 - 40
	Alloyed heat-treatable steels	≥ 850 … 1200	–	8 - 12	10 - 15	25 - 40
	Alloyed tool steels	≤ 1000	–	6 - 10	8 - 12	25 - 40
	High speed tool steels	≥ 650 … 1000	–	6 - 10	8 - 12	25 - 40
	Stainless- and acid-resistant steels, sulphured	≤ 850	–	6 - 12	8 - 15	30 - 50
	austenitic	≤ 850	–	6 - 12	8 - 15	30 - 50
	martensitic	≤ 850	–	6 - 12	8 - 15	30 - 50
	Structural steels	≤ 800	–	10 - 15	15 - 20	30 - 50
	Free-cutting steels	≤ 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 iron	–	≤ 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
	Al cast alloys ≤ 10 % Si	≤ 600	–	15 - 20	20 - 25	30 - 50
	> 10 % Si	≤ 600	–	15 - 20	20 - 25	25 - 40
	Cast iron	–	≤ 240	15 - 20	20 - 25	30 - 40
	Spheroidal graphite iron	–	≤ 240	15 - 20	20 - 25	30 - 40
	Malleable cast iron	–	< 300	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	7 -12	10 - 20
	Magnesium-alloys	≤ 450	–	30 - 50	-	40 - 60
	Titanium and Ti-alloys	≤ 1200	–	-	2 - 8	-
	Ni-alloys	≤ 1200	–	-	2 - 8	-

* With coated tools cutting speed may be increased by up to 50%.

Application alternatives

If the optimal tap for your application is not available, perhaps you can use a tap with another colour ring. The table below gives you a view to possible alternatives.

We recommend a machining test with the selected alternative tool! Cutting speed, tool life and machining quality may not fit the performance of the otimally suited tool.

		possibly can be replaced by tools with colour ring …					
Tools with colour ring …			–		++		–
		–		–	+	–	–
		–	–		+	–	–
		++	+	+			+
		+	–	–	+		–
		–	–	–	+	–	

++ optimally suited + limited suited – not suited

C TiCN Cb Carbo D Cristall F FIRE/nanoFIRE P AlCrN S TiN S+ TiN+ M MolyGlide Y Signum

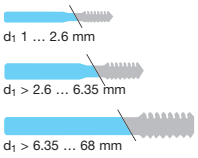
Threading tools

General steels

Material no. to DIN EN 10 027	Abbreviation
Structural steels	
1.0035	S 185 (St 33)
1.0039	S 235 JRH
1.0036	S 235JRG1+CR
1.0060	E 335 (St 60-2)
Free-cutting steels	
1.0718	11SMnPb30
1.0721	10S20
1.0758	60SPb20
1.0726	35S20
Case hardened steels	
1.0401	(C 15)
1.7016	17 CR3
1.7131	16MnCr5
1.5919	15CrNi6
Unalloyed heat-treabable steels	
1.0402	C 22
1.1151	C22E (Ck 22)
1.0503	C 45
1.1191	C45E (Ck 45)

Shank designs

DIN 352 / DIN 2181



DIN 5157

Designation

First tap — 1 groove — V

Second tap — 2 grooves — M

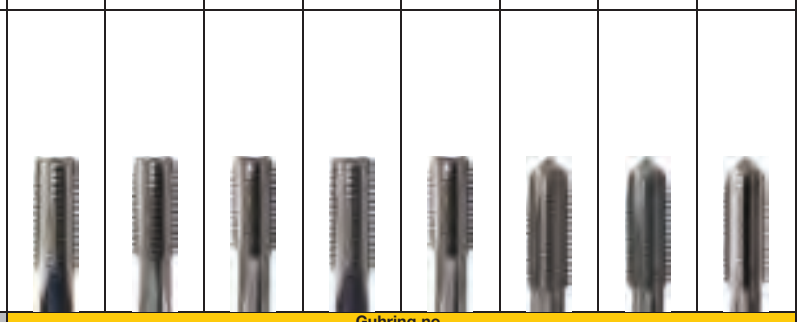
Bottoming tap — without marking — F

Through holes and blind holes

Tool material	HSS							
Type	N	N	N	N	N	N-LH	N-LH	N-LH
Surface finish	○	○	○	○	○	○	○	○
Designation	V	M	F	V	F	V	M	F

The hand tap sets Guhring no. 861. 882 and 904 are also suitable for

- **high tensile steels ≤ 800…1200 N/mm²**
- **for stainless and acid-resistant steels**



Thread type	Tolerance zone	Dim. to DIN 2184-2	Guhring no. Ø-range *Prices on page*		
M	**ISO 2 6H**	**DIN 352**	**861 (Set)** consisting of: **862** **863** **864** M1 – M36 *822*	**882 (Set)** consisting of: **883** **864** M2 – M12 *824*	**904 (Set)** consisting of: **905** **906** **907** M2.2 – M22 *895*
MF	**ISO 2 6H**	**DIN 2181**		**884 (Set)** consisting of: **885** **886** M2x0.25 – M52x1.5 *829*	
UNC	**2B**	**~ DIN 352**	**981 (Set)** consisting of: **982** **983** **984** Nr.1-64 – 2“-4.5 *831*		
UNF	**2B**	**~ DIN 2181**		**985 (Set)** consisting of: **986** **987** Nr.1-72 – 1 3/8 “-12 *832*	
BSW	**–**	**~ DIN 352**	**954 (Set)** consisting of: **955** **956** **957** W1/16“ – W2“ *833*		
G BSP	**–**	**DIN 5157**		**958 (Set)** consisting of: **959** **960** G1/8“ – G2“ *834*	

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A AlTiN SuperA

Through holes and blind holes

High tensile steels

Material no. to DIN EN 10 027 — Abbreviation

Alloyed heat-treabable steels

1.6511	36 CrNiMo 4
1.7033	34 Cr 4
1.7225	42 CrMo 4

Tool steels

1.2316	X 36 CrMo 17
1.2067	10 S20

High speed steels

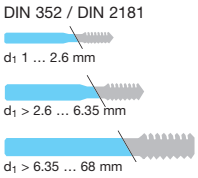
1.3343	HS 6-5-2
1.3344	HS 6-5-3
1.3243	HS 6-5-2-5
1.3247	HS 2-19-1-8

Hardened steels

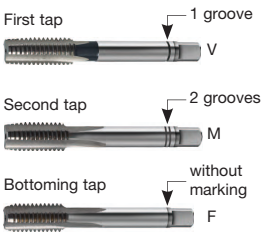
All steel examples are hardened to 45 … 62 HRC

Shank designs

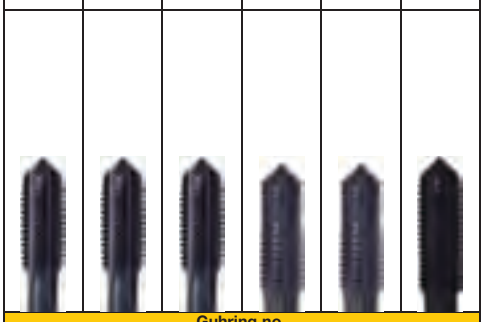
DIN 352 / DIN 2181



Designation



HSS-E			HSS-E-PM		
H	H	H	H	H	H
●	●	●	●	●	●
V	M	F	V	M	F



Guhring no.
Ø-range
Prices on page

857 (Set) consisting of: 858 859 860 M2 – M20 *827*	1818 (Set) consisting of: 1819 1820 M3 – M12 *828*

Stainl./acid-resist. steels

Material no. to DIN EN 10 027 — Abbreviation

Sulphured stainless steels

1.4005	X 12 CrS 13
1.4104	X 14 CrMo S 17
1.4105	X 6 CrMo S 17
1.4305	X 8CrNi S 18-9

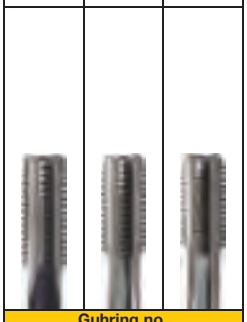
Austenitic stainless steels

1.4300	X 12 CrNi 18-8
1.4301	X 5 CrNi 18-10
1.4541	X 6 CrNiTi 18-10

Martensitic stainless steels

1.4057	X 17 CrNi 16-2
1.4112	X 90 CrMoV 18
1.4006	X 12 Cr 13

HSS-E		
VA	VA	VA
○	○	○
V	M	F



Guhring no.
Ø-range
Prices on page

853 (Set) consisting of: 854 855 856 M2 – M20 *826*

Threading tools

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

Through holes and blind holes

Material examples

Suitable malleable materials see table "Cutting recommendations".

Shank designs

~DIN 371

d_1 2 ... 2.6 mm

d_1 3 ... 10 mm

~DIN 376 / ~DIN 374 / DIN 2189

Generally the application of bright fluteless taps is not recommended. Guhring offers bright fluteless taps in its standard range only as basic tools for a cost efficient coating to customer specific requirements.

* < Ø M5 = without coolant ducts

		Tool material	HSS-E				
		Type/form	N/C	N/C	N/C	N/C	N/C
		Surface finish	S	P	C	S	C
		Cooling	☒	☒	☒	a	r
Rec. parameters see table "Cutting recommendations"							
Thread type	Tolerance zone	Dim. to	**Guhring no.** Ø-range *Prices on page*				
M	**6HX**	**DIN 2174 ~ DIN 371**	**919** M3 – M10 *956*	**1587** M3 – M10 *956*	**2012** M3 – M10 *955*	**2442** M5 – M10 *969*	**2446** M5 – M10 *969*
	6GX		**918** M3 – M10 *956*	**1588** M3 – M10 *956*		**2443** M5 – M10 *969*	**2447** M5 – M10 *970*
	6HX	**DIN 2174 ~ DIN 376 *Guhring std.**	**923** M6 – M39 *958*	**1589** M6 – M20 *958*	**2013** M12 – M20 *957*	**2444** M12 – M16 *971*	**2448** M12 – M16 *971*
	6GX		**922** M6 – M20 *958*	**1590** M12 – M20 *957*		**2445** M12 – M16 *971*	
MF	**6HX**	**DIN 2174 ~ DIN 371**	**1275** M6 x 0,75 – M10x1,25 *961*	**1591** M8 x 1 – M10 x 1 *961*			
	6GX		**1277** M8 x 1 – M10 x 1 *961*	**1592** M8 x 1 – M10 x 1 *961*			
	6HX	**DIN 2174 ~ DIN 374 *Guhring std.**	**927** M6 x 0,75 – M24 x 1,5 *964*	**1593** M12 x 1 – M24 x 1,5 *960*	**2008** M6 x0,75 – M20 x 1,5 *964*		
	6GX		**926** M8 x 1 – M24 x 1,5 *964*	**1594** M12 x 1 – M24 x 1,5 *960*			
UNC	**2BX**	**DIN 2184-1 ~ DIN 371**	**1582** Nr.4-40 – 3/8" - 16 *965*				
	2BX	**DIN 2184-1 ~ DIN 376**	**1583** 7/16"-14 – 3/4" - 10 *965*				
UNF	**2BX**	**DIN 2184-1 ~ DIN 371**	**1584** Nr.4-48 – 3/8" - 24 *966*				
	2BX	**DIN 2184-1 ~ DIN 374**	**1585** 7/16" - 20 – 3/4" - 16 *966*				
BSP	**–**	**DIN 2184-1 DIN 2189**	**1586** G1/16" – G3/4" *967*				

bright · steam tempered · nitrided lands · nitrided · golden brown · TiAlN · TiAlN nanoA · AlTiN SuperA

HSS-E	HSS-E-PM								Solid carbide	
N/C	N/C	N/C	N/C	N/C	N/C	N/C	N/C	N/E	N/C	N/E
Cb	S	S	P	S+	S	C	A	S	A	A
a	☒	☒	☒	r	a	r	r	a	r	r
									Shank tolerance h6	Shank tolerance h6
Guhring no. Ø-range *Prices on page*										
2515 M5 – M20 *969*	**322** M3 – M10 *954*	**1266** M3 – M10 *957*	**1599** M3 – M10 *957*	**323** M5 – M10 *970*		**1270** M5 – M10 *972*	**1717** M5 – M10 *972*	**1725*** M3 – M10 *972*	**1972*** M3 – M10 *968*	**1927*** M3 – M10 *968*
4146 M5 – M20 *969*			**1705** M3 – M10 *957*			**1713** M5 – M10 *973*	**1718** M5 – M10 *973*	**1726** M3 – M10 *972*		
	339 M12 – M16 *954*	**1267** M12 – M20 *957*	**1707** M12 – M20 *957*	**342** M12 – M16 *971*	**4143*** M3 – M20 *974*	**1271** M12 – M20 *973*	**1719** M12 – M20 *973*	**1727** M12 – M20 *973*	**1931** M12 – M20 *971*	
			1708 M12 – M20 *957*			**1714** M12 – M20 *973*	**1720** M12 – M20 *973*	**1728** M12 – M20 *973*		
4147 M8 x 1 – M16x1,5 *975*	**1284** M6 x 0,75 – M10 x 1,25 *959*	**1268** M8 x 1 – M10 x 1,25 *961*				**1272** M8 x 1 – M10 x 1,25 *978*	**1721** M8 x 1 – M10 x 1,25 *978*	**1729** M8 x 1 – M10 x 1,25 *976*	**1581** M10 x 1 *977*	
4151 M8 x 1 – M16 x 1,5 *975*			**1710** M8 x 1 – M10 x 1 *963*			**1715** M8 x 1 – M10 x 1,25 *979*		**1730** M8 x 1 – M10 x 1,25 *978*		
	333 M8 x 1 – M20 x 1,50 *963*	**1269** M12 x 1 – M24 x 2 *960*	**1711** M12 x 1 – M24 x 1,5 *960*	**338** M8 x 1 – M16 x 1,5 *980*	**4145*** M8x1 – M16 x 1,5 *981*	**1273** M12 x 1 – M24 x 2 *979*	**1723** M12 x 1 – M24 x 1,5 *979*	**1731** M12 x 1 – M24 x 1,5 *979*	**1581** M12 x 1 – M24 x 1,5 *977*	
			1712 M12 x 1 – M24 x 1,5 *960*			**1716** M12 x 1 – M24 x 1,5 *979*		**1732** M12 x 1 – M24 x 1,5 *979*		
4152 G1/16“ – G1“ *982*										

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

≤ 1 x D — Through holes and blind holes

> 1 x D — Blind holes

Material examples

Suitable malleable materials see table "Cutting recommendations".

Shank designs

~DIN 371

d_1 2 ... 2,6 mm

d_1 3 ... 10 mm

~DIN 376 / ~DIN 374 / DIN 2189

Generally the application of bright fluteless taps is not recommended. Guhring offers bright fluteless taps in its standard range only as basic tools for a cost efficient coating to customer specific requirements.

		Tool material	HSS-E			Solid carbide
		Type/form	N/C	N/C	N/C	N/C
		Surface finish	S	S	Cb	S
		Cooling	☒	☒	☒	a
Rec. parameters see table "Cutting recommendations"						Shank tolerance h6
Thread type	Tolerance zone	Dim. to	**Guhring no.** Ø-range *Prices on page*			
M	6HX	DIN 2174 ~ DIN 371	**921** M2 – M10 *944*	**1255** M2 – M10 *944*	**1347** M2 – M10 *945*	**2518** M5 – M16 *953*
	6GX		**920** M2 – M10 *944*	**903** M2 – M10 *945*	**1565** M2 – M10 *945*	
	6HX	DIN 2174 ~ DIN 376	**925** M12 – M20 *945*	**1256** M12 – M20 *945*	**1566** M12 – M20	
	6GX		**924** M12 – M20 *945*	**952** M12 – M20 *945*	**1567** M12 – M20 *945*	
MF	6HX	DIN 2174 ~ DIN 371	**1279** M8 x 1 – M10 x 1	**1257** M8 x 1 – M10 x 1,25 *946*	**1568** M8 x 1 – M10 x 1 *947*	
	6GX		**1280** M8 x 1 – M10 x 1 *946*	**1740** M8 x 1 – M10 x 1,25 *947*	**1569** M8 x 1 – M10 x 1 *947*	
	6HX	DIN 2174 ~ DIN 374	**929** M8 x 1 – M24 x 1,5 *948*	**1258** M12 x 1 – M24 x 2 *947*		
	6GX		**928** M8 x 1 – M24 x 1,5 *948*		**1580** M12 x 1 – M24 x 1,5 *947*	
UNC	2BX	DIN 2184-1 ~ DIN 371	**2273** Nr.10-24 – 3/8" - 16 *949*			
	2BX	DIN 2184-1 ~ DIN 376	**2274** 7/16"-14 – 7/8" - 9 *949*			
UNF	2BX	DIN 2184-1 ~ DIN 371	**1283** Nr.10-32 – 3/8" - 24 *950*			
	2BX	DIN 2184-1 ~ DIN 374	**2275** Nr.10-32 – 1"-12 *951*			
BSP	–	DIN 2184-1 DIN 2189	**966** G1 1/16" – G1 1/4" *952*			

a With internal cooling, tools with axial coolant duct are, as a rule, only suitable for the machining of blind holes. Without internal cooling, i.e. external cooling, the tools are also suitable for through holes.

bright · steam tempered · nitrided lands · nitrided · golden brown · A TiAlN · a TiAlN nanoA · A AlTiN SuperA

Thanks to the development of modern tool materials, geometries, coatings and recently the Guhring developed improved tool surface the scope of malleable materials able to be fluteless tapped is expanding. The table “Cutting rate recommendations” below provides an overview of materials that can be machined with Guhring’s “Profile” fluteless taps. In many cases, a test in harder or more brittle materials is worth while in order to benefit from the advantages of fluteless tapping in these materials. Please contact our technicians for advice.

Cutting rate recommendations

Material group		Tens. strength MPa (N/mm²)	Hardness HB	Cutting speed v_c m/min*		
				HSS-E	HSS-E-PM	Solid carbide
	Structural steels	≤ 850	–	10 - 15	15 - 20	20 - 30
	Free-cutting steels	≤ 1000	–	10 - 20	15 - 25	20 - 30
	Unalloyed case hardened steels	≤ 750	–	10 - 15	15 - 20	20 - 30
	Unalloyed heat-treatable steels	≤ 850	–	10 - 15	15 - 20	20 - 30
	Alloyed case hardened steels	≥ 850 … 1200	–	8 - 12	10 - 15	15 - 20
	Alloyed heat-treatable steels	≥ 850 … 1200	–	8 - 12	10 - 15	15 - 20
	Alloyed tool steels	≤ 1000	–	6 - 10	8 - 12	10 - 15
	High speed tool steels	≥ 650 … 1000	–	6 - 10	8 - 12	10 - 15
	Stainless- and acid-resistant steels, sulphured	≤ 850	–	6 - 12	8 - 15	12 - 20
	austenitic	≤ 850	–	4 - 8	8 - 15	12 - 20
	martensitic	≤ 850	–	4 - 8	8 - 15	12 - 20
	Structural steels	≤ 800	–	10 - 15	15 - 20	20 - 30
	Free-cutting steels	≤ 1000	–	10 - 20	15 - 25	20 - 30
	Case hardened steels	≤ 1000	–	10 - 15	15 - 20	20 - 30
	Heat-treatable steels	≤ 1200	–	10 - 15	15 - 20	20 - 30
	Nitriding steels	≤ 1200	–	10 - 15	15 - 20	20 - 30
	Spheroidal graphite iron	–	≤ 240	10 - 20	15 - 25	20 - 30
	Aluminium and Al-alloys	≤ 400	–	15 - 20	20 - 25	30 - 50
	Al wrought alloys	≤ 400	–	15 - 20	20 - 25	30 - 50
	Al cast alloys ≤ 10 % Si	≤ 600	–	15 - 20	20 - 25	30 - 50
	> 10 % Si	≤ 600	–	–	–	–
	Cast iron	–	≤ 240	–	–	–
	Spheroidal graphite iron	–	≤ 240	15 - 20	20 - 25	30 - 40
	Malleable cast iron	–	< 300	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	–	–	–	–	–
	Magnesium-alloys	≤ 450	–	–	–	–
	Titanium and Ti-alloys	≤ 1200	–	2 - 6	2 - 8	8 - 12
	Ni-alloys	≤ 1200	–	2 - 6	2 - 8	8 - 12

C TiCN Cb Carbo D Cristall F FIRE/nanoFIRE P AlCrN S TiN S+ TiN+ M MolyGlide Y Signum

Material examples

Material no.	Abbreviation
Al and Al-alloys	
3.0250	Al 99,5H
3.0280	AL 99,8H
3.3308	Al99,9Mg0,5
Al wrought alloys	
3.2315	AlMgSi1
3.1655	AlCuMgPb
3.4335	AlZn4,5Mg1
Al cast alloys ≤ 10% Si	
3.2134	GD-AlSi5Cu1Mg
3.2162	GD-AlSi8Cu3
3.2373	G-AlSi9Mg

Material examples

Material no.	Abbreviation
Cast iron	
0.6015 (GG15)	EN-GJL-150
0.6025 (GG25)	EN-GJL-250
0.6040 (GG40)	EN-JLZ
Spheroidal graphite cast iron	
0.7040 (GGG40)	EN-GJS-400-15
0.7060 (GGG60)	EN-GJS-600-3

Material examples

Material no.	Abbreviation
Brass, short-chipping	
2.0380	CuZn39Pb2
2.0401	CuZn39Pb3
2.0410	CuZn43Pb2
Brass, long-chipping	
2.0250	CuZn20
2.0280	CuZn33
2.0332	CuZn37Pb0,5

Material examples

Material no.	Abbreviation
Duroplastics	
–	Bakelit
	Resopal
	Pertinax
	Moltopren
Thermoplastics	
–	Plexiglas
	Hostalen
	Novodur
	Makralon

Material examples

Material no.	Abbreviation
Magnesium-alloys	
3.5200	MgMn2
3.5612	MgAl6Zn
3.5812	MgAl8Zn
3.5812.05	GDMgAl8Zn1
3.5612.05	GDMgAl6Zn1
3.5662.01	GMgAl6

Material examples

Material no.	Abbreviation
Titanium	
3.7025	Ti
3.7065	Ti

Through holes and blind holes

Tool material	Solid carbide				
Type	TM SP	TMU SP	TMC SP	DTMC SP	DTMC SP
Surface finish	○	○	○	○ / C	○ / C
Cooling	a	a	a	a	⊠

Rec. parameters

see table "Cutting recommendations"

Thread type	Thread depth	TM SP	TMU SP	TMC SP	DTMC SP	DTMC SP
		Guhring no. Ø-range *Preisseite*				
M	1,5 x D	NEW		**3510** M3 - M20 *1006*	**3775** **3777** M4 - M16 *985* *985*	**3774** **3776** M3 - M16 *984* *985*
	2,0 x D	**3734** **4132** M6 - M20 *996* *997*		**3511** M3 - M20 *1008*	**3779** **3781** M4 - M16 *987* *987*	**3778** **3780** M3 - M16 *986* *987*
	2,5 x D	**3735** M6 - M20 *998*		**3759** M3 - M20 *1010*	**3783** **3785** M4 - M16 *989* *989*	**3782** **3784** M3 - M16 *988* *989*
	16/20/25/ 33 mm		**3523** Ø10xM1 - Ø20xM3,5 *1030*			
	Außengewinde-fräsen		**4162** NEW Ø10xM0,5 - Ø20xM3 *1035*			
MF	1,5 x D			**3512** M4x0,5 - M16x1,5 *1012*	**3787** **3789** M6x0,75 - M16x1,5 *991* *991*	**3788** M4x0,5 - M16x1,5 *990* *990*
	2,0 x D			**3513** M4x0,5 - M16x1,5 *1013*	**3791** **3793** M6x0,75..M16x1,5 *993* *993*	**3790** **3792** M4x0,5 - M16x1,5 *992* *993*
	2,5 x D			**3762** M4x0,5 - M16x1,5 *1014*		
	16/20/25/ 33 mm		**3523** Ø10xM1 - Ø20xM3,5 *1030*			
UNC	1,5 x D	NEW	**3595** Ø10xUN24-Ø20xUN7 *1031*	**3516** 1/4-20 - 1/2-13 *1015*	NEW	NEW
	2,0 x D	**4134** Nr.10-24 - 5/8-11 *1003*		**3517** 1/4-20 - 1/2-13 *1016*	**4139** 1/4-20 - 5/8-11 *994*	**4138** 1/4-20 - 5/8-11 *994*
UNF	1,5 x D	NEW	**3595** Ø10xUN24-Ø20xUN7 *1031*	**3518** 1/4-28 - 1/2-20 *1017*	NEW	NEW
	2,0 x D	**4136** Nr.10-32 - 5/8-18 *1004*		**3519** 1/4-28 - 1/2-20 *1018*	**4141** 1/4-28 - 5/8-18 *995*	**4140** 1/4-28 - 5/8-18 *995*
G BSP	1,5 x D			**3514** G1/8 - G3/8 *1020*		
	2,0 x D	**3745** G1/8 - G3/8 *999*		**3515** G1/8 - G3/8 *1022*		
	2,5 x D	**3746** G1/8 - G3/8 *1000*		**3765** G1/8 - G3/8 *1024*		
	16/20/25/ 33 mm		**3524** Ø10xG19 - Ø20xG11 *1032*			
NPT	std. length	**3753** 1/16 - 3/8 *1001*	**3768** Ø14,5x14-Ø18,5x11,5 *1033*	**3520** 1/8 - 3/8 *1026*		
NPTF	std. length	**3756** 1/16 - 3/8 *1002*		**3521** 1/8 - 3/8 *1028*		

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○ bright ● steam tempered ◐ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A AlTiN SuperA

Through holes and blind holes

Material examples

Material no. Abbreviation

Structural steels

1.0035	S 185 (St 33)
1.0039	S 235 JRH
1.0036	S 235JRG1+CR
1.0060	E 335 (St 60-2)

Free cutting steels

1.0718	11SMnPb30
1.0721	10S20
1.0758	60SPb20
1.0726	35S20

Case hardened steels

1.0401	(C 15)
1.7016	17 CR3
1.7131	16MnCr5
1.5919	15CrNi6

Unalloyed heat-treatable steels

1.0402	C 22
1.1151	C22E (Ck 22)
1.0503	C 45
1.1191	C45E (Ck 45)

Material examples

Material no. Abbreviation

Alloyed heat-treatable steels

1.6511	36 CrNiMo 4
1.7033	34 Cr 4
1.7225	42 CrMo 4

Tool steels

1.2316	X 36 CrMo 17
1.2067	10 S20

High speed steels

1.3343	HS 6-5-2
1.3344	HS 6-5-3
1.3243	HS 6-5-2-5
1.3247	HS 2-19-1-8

Hardened steels

All steel examples are hardened to 45 … 62 HRC

Material examples

Material no. Abbreviation

Sulphured steels

1.4005	X 12 CrS 13
1.4104	X 14 CrMo S 17
1.4105	X 6 CrMo S 17
1.4305	X 8CrNi S 18-9

Austenitic steels

1.4300	X 12 CrNi 18-8
1.4301	X 5 CrNi 18-10
1.4541	X 6 CrNiTi 18-10

Martensitic steels

1.4057	X 17 CrNi 16-2
1.4112	X 90 CrMoV 18
1.4006	X 12 Cr 13

Material examples

Material no. Abbreviation

Special alloys

2.4610	Hastelloy C4
2.4876	Incoloy 800
2.4816	Inconel 600
2.4668	Inconel 718
2.4634	Nimonic 105
	CuNi12Zn24
	CuNi18Zn20

	Tool material	Solid carbide		
	Type	TM SP	TMU SP	TMC SP
	Surface finish	C	C	C
	Cooling	a	a	a
Rec. parameters see table "Cutting recommendations"				
Thread type	**Thread depth**	**Guhring no.** Ø-range *Prices on page*		
M	1,5 x D	NEW		**3525** M3 - M20 *1007*
	2,0 x D	**3737** **4133** M6 - M20 *996* *997*		**3526** M3 - M20 *1009*
	2,5 x D	**3740** M6 - M20 *998*		**3760** M3 - M20 *1011*
	16/20/25/ 33 mm		**3541** Ø10xM1 - Ø20xM3,5 *1030*	
	external thread milling		**4163** Ø10xM0,5 - Ø20xM3 NEW *1035*	
MF	1,5 x D			**3527** M4x0.5 - M16x1.5 *1012*
	2,0 x D			**3528** M4x0.5 - M16x1.5 *1013*
	2,5 x D			**3763** M4x0.5 - M16x1.5 *1014*
	16/20/25/ 33 mm		**3541** Ø10xM1 - Ø20xM3,5 *1030*	
UNC	1,5 x D		**3596** Ø10xUN24-Ø20xUN7 *1031*	**3534** 1/4-20 - 1/2-13 *1015*
	2,0 x D	**4135** Nr.10-24 - 5/8-11 NEW *1003*		**3535** 1/4-20 - 1/2-13 *1016*
UNF	1,5 x D		**3596** Ø10xUN24-Ø20xUN7 *1031*	**3536** 1/4-28 - 1/2-20 *1017*
	2,0 x D	**4137** Nr.10-32 - 5/8-18 NEW *1004*		**3537** 1/4-28 - 1/2-20 *1018*
G BSP	1,5 x D			**3529** G1/8 - G3/8 *1021*
	2,0 x D	**3748** G1/8 - G3/8 *999*		**3533** G1/8 - G3/8 *1024*
	2,5 x D	**3750** G1/8 - G3/8 *1001*		
	16/20/25/ 33 mm		**3542** Ø10xG19 - Ø20xG11 *1032*	
NPT	std. length	**3754** 1/16 - 3/8 *1001*	**3769** Ø14,5x14-Ø18,5x11,5 *1033*	**3538** 1/8 - 3/8 *1027*
NPTF	std. length	**3757** 1/16 - 3/8 *1002*	**3772** Ø14,5x14-Ø18,5x11,5 *1034*	**3539** 1/8 - 3/8 *1029*

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Through holes and blind holes

Material examples

Material no.	Abbreviation
Al cast alloys > 10% Si	
3.2581	G-AlSi12
3.2583	G-AlSi12Cu
3.2581	G-AlSi10Mg

Material examples

Material no.	Abbreviation
Malleable cast iron	
0.8035	EN-GJMW-350-4
0.8040	EN-GJMW-400-5
0.8135	EN-GJMB-350-10
Spheroidal graphite iron	
0.7040 (GGG40)	EN-GJS-400-15
0.7060 (GGG40)	EN-GJS-600-3
Cast iron with vermicular graphite	
–	GGV

Material examples

Material no.	Abbreviation
Glass-/carbon-reinforced plastics	
–	Polypropylen GFK CFK

Material examples

Material no.	Abbreviation
Titanium-alloys	
3.7115	TiAl 5Sn2
3.7165	TiAl 6 V4

	Tool material	**Solid carbide**		
	Type	TM SP	TMU SP	TMC SP
	Surface finish	A	A	A
	Cooling	a	a	a
Rec. parameters see table "Cutting recommendations"				
Thread type	**Thread depth**	**Guhring no.** Ø-range *Prices on page*		
M	1,5 x D			**3543** M3 - M20 *1007*
	2,0 x D	**3743** M6 - M20 *996*		**3544** M3 - M20 *1009*
	2,5 x D	**3744** M6 - M20 *998*		**3761** M3 - M20 *1011*
	16/20/25/ 33 mm		**3556** Ø10xM1 - Ø20xM3,5 *1030*	
MF	1,5 x D			**3545** M4x0.5 - M16x1.5 *1012*
	2,0 x D			**3546** M4x0.5 - M16x1.5 *1013*
	2,5 x D			**3764** M4x0.5 - M16x1.5 *1014*
	16/20/25/ 33 mm		**3556** Ø10xM1 - Ø20xM3,5 *1030*	
UNC	1,5 x D		**3597** Ø10xUN24-Ø20xUN7 *1031*	
	2,0 x D			**3550** 1/4-20 - 1/2-13 *1016*
UNF	1,5 x D		**3597** Ø10xUN24-Ø20xUN7 *1031*	**3551** 1/4-28 - 1/2-20 *1017*
	2,0 x D			**3552** 1/4-28 - 1/2-20 *1018*
G BSP	1,5 x D			**3547** G1/8 - G3/8 *1021*
	2,0 x D	**3751** G1/8 - G3/8 *999*		**3548** G1/8 - G3/8 *1023*
	2,5 x D	**3752** G1/8 - G3/8 *1000*		
	16/20/25/ 33 mm		**3557** Ø10xG19 - Ø20xG11 *1032*	
NPT	std. length	**3755** 1/16 - 3/8 *1001*	**3770** Ø14,5x14-Ø18,5x11,5 *1033*	**3553** 1/8 - 3/8 *1027*
NPTF	std. length	**3758** 1/16 - 3/8 *1002*	**3773** Ø14,5x14-Ø18,5x11,5 *1034*	**3554** 1/8 - 3/8 *1029*

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bright · steam tempered · nitrided lands · nitrided · golden brown · A TiAlN · a TiAlN nanoA · A AlTiN SuperA

Material group		Tensile strength MPa (N/mm²)	Hardness HB	Cutting speed v_c (m/min)	Feed per tooth f_z (mm)	Feed for drill per revolution f_b (mm)
	Structural steels	≤ 850	–	80 - 120	0,02 - 0,10	–
	Free-cutting steels	≤ 1000	–	80 - 120	0,02 - 0,10	–
	Unalloyed case hardened steels	≤ 750	–	80 - 120	0,02 - 0,10	–
	Unalloyed heat-treatable steels	≤ 850	–	80 - 120	0,02 - 0,10	–
	Alloyed case hardened steels	≥ 850 … 1200	–	60 - 80	0,01 - 0,08	–
	Alloyed heat-treatable steels	≥ 850 … 1200	–	60 - 80	0,01 - 0,08	–
	Alloyed tool steels	≤ 1000	–	60 - 80	0,01 - 0,08	–
	High speed tool steels	≥ 650 … 1000	–	60 - 80	0,01 - 0,08	–
	Stainless- and acid-resistant steels. sulphured	≤ 850	–	50 - 80	0,02 - 0,10	–
	austenitic	≤ 850	–	50 - 70	0,02 - 0,10	–
	martensitic	≤ 850	–	50 - 70	0,02 - 0,10	–
	Structural steels	≤ 800	–	80 - 100	0,02 - 0,10	–
	Free-cutting steels	≤ 1000	–	80 - 100	0,02 - 0,10	–
	Case hardened steels	≤ 1000	–	80 - 100	0,02 - 0,10	–
	Heat-treatable steels	≤ 1200	–	80 - 100	0,02 - 0,10	–
	Nitriding steels	≤ 1200	–	80 - 100	0,02 - 0,10	–
	Spheroidal graphite iron	–	≤ 240	80 - 120	0,02 - 0,10	0,05 - 0,20
	Aluminium and Al-alloys	≤ 400	–	150 - 300	0,05 - 0,20	0,05 - 0,25
	Al wrought alloys	≤ 400	–	150 - 300	0,05 - 0,20	0,05 - 0,25
	Al cast alloys ≤ 10 % Si	≤ 600	–	150 - 300	0,05 - 0,20	0,05 - 0,40
	> 10 % Si	≤ 600	–	100 - 200	0,05 - 0,20	0,05 - 0,30
	Cast iron	–	≤ 240	100 - 150	0,05 - 0,15	0,05 - 0,25
	Spheroidal graphite iron	–	≤ 240	80 - 120	0,05 - 0,15	0,05 - 0,20
	Malleable cast iron	–	< 300	80 - 120	0,05 - 0,15	0,05 - 0,20
	Brass. short-chipping	≤ 600	–	150 - 250	0,05 - 0,25	0,05 - 0,40
	long-chipping	≤ 600	–	150 - 250	–	0,05 - 0,25
	Plastics	–	–	100 - 200	0,05 - 0,25	0,05 - 0,40
	Magnesium-alloys	≤ 450	–	150 - 300	0,05 - 0,25	0,05 - 0,40
	Titanium and Ti-alloys	≤ 1200	–	40 - 60	0,01 - 0,08	–
	Ni-alloys	≤ 1200	–	40 - 60	0,01 - 0,08	–

The surface of a thread milling cutter does not influence the cutting data, but the suitability for materials:

- ○ easy-to-machine materials
- C steels and Ni-alloys
- A abrasive materials

Formula of calculation

$$v_c = \frac{d \cdot \pi \cdot n}{1000}$$

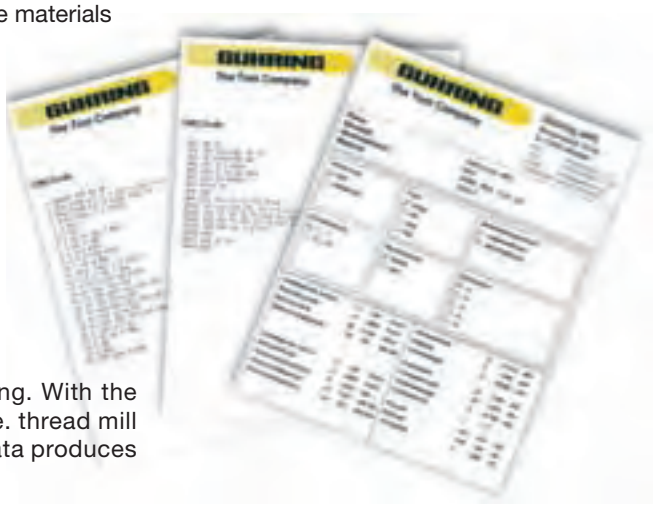
$$n = \frac{v_c \cdot 1000}{d \cdot \pi}$$

$$v_f = n \cdot z \cdot f_z$$

$$v_m = \frac{v_f \cdot (D - d)}{D}$$

$$v_b = n \cdot f_b$$

v_c = cutting speed
v_f = contour feed
v_m = centre point path feed
n = revolutions
z = number of teeth
f_z = feed per tooth
f_b = feed for drill per revolution*
v_b = drill feed rate*
D = Ø nom. of thread [mm]
d = milling cutter nom. Ø [mm]
* for drill/thread milling



Guhring Thread Mill: CNC programming made easy

Guhring's Thread Mill software considerably simplifies CNC programming. With the assistance of a clear input mask, the user enters all the required data, i.e. thread mill type, thread type and diameter, machine parameters etc. and with this data produces the relevant CNC program.

C TiCN | Cb Carbo | D Cristall | F FIRE/nanoFIRE | P AlCrN | S TiN | S+ TiN+ | M MolyGlide | Y Signum

General steels

Material no. to DIN EN 10 027 — Abbreviation

Structural steels

1.0035	S 185 (St 33)
1.0039	S 235 JRH
1.0036	S 235JRG1+CR
1.0060	E 335 (St 60-2)

Free-cutting steels

1.0718	11SMnPb30
1.0721	10S20
1.0758	60SPb20
1.0726	35S20

Case hardened steels

1.0401	(C 15)
1.7016	17 CR3
1.7131	16MnCr5
1.5919	15CrNi6

Unalloyed heat-treabable steels

1.0402	C 22
1.1151	C22E (Ck 22)
1.0503	C 45
1.1191	C45E (Ck 45)

High tensile steels

Material no. to DIN EN 10 027 — Abbreviation

Alloyed heat-treabable steels

1.6511	36 CrNiMo 4
1.7033	34 Cr 4
1.7225	42 CrMo 4

Tool steels

1.2316	X 36 CrMo 17
1.2067	10 S20

High speed tool steels

1.3343	HS 6-5-2
1.3344	HS 6-5-3
1.3243	HS 6-5-2-5
1.3247	HS 2-19-1-8

Stainl./acid resist. steels

Material no. to DIN EN 10 027 — Abbreviation

Sulphured stainless steels

1.4005	X 12 CrS 13
1.4104	X 14 CrMo S 17
1.4105	X 6 CrMo S 17
1.4305	X 8CrNi S 18-9

Austenitic stainless steels

1.4300	X 12 CrNi 18-8
1.4301	X 5 CrNi 18-10
1.4541	X 6 CrNiTi 18-10

Martensitic stainless steels

1.4057	X 17 CrNi 16-2
1.4112	X 90 CrMoV 18
1.4006	X 12 Cr 13

		Tool material	HSS					HSS-E
		Surface finish	○	○	○	○	○	●
			–	–	lapped	lapped	–	lapped
		Chamfer	without	with*	with*	with*	with*	with*
* Dies for metric and metric fine threads > M2.6 with chamfer						for brass	left-hand thread	
Thread type	Tolerance zone	Dim. to DIN 2184-2	Guhring no. Ø-range *Prices on page*					
M	**6g**	**DIN EN 22568**	**151** M1 – M39 *1041*	**152** M3 – M52 *1042*	**153** M3 – M27 *1041*	**155** M3 – M24 *1041*	**156** M3 – M33 *1041*	**130** M2 – M20 *1039*
	6g	**DIN 382**	**139** M3,5 – M52 Hexagonal *1038*	**140** M3 – M16 Hexagonal *1040*				
	6g	**Guhring std.**		**121**** M2,2 – M12 *1037*	**125**** M1,1 – M10 *1036*			
MF	**6g**	**DIN EN 22568**	**161** M2,3x0,25 – M56x1,50 *1043*	**162** M3x0,35 – M33x3 *1043*	**163** M4,5x0,5 – M48x3 *1043*			
UNC	**–**	**DIN EN 22568**	**181** Nr. 2-56 – 7/16-14 *1045*	**182** Nr. 8-32 – 2-4,5 *1045*				
UNF	**–**	**DIN EN 22568**		**185** Nr. 6-40 – 1 3/8"-12 *1046*				
BSW	**–**	**DIN EN 22568**		**172** W 3/16" – W 3/4" *1047*				
G BSP thread	**–**	**DIN EN 24231**	**175** G 1/8" – G 1 3/4" *1048*	**176** G 1/8" – G 2 1/4" *1048*				
R-BSPT thread	**–**	**DIN EN 24230**		**198** R 1/8" – R 1 1/4" *1049*				
NPT-thread	**–**	**DIN EN 22568**	**190** 1/8" – 1 *1050*	**191** 1/8" – 3/4" *1050*				

** Guhring no. 121 with additional clearance hole
Guhring no. 125 with screw holes
Guhring no. 126 with bell form

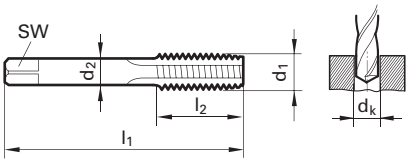
○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A AlTiN SuperA

Material group		Tens. strength MPa (N/mm2)	Hardness HB	Cutting speed vc m/min	
				HSS	HSS-E
	Structural steels	≤ 800	–	8 - 12	–
	Free-cutting steels	≤ 1000	–	10 - 14	–
	Unalloyed case hardened steels	≤ 750	–	6 - 10	–
	Unalloyed heat-treatable steels	≤ 850	–	6 - 10	–
	Alloyed case hardened steels	≥ 850 … 1200	–	–	5 - 8
	Alloyed heat-treatable steels	≥ 850 … 1200	–	–	5 - 8
	Alloyed tool steels	≤ 1000	–	–	5 - 8
	High speed tool steels	≥ 650 … 1000	–	–	5 - 8
	Stainless- and acid-resistant steels, sulphured	≤ 850	–	–	4 - 6
	austenitic	≤ 850	–	–	4 - 6
	martensitic	≤ 850	–	–	4 - 6
	Structural steels	≤ 800	–	8 - 12	–
	Free-cutting steels	≤ 1000	–	10 - 14	–
	Case hardened steels	≤ 1000	–	6 - 10	–
	Heat-treatable steels	≤ 1200	–	6 - 10	–
	Nitriding steels	≤ 1200	–	–	5 - 8
	Spheroidal graphite iron	–	≤ 240	5 - 8	–
	Aluminium and Al-alloys	≤ 400	–	10 - 20	–
	Al wrought alloys	≤ 400	–	10 - 20	–
	Al cast alloys ≤ 10 % Si	≤ 600	–	10 - 15	–
	> 10 % Si	≤ 600	–	10 - 12	–
	Cast iron	–	≤ 240	5 - 8	–
	Spheroidal graphite iron	–	≤ 240	5 - 8	–
	Malleable cast iron	–	< 300	5 - 8	–
	Brass, short-chipping	≤ 600	–	5 - 8	–
	long-chipping	≤ 600	–	20 - 30	–
	Plastics	–	–	12 - 18	–
	Magnesium-alloys	≤ 450	–	10 - 20	–
	Titanium and Ti-alloys	≤ 1200	–	–	2 - 6
	Ni-alloys	≤ 1200	–	–	2 - 6

Material group	Material example	Helix angle	Lubricant
Structural steels	St 37-2, St 50-2 etc.	17 - 22°	Cutting oil
Free-cutting steels	9 S Mn 28, 9 S MnPb 28 etc.	17 - 22°	Cutting oil
Case hardened steels	C 15, Ck 15, 16 MnCr 5 etc.	17 - 22°	Cutting oil, special cutting oil
Heat-treatable steels	C 35 Pb, C 45 etc.	13 - 18°	Cutting oil, special cutting oil
Stainless- and acidresistant steels	x12 CrMoS 17, x12 CrNiS 188 etc.	13 - 18°	Special cutting oil
Grey cast iron	GG 15, GG25	8 - 12°	Cutting oil, petroleum
Brass, short-chipping, Ms58	CuZn 39 Pb 2, CuZn 40 Pb 2	10 - 12°	Cutting oil
Brass, long-chipping, Ms60	CuZn 20, CuZn 37	3 - 7°	Cutting oil
Al-alloys, long-chipping	AlCuMg 1, AlMg 3 Si	23 - 28°	Special cutting oil, petroleum
Al-alloys, short-chipping	GD-AlSI 8 Cu 3, GD AlSi 12	13 - 18°	Special cutting oil, petroleum

C TiCN Cb Carbo D Cristall F FIRE/nanoFIRE P AlCrN S TiN S+ TiN+ M MolyGlide Y Signum

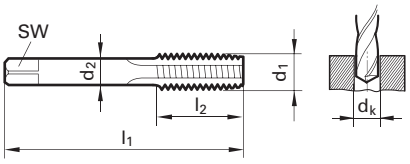
Guhring no.	861	862	863	864
Standard	DIN 2184-2			
Standard	DIN 352			
Tool material	HSS			
Surface	○	○	○	○
Type	N	N	N	N
Description	Set of taps	F	S	B
Tolerance	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H
Cutting direction	right-hand	right-hand	right-hand	right-hand
Discount group	118	118	118	118
Techn. data page	810	810	810	810



d1	P	d2	SW	dk	l1	l2	Availability			
	mm	mm		mm	mm	mm				
M 1	0.25	2.500	2.10	0.750	32.00	5.50	●	●	●	●
M 1,1	0.25	2.500	2.10	0.850	32.00	5.50	●	○	○	○
M 1,2	0.25	2.500	2.10	0.950	32.00	5.50		●	○	●
M 1,4	0.30	2.500	2.10	1.100	32.00	7.00	●	●	●	●
M 1,6	0.35	2.500	2.10	1.250	32.00	8.00	●		●	●
M 1,7	0.35	2.500	2.10	1.350	32.00	8.00		●	●	●
M 1,8	0.35	2.500	2.10	1.450	32.00	8.00	●	○	○	●
M 2	0.40	2.800	2.10	1.600	36.00	8.00	●	●	●	●
M 2,3	0.40	2.800	2.10	1.900	36.00	9.00	●	○	○	●
M 2,5	0.45	2.800	2.10	2.050	40.00	9.00	●	●	●	●
M 2,6	0.45	2.800	2.10	2.150	40.00	9.00		○	○	
M 3	0.50	3.500	2.70	2.500	40.00	10.00	●	●	●	●
M 3,5	0.60	4.000	3.00	2.900	45.00	12.00	●		○	●
M 4	0.70	4.500	3.40	3.300	45.00	12.00	●	●	●	●
M 4,5	0.75	6.000	4.90	3.700	50.00	14.00	●	○		●
M 5	0.80	6.000	4.90	4.200	50.00	14.00	●	●	●	●
M 6	1.00	6.000	4.90	5.000	56.00	16.00	●	●	●	●
M 7	1.00	6.000	4.90	6.000	56.00	16.00	●	○	○	●
M 8	1.25	6.000	4.90	6.800	63.00	17.00	●	●	●	●
M 9	1.25	7.000	5.50	7.800	63.00	17.00	●	○	○	
M10	1.50	7.000	5.50	8.500	70.00	20.00	●	●	●	●
M11	1.50	8.000	6.20	9.500	70.00	20.00	○	●		●
M12	1.75	9.000	7.00	10.200	75.00	24.00	●	●	●	●
M14	2.00	11.000	9.00	12.000	80.00	26.00	●	●	●	●
M16	2.00	12.000	9.00	14.000	80.00	26.00	●	●	●	●
M18	2.50	14.000	11.00	15.500	95.00	30.00	●	●	●	●
M20	2.50	16.000	12.00	17.500	95.00	32.00	●	●	●	●
M22	2.50	18.000	14.50	19.500	100.00	32.00	●	●	●	○
M24	3.00	18.000	14.50	21.000	110.00	36.00	●	●	●	●
M27	3.00	20.000	16.00	24.000	110.00	36.00	●	●	●	●
M30	3.50	22.000	18.00	26.500	125.00	40.00	●	●	●	●
M36	4.00	28.000	22.00	32.000	150.00	50.00	●	●	●	●
M42	4.50	32.000	24.00	37.500	150.00	56.00		○	○	
M45	4.50	36.000	29.00	40.500	160.00	58.00	●	○	○	
M56	5.50	45.000	35.00	50.500	180.00	70.00		○		
M60	5.50	45.000	35.00	54.500	200.00	70.00		○	○	

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

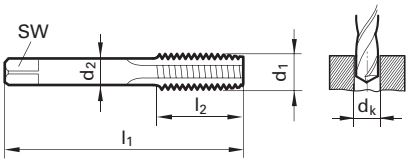
Guhring no.	861	862	863	864
Standard	DIN 2184-2			
Standard	DIN 352			
Tool material	HSS			
Surface	◯	◯	◯	◯
Type	N	N	N	N
Description	Set of taps	F	S	B
Tolerance	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H
Cutting direction	right-hand	right-hand	right-hand	right-hand
Discount group	118	118	118	118
Techn. data page	810	810	810	810



d1	P	d2	SW	dk	l1	l2	Availability	
	mm	mm		mm	mm	mm		
M64	6.00	50.000	39.00	58.000	220.00	75.00	❍	
M68	6.00	50.000	39.00	62.000	220.00	75.00	❍	❍

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

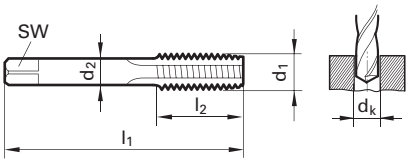
Guhring no.	882	883	864
Standard	DIN 2184-2		
Standard	DIN 352		
Tool material	HSS		
Surface	○	○	○
Type	N	N	N
Description	Set of taps	F	B
Tolerance	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H
Cutting direction	right-hand	right-hand	right-hand
Discount group	118	118	118
Techn. data page	810	810	810



d1	P	d2	SW	dk	l1	l2	Availability		
	mm	mm		mm	mm	mm			
M 1	0.25	2.500	2.10	0.750	32.00	5.50			●
M 1,1	0.25	2.500	2.10	0.850	32.00	5.50			○
M 1,2	0.25	2.500	2.10	0.950	32.00	5.50			●
M 1,4	0.30	2.500	2.10	1.100	32.00	7.00			●
M 1,6	0.35	2.500	2.10	1.250	32.00	8.00			●
M 1,7	0.35	2.500	2.10	1.350	32.00	8.00			●
M 1,8	0.35	2.500	2.10	1.450	32.00	8.00			●
M 2	0.40	2.800	2.10	1.600	36.00	8.00	●	○	●
M 2,2	0.45	2.800	2.10	1.750	36.00	9.00		○	
M 2,3	0.40	2.800	2.10	1.900	36.00	9.00	○	○	●
M 2,5	0.45	2.800	2.10	2.050	40.00	9.00	○	○	●
M 2,6	0.45	2.800	2.10	2.150	40.00	9.00	○	○	
M 3	0.50	3.500	2.70	2.500	40.00	10.00	●	●	●
M 3,5	0.60	4.000	3.00	2.900	45.00	12.00		●	●
M 4	0.70	4.500	3.40	3.300	45.00	12.00	●	●	●
M 4,5	0.75	6.000	4.90	3.700	50.00	14.00			●
M 5	0.80	6.000	4.90	4.200	50.00	14.00	●		●
M 6	1.00	6.000	4.90	5.000	56.00	16.00	●	●	●
M 7	1.00	6.000	4.90	6.000	56.00	16.00	●	●	●
M 8	1.25	6.000	4.90	6.800	63.00	17.00	●		●
M 9	1.25	7.000	5.50	7.800	63.00	17.00	●	○	
M10	1.50	7.000	5.50	8.500	70.00	20.00			●
M11	1.50	8.000	6.20	9.500	70.00	20.00			●
M12	1.75	9.000	7.00	10.200	75.00	24.00		○	●
M14	2.00	11.000	9.00	12.000	80.00	26.00			●
M16	2.00	12.000	9.00	14.000	80.00	26.00			●
M18	2.50	14.000	11.00	15.500	95.00	30.00			●
M20	2.50	16.000	12.00	17.500	95.00	32.00			●
M22	2.50	18.000	14.50	19.500	100.00	32.00			○
M24	3.00	18.000	14.50	21.000	110.00	36.00			●
M27	3.00	20.000	16.00	24.000	110.00	36.00			●
M30	3.50	22.000	18.00	26.500	125.00	40.00			●
M36	4.00	28.000	22.00	32.000	150.00	50.00			●

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

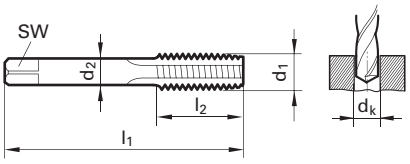
Guhring no.	904	905	906	907
Standard	DIN 2184-2			
Standard	DIN 352			
Tool material	HSS			
Surface	◯	◯	◯	◯
Type	N-LH	N-LH	N-LH	N-LH
Description	Set of taps	F	S	B
Tolerance	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H
Cutting direction	left-hand	left-hand	left-hand	left-hand
Discount group	118	118	118	118
Techn. data page	810	810	810	810



d1	P	d2	SW	dk	l1	l2	Availability			
	mm	mm		mm	mm	mm				
M 2	0.40	2.800	2.10	1.600	36.00	8.00				❍
M 2,2	0.45	2.800	2.10	1.750	36.00	9.00	❍			❍
M 3	0.50	3.500	2.70	2.500	40.00	10.00				❍
M 4	0.70	4.500	3.40	3.300	45.00	12.00	❍			
M 5	0.80	6.000	4.90	4.200	50.00	14.00	❍			
M 6	1.00	6.000	4.90	5.000	56.00	16.00	●			❍
M 8	1.25	6.000	4.90	6.800	63.00	17.00	❍			❍
M10	1.50	7.000	5.50	8.500	70.00	20.00	❍			❍
M12	1.75	9.000	7.00	10.200	75.00	24.00	●			❍
M14	2.00	11.000	9.00	12.000	80.00	26.00	❍	❍	❍	❍
M16	2.00	12.000	9.00	14.000	80.00	26.00	❍	❍	❍	❍
M18	2.50	14.000	11.00	15.500	95.00	30.00	❍			
M20	2.50	16.000	12.00	17.500	95.00	32.00	●			❍
M22	2.50	18.000	14.50	19.500	100.00	32.00	❍			

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

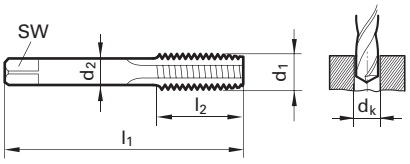
Guhring no.	853	854	855	856
Standard	DIN 2184-2			
Standard	DIN 352			
Tool material	HSS-E			
Surface	○	○	○	○
Type	VA	VA	VA	VA
Description	Set of taps	F	S	B
Tolerance	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H
Cutting direction	right-hand	right-hand	right-hand	right-hand
Discount group	118	118	118	118
Techn. data page	811	811	811	811



d1	P	d2	SW	dk	l1	l2	Availability			
	mm	mm		mm	mm	mm				
M 2	0.40	2.800	2.10	1.600	36.00	8.00	●	❍	❍	●
M 2,2	0.45	2.800	2.10	1.750	36.00	9.00			❍	
M 2,3	0.40	2.800	2.10	1.900	36.00	9.00				❍
M 2,5	0.45	2.800	2.10	2.050	40.00	9.00	●	❍	❍	
M 2,6	0.45	2.800	2.10	2.150	40.00	9.00	❍	❍	❍	❍
M 3	0.50	3.500	2.70	2.500	40.00	10.00	●	❍	●	●
M 4	0.70	4.500	3.40	3.300	45.00	12.00	●	❍	●	●
M 5	0.80	6.000	4.90	4.200	50.00	14.00	●	❍	●	●
M 6	1.00	6.000	4.90	5.000	56.00	16.00	●	❍	●	●
M 8	1.25	6.000	4.90	6.800	63.00	17.00	●	❍	●	●
M10	1.50	7.000	5.50	8.500	70.00	20.00	●	❍	❍	❍
M12	1.75	9.000	7.00	10.200	75.00	24.00	●	❍	❍	●
M14	2.00	11.000	9.00	12.000	80.00	26.00		❍	❍	❍
M16	2.00	12.000	9.00	14.000	80.00	26.00	●	❍	●	❍
M18	2.50	14.000	11.00	15.500	95.00	30.00				❍
M20	2.50	16.000	12.00	17.500	95.00	32.00	●	❍	❍	❍

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

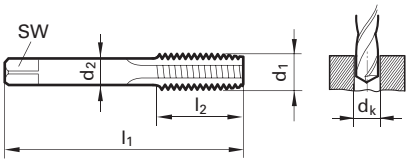
Guhring no.	857	858	859	860
Standard	DIN 2184-2			
Standard	DIN 352			
Tool material	HSS-E			
Surface	●	●	●	●
Type	H	H	H	H
Description	Set of taps	F	S	B
Tolerance	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H
Cutting direction	right-hand	right-hand	right-hand	right-hand
Discount group	118	118	118	118
Techn. data page	811	811	811	811



d1	P	d2	SW	dk	l1	l2	Availability			
	mm	mm		mm	mm	mm				
M 2	0.40	2.800	2.10	1.600	36.00	8.00	●	●		
M 2,2	0.45	2.800	2.10	1.750	36.00	9.00	❍	●	●	●
M 2,5	0.45	2.800	2.10	2.050	40.00	9.00		●		
M 3	0.50	3.500	2.70	2.500	40.00	10.00	●	❍	❍	●
M 3,5	0.60	4.000	3.00	2.900	45.00	12.00				❍
M 4	0.70	4.500	3.40	3.300	45.00	12.00	●	●	●	❍
M 5	0.80	6.000	4.90	4.200	50.00	14.00	●	●	❍	●
M 6	1.00	6.000	4.90	5.000	56.00	16.00	●	●	●	●
M 8	1.25	6.000	4.90	6.800	63.00	17.00	●	●	●	●
M10	1.50	7.000	5.50	8.500	70.00	20.00	●	●	●	●
M12	1.75	9.000	7.00	10.200	75.00	24.00	●	❍	❍	❍
M14	2.00	11.000	9.00	12.000	80.00	26.00	●	❍	●	●
M16	2.00	12.000	9.00	14.000	80.00	26.00	●	●	❍	❍
M18	2.50	14.000	11.00	15.500	95.00	30.00	❍	❍	❍	
M20	2.50	16.000	12.00	17.500	95.00	32.00	●	❍	❍	❍

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

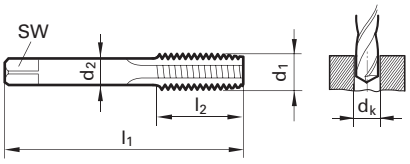
Guhring no.	1818	1819	1820
Standard	DIN 2184-2		
Standard	DIN 352		
Tool material	HSS-E-PM		
Surface	●	●	●
Type	H	H	H
Description	Set of taps	F	S
Tolerance	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H
Cutting direction	right-hand	right-hand	right-hand
Discount group	118	118	118
Techn. data page	811	811	811



d1	P	d2	SW	dk	l1	l2	Availability		
	mm	mm		mm	mm	mm			
M 3	0.50	3.500	2.70	2.500	40.00	10.00	●		
M 4	0.70	4.500	3.40	3.300	45.00	12.00	●		❍
M 5	0.80	6.000	4.90	4.200	50.00	14.00	●		❍
M 6	1.00	6.000	4.90	5.000	56.00	16.00	●		
M 8	1.25	6.000	4.90	6.800	63.00	17.00	●	❍	❍
M10	1.50	7.000	5.50	8.500	70.00	20.00	●	●	❍
M12	1.75	9.000	7.00	10.200	75.00	24.00	●		❍

○ bright ◐ steam tempered ◒ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

Guhring no.	884	885	886
Standard	DIN 2184-2		
Standard	DIN 2181		
Tool material	HSS		
Surface	○	○	○
Type	N	N	N
Description	Set of taps	F	B
Tolerance	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H
Cutting direction	right-hand	right-hand	right-hand
Discount group	118	118	118
Techn. data page	810	810	810



d1 X P	d2	SW	dk	l1	l2	Code no.	Availability		
	mm		mm	mm	mm				
M 2 X0,25	2.800	2.10	1.750	36.00	7.00	2.001		○	●
M 2,2X0,25	2.800	2.10	1.950	36.00	7.00	2.201		○	○
M 2,3X0,25	2.800	2.10	2.050	36.00	7.00	2.301	○	○	○
M 2,6X0,35	2.800	2.10	2.250	40.00	7.00	2.602	○	●	○
M 3 X0,35	3.500	2.70	2.650	40.00	7.00	3.002		○	●
M 4 X0,35	4.500	3.40	3.650	45.00	8.00	4.002	○	○	○
M 4 X0,5	4.500	3.40	3.500	45.00	8.00	4.003		●	●
M 5 X0,5	6.000	4.90	4.500	50.00	10.00	5.003	●	●	
M 6 X0,5	6.000	4.90	5.500	56.00	13.00	6.003		○	●
M 6 X0,75	6.000	4.90	5.200	56.00	13.00	6.004	●	○	●
M 7 X0,75	6.000	4.90	6.200	56.00	13.00	7.004		○	
M 8 X0,5	6.000	4.90	7.500	56.00	14.00	8.003	○	○	
M 8 X0,75	6.000	4.90	7.200	56.00	14.00	8.004	●	○	●
M 8 X1	6.000	4.90	7.000	56.00	17.00	8.005	●	●	●
M 9 X1	7.000	5.50	8.000	63.00	17.00	9.005	○	○	●
M10 X0,75	7.000	5.50	9.200	63.00	17.00	10.004		○	○
M10 X1	7.000	5.50	9.000	63.00	17.00	10.005	●	●	●
M10 X1,25	7.000	5.50	8.800	63.00	20.00	10.006	●	●	●
M11 X1	8.000	6.20	10.000	63.00	20.00	11.005		○	
M12 X1	9.000	7.00	11.000	70.00	20.00	12.005	●	●	●
M12 X1,25	9.000	7.00	10.800	70.00	20.00	12.006	●	●	●
M12 X1,5	9.000	7.00	10.500	70.00	20.00	12.007	●	●	●
M14 X1	11.000	9.00	13.000	70.00	20.00	14.005	●	●	
M14 X1,25	11.000	9.00	12.800	70.00	20.00	14.006	●	○	●
M14 X1,5	11.000	9.00	12.500	70.00	20.00	14.007	●	●	●
M15 X1	12.000	9.00	14.000	70.00	20.00	15.005			●
M15 X1,5	12.000	9.00	13.500	70.00	20.00	15.007		○	
M16 X1	12.000	9.00	15.000	70.00	22.00	16.005	●	○	●
M16 X1,5	12.000	9.00	14.500	70.00	22.00	16.007	●	●	●
M18 X1	14.000	11.00	17.000	80.00	22.00	18.005	●	○	○
M18 X1,5	14.000	11.00	16.500	80.00	22.00	18.007	●	●	●
M18 X2	14.000	11.00	16.000	80.00	22.00	18.008		○	○
M20 X1	16.000	12.00	19.000	80.00	22.00	20.005	○		
M20 X1,5	16.000	12.00	18.500	80.00	22.00	20.007	●	●	●
M20 X2	16.000	12.00	18.000	80.00	22.00	20.008	●	○	○
M22 X1	18.000	14.50	21.000	80.00	22.00	22.005		○	

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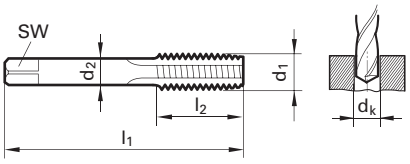
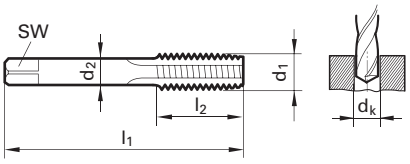
Guhring no.	884	885	886
Standard	DIN 2184-2		
Standard	DIN 2181		
Tool material	HSS		
Surface	○	○	○
Type	N	N	N
Description	Set of taps	F	B
Tolerance	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H
Cutting direction	right-hand	right-hand	right-hand
Discount group	118	118	118
Techn. data page	810	810	810



d1 X P	d2	SW	dk	l1	l2	Code no.	Availability		
	mm		mm	mm	mm				
M22 X1,5	18.000	14.50	20.500	80.00	22.00	22.007	●	❍	●
M22 X2	18.000	14.50	20.000	80.00	22.00	22.008			❍
M24 X1	18.000	14.50	23.000	90.00	22.00	24.005		❍	
M24 X1,5	18.000	14.50	22.500	90.00	22.00	24.007	●	❍	❍
M24 X2	18.000	14.50	22.000	90.00	22.00	24.008	●		❍
M26 X1,5	18.000	14.50	24.500	90.00	22.00	26.007	❍		
M27 X1,5	20.000	16.00	25.500	90.00	22.00	27.007	●	❍	
M27 X2	20.000	16.00	25.000	90.00	22.00	27.008	●		
M30 X1	22.000	18.00	29.000	90.00	22.00	30.005		❍	
M30 X1,5	22.000	18.00	28.500	90.00	22.00	30.007	●		
M30 X2	22.000	18.00	28.000	90.00	22.00	30.008	●		
M32 X1,5	22.000	18.00	30.500	90.00	22.00	32.007		❍	
M34 X1,5	28.000	22.00	32.500	100.00	25.00	34.007		❍	●
M35 X1,5	28.000	22.00	33.500	100.00	25.00	35.007	●	❍	
M36 X1,5	28.000	22.00	34.500	100.00	25.00	36.007	❍	❍	
M38 X1,5	28.000	22.00	36.500	100.00	25.00	38.007		❍	
M45 X1,5	36.000	29.00	43.500	110.00	25.00	45.007		❍	
M52 X1,5	40.000	32.00	50.500	140.00	32.00	52.007		❍	

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

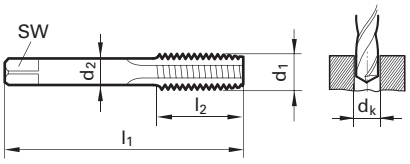
Guhring no.	981	982	983	984
Standard	DIN 2184-2			
Standard	~ DIN 352			
Tool material	HSS			
Surface	○	○	○	○
Type	N	N	N	N
Description	Set of taps	F	S	B
Tolerance	2B	2B	2B	2B
Cutting direction	right-hand	right-hand	right-hand	right-hand
Discount group	118	118	118	118
Techn. data page	810	810	810	810



d1 - P	d2	SW	dk	l1	l2	Code no.	Availability			
	mm		mm	mm	mm					
NR. 1 -64	2.800	2.10	1.550	36.00	8.00	1.854	●	○	○	○
NR. 2 -56	2.800	2.10	1.850	36.00	9.00	2.184		●	●	●
NR. 3 -48	2.800	2.10	2.100	40.00	9.00	2.515		○	○	○
NR. 4 -40	3.500	2.70	2.350	40.00	11.00	2.845	●	●	●	●
NR. 5 -40	4.000	3.00	2.650	40.00	11.00	3.175		●	●	●
NR. 6 -32	4.000	3.00	2.850	45.00	12.00	3.505	●	●	○	●
NR. 8 -32	4.500	3.40	3.500	45.00	13.00	4.166	●	●	○	●
NR.10 -24	6.000	4.90	3.900	50.00	14.00	4.826	●	○	●	●
NR.12 -24	6.000	4.90	4.500	56.00	16.00	5.486	○	○	○	○
1/4 -20	6.000	4.90	5.100	56.00	16.00	6.350	●	○	○	●
5/16-18	6.000	4.90	6.600	63.00	18.00	7.938	●	○	○	●
3/8 -16	7.000	5.50	8.000	70.00	20.00	9.525	●	○		●
7/16-14	8.000	6.20	9.400	70.00	22.00	11.113	●	○	○	●
1/2 -13	9.000	7.00	10.800	75.00	25.00	12.700	●	○	○	●
9/16-12	11.000	9.00	12.200	80.00	30.00	14.288	●	○	○	○
5/8 -11	12.000	9.00	13.500	80.00	30.00	15.875	●	○	○	●
3/4 -10	16.000	12.00	16.500	95.00	33.00	19.050	●	○		●
7/8 - 9	18.000	14.50	19.500	100.00	35.00	22.225		○	○	
1 - 8	18.000	14.50	22.250	110.00	38.00	25.400	●	○		
1 1/8 - 7	22.000	18.00	25.000	125.00	44.00	28.575		○		○
1 1/4 - 7	22.000	18.00	28.000	125.00	44.00	31.750		○	○	
1 3/8 - 6	28.000	22.00	30.750	150.00	50.00	34.925		○	○	○
1 1/2 - 6	32.000	24.00	34.000	150.00	50.00	38.100		○	○	
1 3/4 - 5	36.000	29.00	39.500	160.00	58.00	44.450	○	○	○	○
2 -4,5	40.000	32.00	45.000	180.00	65.00	50.800	○	○	○	○

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

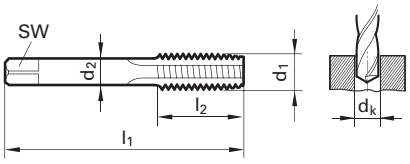
Guhring no.	985	986	987
Standard	DIN 2184-2		
Standard	~ DIN 2181		
Tool material	HSS		
Surface	○	○	○
Type	N	N	N
Description	Set of taps	F	B
Tolerance	2B	2B	2B
Cutting direction	right-hand	right-hand	right-hand
Discount group	118	118	118
Techn. data page	810	810	810



d1 - P	d2	SW	dk	l1	l2	Code no.	Availability		
	mm		mm	mm	mm				
NR. 0 -80	2.500	2.10	1.250	32.00	8.00	1.524		❍	
NR. 1 -72	2.800	2.10	1.550	36.00	8.00	1.854	❍	❍	
NR. 2 -64	2.800	2.10	1.850	36.00	9.00	2.184	❍	❍	❍
NR. 3 -56	2.800	2.10	2.150	40.00	9.00	2.515	❍	❍	❍
NR. 4 -48	3.500	2.70	2.400	40.00	10.00	2.845	●	❍	❍
NR. 5 -44	4.000	3.00	2.700	40.00	10.00	3.175	❍	❍	❍
NR. 6 -40	4.000	3.00	2.950	45.00	11.00	3.505		❍	❍
NR. 8 -36	4.500	3.40	3.500	45.00	12.00	4.166	❍	❍	❍
NR.10 -32	6.000	4.90	4.100	50.00	14.00	4.826	●	●	●
NR.12 -28	6.000	4.90	4.600	56.00	16.00	5.486	❍	●	❍
1/4 -28	6.000	4.90	5.500	56.00	17.00	6.350	●	●	●
5/16-24	6.000	4.90	6.900	63.00	17.00	7.938	●	❍	●
3/8 -24	7.000	5.50	8.500	63.00	18.00	9.525	●	●	●
7/16-20	8.000	6.20	9.900	70.00	20.00	11.113	●	❍	●
1/2 -20	9.000	7.00	11.500	70.00	20.00	12.700	●	❍	●
9/16-18	11.000	9.00	12.900	70.00	20.00	14.288	●	❍	●
5/8 -18	12.000	9.00	14.500	70.00	20.00	15.875	●	●	
3/4 -16	16.000	12.00	17.500	80.00	22.00	19.050	●	❍	●
7/8 -14	18.000	14.50	20.400	80.00	22.00	22.225	●	❍	
1 -12	18.000	14.50	23.250	90.00	22.00	25.400		❍	
1 1/8 -12	22.000	18.00	26.500	90.00	22.00	28.575		❍	
1 1/4 -12	22.000	18.00	29.500	90.00	22.00	31.750		❍	
1 3/8 -12	28.000	22.00	32.750	125.00	30.00	34.925	❍	❍	❍
1 1/2 -12	32.000	24.00	36.000	125.00	30.00	38.100		❍	❍

○ bright ◐ steam tempered ◒ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

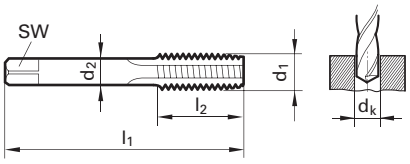
Guhring no.	954	955	956	957
Standard	DIN 2184-2			
Standard	~ DIN 352			
Tool material	HSS			
Surface	○	○	○	○
Type	N	N	N	N
Description	Set of taps	F	S	B
Tolerance				
Cutting direction	right-hand	right-hand	right-hand	right-hand
Discount group	118	118	118	118
Techn. data page	810	810	810	810



d1	P	d2	SW	dk	l1	l2	Code no.	Availability			
	G/inch	mm		mm	mm	mm					
W 1/16	60.00	2.500	2.10	1.200	32.00	8.00	1.587		❍		
W 3/32	48.00	2.800	2.10	1.800	40.00	9.00	2.381		❍	❍	
W 1/8	40.00	4.000	3.00	2.500	40.00	11.00	3.175	❍	❍	❍	❍
W 5/32	32.00	4.500	3.40	3.200	45.00	13.00	3.969		❍	❍	●
W 3/16	24.00	6.000	4.90	3.600	50.00	14.00	4.762		❍	❍	●
W 7/32	24.00	6.000	4.90	4.500	56.00	16.00	5.556		❍		❍
W 1/4	20.00	6.000	4.90	5.100	56.00	16.00	6.350	●	❍	❍	●
W 5/16	18.00	6.000	4.90	6.500	63.00	18.00	7.938	●	❍	❍	●
W 3/8	16.00	7.000	5.50	7.900	70.00	20.00	9.525	●		❍	❍
W 7/16	14.00	8.000	6.20	9.200	70.00	22.00	11.113		❍	❍	
W 1/2	12.00	9.000	7.00	10.500	75.00	25.00	12.700	●	❍	❍	❍
W 9/16	12.00	11.000	9.00	12.000	80.00	30.00	14.287		❍	❍	❍
W 5/8	11.00	12.000	9.00	13.500	80.00	30.00	15.876	●	❍	❍	❍
W 3/4	10.00	16.000	12.00	16.250	95.00	33.00	19.051	❍		❍	❍
W 7/8	9.00	18.000	14.50	19.250	100.00	35.00	22.226	❍	❍	❍	
W1	8.00	18.000	14.50	22.000	110.00	38.00	25.401				❍
W1 1/4	7.00	22.000	18.00	27.750	125.00	44.00	31.751	❍		❍	
W1 3/8	6.00	28.000	22.00	30.500	150.00	50.00	34.926	❍	❍		❍
W1 1/2	6.00	32.000	24.00	33.500	150.00	50.00	38.101	●	❍	❍	
W1 5/8	5.00	32.000	24.00	35.500	150.00	58.00	41.277	❍	❍	❍	❍
W1 3/4	5.00	36.000	29.00	39.000	160.00	58.00	44.452	●	❍	❍	❍
W2	4.50	40.000	32.00	44.500	180.00	65.00	50.802	●	❍	❍	❍

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

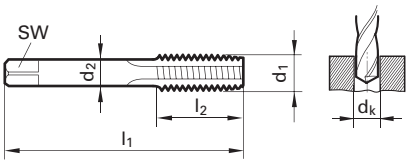
Guhring no.	958	959	960
Standard	DIN 2184-2		
Standard	DIN 5157		
Tool material	HSS		
Surface	○	○	○
Type	N	N	N
Description	Set of taps	F	B
Tolerance			
Cutting direction	right-hand	right-hand	right-hand
Discount group	118	118	118
Techn. data page	810	810	810



d1	P	d2	SW	dk	l1	l2	Code no.	Availability		
	G/inch	mm		mm	mm	mm				
G 1/8	28.00	7.000	5.50	8.800	63.00	20.00	9.728	●	●	●
G 1/4	19.00	11.000	9.00	11.800	70.00	20.00	13.157	●	●	●
G 3/8	19.00	12.000	9.00	15.250	70.00	22.00	16.662	●	●	●
G 1/2	14.00	16.000	12.00	19.000	80.00	22.00	20.955	●	●	●
G 5/8	14.00	18.000	14.50	21.000	80.00	22.00	22.911			●
G 3/4	14.00	20.000	16.00	24.500	90.00	22.00	26.441	●	●	●
G 7/8	14.00	22.000	18.00	28.250	90.00	22.00	30.201		●	●
G1	11.00	25.000	20.00	30.750	100.00	30.00	33.249	●	❍	●
G1 1/8	11.00	28.000	22.00	35.500	125.00	30.00	37.897			❍
G1 1/4	11.00	32.000	24.00	39.500	125.00	40.00	41.910	●	❍	●
G1 3/8	11.00	36.000	29.00	41.750	125.00	40.00	44.323	❍	❍	❍
G1 1/2	11.00	36.000	29.00	45.250	140.00	40.00	47.803	●	❍	●
G1 3/4	11.00	40.000	32.00	51.000	140.00	40.00	53.746	❍	❍	
G2	11.00	45.000	35.00	57.000	160.00	40.00	59.614	●	❍	❍

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

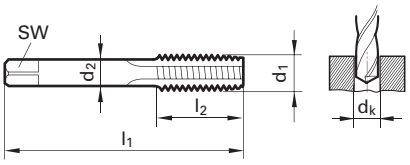
Guhring no.	992	993
Standard	DIN 2184-2	
Standard	DIN 352	
Tool material	HSS-E	
Surface	◯	◯
Type	N R15	N R40
Form	C	C
Tolerance	ISO 2 / 6H	ISO 2 / 6H
Cutting direction	right-hand	right-hand
Discount group	103	103
Techn. data page	789	789



d1	P	d2	SW	dk	l1	l2	Availability	
	mm	mm		mm	mm	mm		
M 2	0.40	2.800	2.10	1.600	36.00	8.00		●
M 2,2	0.45	2.800	2.10	1.750	36.00	9.00	❍	❍
M 2,5	0.45	2.800	2.10	2.050	40.00	9.00	●	●
M 2,6	0.45	2.800	2.10	2.150	40.00	9.00	❍	❍
M 3	0.50	3.500	2.70	2.500	40.00	6.00	●	●
M 3,5	0.60	4.000	3.00	2.900	45.00	7.00		❍
M 4	0.70	4.500	3.40	3.300	45.00	7.50	●	●
M 5	0.80	6.000	4.90	4.200	50.00	8.50	●	●
M 6	1.00	6.000	4.90	5.000	56.00	11.00	●	●
M 7	1.00	6.000	4.90	6.000	56.00	11.00	●	●
M 8	1.25	6.000	4.90	6.800	63.00	14.00	●	●
M10	1.50	7.000	5.50	8.500	70.00	16.00	●	●
M12	1.75	9.000	7.00	10.200	75.00	18.50	●	●
M14	2.00	11.000	9.00	12.000	80.00	20.00	●	
M18	2.50	14.000	11.00	15.500	95.00	25.00	❍	●
M20	2.50	16.000	12.00	17.500	95.00	25.00	●	●
M22	2.50	18.000	14.50	19.500	100.00	27.00		❍

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

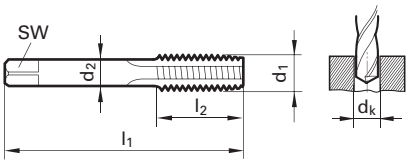
Guhring no.	995
Standard	DIN 2184-2
Standard	DIN 352
Tool material	HSS-E
Surface	○
Type	N
Form	C
Tolerance	ISO 2 / 6H
Cutting direction	right-hand
Discount group	103
Techn. data page	789



d1	P	d2	SW	dk	l1	l2	Availability
	mm	mm		mm	mm	mm	
M 2	0.40	2.800	2.10	1.600	36.00	8.00	❍
M 2,2	0.45	2.800	2.10	1.750	36.00	9.00	❍
M 2,3	0.40	2.800	2.10	1.900	36.00	9.00	●
M 2,5	0.45	2.800	2.10	2.050	40.00	9.00	●
M 2,6	0.45	2.800	2.10	2.150	40.00	9.00	❍
M 3	0.50	3.500	2.70	2.500	40.00	10.00	●
M 3,5	0.60	4.000	3.00	2.900	45.00	7.00	●
M 4	0.70	4.500	3.40	3.300	45.00	7.50	●
M 5	0.80	6.000	4.90	4.200	50.00	8.50	●
M 6	1.00	6.000	4.90	5.000	56.00	11.00	●
M 7	1.00	6.000	4.90	6.000	56.00	16.00	❍
M 8	1.25	6.000	4.90	6.800	63.00	14.00	●
M10	1.50	7.000	5.50	8.500	70.00	16.00	●
M12	1.75	9.000	7.00	10.200	75.00	18.50	●
M16	2.00	12.000	9.00	14.000	80.00	20.00	●
M24	3.00	18.000	14.50	21.000	110.00	36.00	❍

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

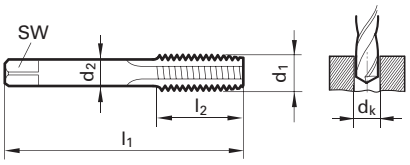
Guhring no.	991
Standard	DIN 2184-2
Standard	DIN 352
Tool material	HSS-E
Surface	◯
Type	N
Form	B
Tolerance	ISO 2 / 6H
Cutting direction	right-hand
Discount group	103
Techn. data page	789



d1	P	d2	SW	dk	l1	l2	Availability
	mm	mm		mm	mm	mm	
M 2	0.40	2.800	2.10	1.600	36.00	8.00	●
M 2,2	0.45	2.800	2.10	1.750	36.00	9.00	❍
M 2,3	0.40	2.800	2.10	1.900	36.00	9.00	●
M 2,5	0.45	2.800	2.10	2.050	40.00	9.00	●
M 2,6	0.45	2.800	2.10	2.150	40.00	9.00	●
M 3	0.50	3.500	2.70	2.500	40.00	10.00	●
M 3,5	0.60	4.000	3.00	2.900	45.00	12.00	●
M 4	0.70	4.500	3.40	3.300	45.00	12.00	●
M 4,5	0.75	6.000	4.90	3.700	50.00	14.00	●
M 5	0.80	6.000	4.90	4.200	50.00	14.00	●
M 6	1.00	6.000	4.90	5.000	56.00	16.00	●
M 7	1.00	6.000	4.90	6.000	56.00	16.00	❍
M 8	1.25	6.000	4.90	6.800	63.00	17.00	●
M10	1.50	7.000	5.50	8.500	70.00	20.00	●
M12	1.75	9.000	7.00	10.200	75.00	24.00	●
M14	2.00	11.000	9.00	12.000	80.00	26.00	●
M16	2.00	12.000	9.00	14.000	80.00	26.00	●
M20	2.50	16.000	12.00	17.500	95.00	32.00	❍
M22	2.50	18.000	14.50	19.500	100.00	32.00	❍
M24	3.00	18.000	14.50	21.000	110.00	36.00	❍

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

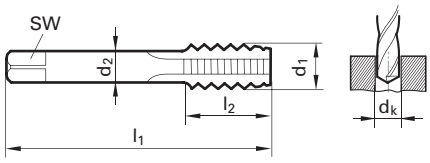
Guhring no.	997	1970
Standard	DIN 2184-2	
Standard	DIN 2181	
Tool material	HSS-E	
Surface	○	○
Type	N	N R40
Form	C	C
Tolerance	ISO 2 / 6H	ISO 2 / 6H
Cutting direction	right-hand	right-hand
Discount group	103	103
Techn. data page	789	789



d1 X P	d2	SW	dk	l1	l2	Code no.	Availability	
	mm		mm	mm	mm			
M 5 X0,5	6.000	4.90	4.500	50.00	5.00	5.003	❍	
M 6 X0,75	6.000	4.90	5.200	56.00	8.00	6.004		❍
M 7 X0,75	6.000	4.90	6.200	56.00	8.00	7.004	❍	
M 8 X0,5	6.000	4.90	7.500	56.00	8.00	8.003		❍
M 8 X0,75	6.000	4.90	7.200	56.00	8.00	8.004		❍
M 8 X1	6.000	4.90	7.000	63.00	11.00	8.005	●	●
M10 X0,75	7.000	5.50	9.200	63.00	11.00	10.004		❍
M10 X1	7.000	5.50	9.000	63.00	11.00	10.005	●	●
M11 X1	8.000	6.20	10.000	63.00	11.00	11.005		❍
M12 X1	9.000	7.00	11.000	70.00	11.00	12.005		❍
M12 X1,5	9.000	7.00	10.500	70.00	16.00	12.007		❍

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

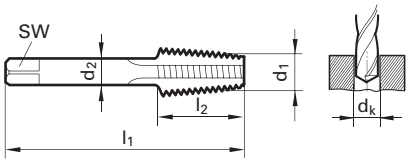
Guhring no.	980	979
Standard	DIN 2184-2	
Standard	DIN 40432	
Tool material	HSS-E	
Surface	○	○
Type	N	N
Form	B	C
Tolerance		
Cutting direction	right-hand	right-hand
Discount group	103	103
Techn. data page	789	789



d1	P	d2	SW	dk	l1	l2	Code no.	Availability	
	G/inch	mm		mm	mm	mm			
PG 7	20.00	9.000	7.00	11.500	70.00	22.00	12.500	●	●
PG 9	18.00	12.000	9.00	14.000	70.00	22.00	15.200	●	●
PG 11	18.00	14.000	11.00	17.250	80.00	22.00	18.600	●	●
PG 13,5	18.00	16.000	12.00	19.000	80.00	22.00	20.400	●	●
PG 16	18.00	18.000	14.50	21.250	80.00	22.00	22.500	●	●
PG 21	16.00	22.000	18.00	27.000	90.00	22.00	28.300		●
PG 29	16.00	28.000	22.00	35.500	100.00	25.00	37.000		●

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

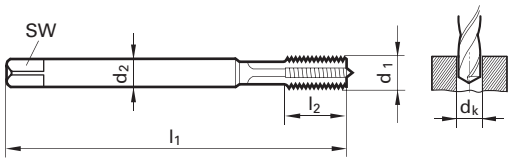
Guhring no.	973
Standard	
Standard	Guhring std.
Tool material	HSS-E
Surface	○
Type	N
Form	C
Tolerance	
Cutting direction	right-hand
Discount group	103
Techn. data page	789



d1	P	d2	SW	dk	l1	l2	Code no.	Availability
	G/inch	mm		mm	mm	mm		
1/16	27.00	6.000	4.90	6.150	56.00	14.00	8.190	●
1/8	27.00	7.000	5.50	8.400	63.00	15.00	10.620	●
1/4	18.00	11.000	9.00	11.100	63.00	21.00	14.140	●
3/8	18.00	12.000	9.00	14.300	70.00	21.00	17.570	●
1/2	14.00	16.000	12.00	17.900	80.00	27.00	21.900	●
3/4	14.00	20.000	16.00	23.300	100.00	27.00	27.230	●
1	11.50	25.000	20.00	29.000	110.00	32.00	34.180	●
1 1/4	11.50	32.000	24.00	37.700	125.00	33.00	42.900	●
1 1/2	11.50	36.000	29.00	43.700	140.00	33.00	48.940	●
2	11.50	36.000	29.00	55.600	160.00	33.00	61.000	●

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

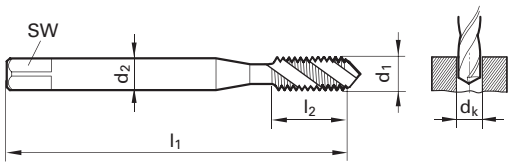
Guhring no.	1057	1061	1065
Standard	DIN 2184-1		
Standard	DIN 371	DIN 371/DIN 376	
Tool material	HSS-E-PM		
Surface	C	C	A
Type	Ti	Ti R15	Ni R10
Form	B	C	C
Tolerance	4HX	4HX	4HX
Cutting direction	right-hand	right-hand	right-hand
Discount group	103	103	103
Techn. data page	805	805	805
	NEW	NEW	NEW



d1	P	d2	SW	dk	l1	l2	Availability		
	mm	mm		mm	mm	mm			
MJ 3X0,5	0.50	3.500	2.70	2.500	56.00	10.00	●	●	●
MJ 4X0,7	0.70	4.500	3.40	3.300	63.00	12.00	●	●	●
MJ 5X0,8	0.80	6.000	4.90	4.200	70.00	14.00	●	●	●
MJ 6X1	1.00	6.000	4.90	5.000	80.00	16.00	●	●	●
MJ 8X1,25	1.25	8.000	6.20	6.800	90.00	17.00	●	●	●
MJ10X1,5	1.50	10.000	8.00	8.500	100.00	20.00	●	●	●
MJ12X1,75	1.75	9.000	7.00	10.200	110.00	24.00	●	●	●
MJ16X2	2.00	12.000	9.00	14.000	110.00	26.00	●	●	●

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

Guhring no.	174	361	783	786
Standard	DIN 2184-1			
Standard	DIN 371			
Tool material	HSS-E			
Surface	S	S	●	○
Type	N R40	H R40	N R40	N L40-LH
Form	C(K)	C	C	C
Tolerance	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H
Cutting direction	right-hand	right-hand	right-hand	left-hand
Discount group	103	103	103	103
Techn. data page	799	793	787	787



d1	P	d2	SW	dk	l1	l2	Availability			
	mm	mm		mm	mm	mm				
M 1	0.25	2.500	2.10	0.750	40.00	5.50				
M 1,2	0.25	2.500	2.10	0.950	40.00	5.50				
M 1,4	0.30	2.500	2.10	1.100	40.00	7.00				
M 1,6	0.35	2.500	2.10	1.250	40.00	4.50				
M 1,7	0.35	2.500	2.10	1.350	40.00	4.50				
M 1,8	0.35	2.500	2.10	1.450	40.00	4.50				
M 2	0.40	2.800	2.10	1.600	45.00	4.50		●	●	
M 2,2	0.45	2.800	2.10	1.750	45.00	5.00				
M 2,3	0.40	2.800	2.10	1.900	45.00	4.50			◐	
M 2,5	0.45	2.800	2.10	2.050	50.00	5.00		●	●	
M 2,6	0.45	2.800	2.10	2.150	50.00	5.00				
M 3	0.50	3.500	2.70	2.500	56.00	6.00		●	●	●
M 3,5	0.60	4.000	3.00	2.900	56.00	7.00		●		
M 4	0.70	4.500	3.40	3.300	63.00	7.50		●	●	●
M 5	0.80	6.000	4.90	4.200	70.00	8.50	●	●	●	●
M 6	1.00	6.000	4.90	5.000	80.00	11.00	●	●	●	●
M 7	1.00	7.000	5.50	6.000	80.00	11.00		●		
M 8	1.25	8.000	6.20	6.800	90.00	14.00	●	●	●	●
M10	1.50	10.000	8.00	8.500	100.00	16.00	●	●	●	●

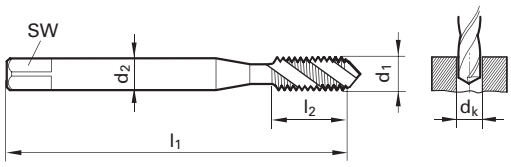
○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

795	799	806	809	810	811	812	814
DIN 2184-1							
DIN 371							
HSS-E							
○	○	○	○	○	○	○	○
N	N R15	N	N R15	N R40	H R40	Al R45	VA R40
C	C	C	C	C	C	C	C
ISO 3 / 6G	ISO 3 / 6G	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H
right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand
103	103	103	103	103	103	103	103
786	787	787	787	787	793	800	797

Availability							
		●					
		●					
		●					
		●				●	
		●					
		●					
	●	●	●	●	●	●	
	○		○	○	○	○	
		●	●	●	●	○	
	●	●	●	●	●	●	
		●	●	●	●	○	
●	●	●	●	●	●	●	●
	●	●	●	●	●	●	
●	●	●	●	●	●	●	●
●	●	●	●	●	●	●	●
					●		
●	●	●	●	●	●	●	●
○	●	●	●	●	●	●	●

C TiCN Cb Carbo D Cristall F FIRE/nanoFIRE P AlCrN S TiN S+ TiN+ M MolyGlide Y Signum

Guhring no.	836	843	844	889
Standard	DIN 2184-1			
Standard	DIN 371			
Tool material	HSS-E			
Surface	steam tempered	steam tempered	bright	bright
Type	N R40	VA R15	N R40	N R40
Form	C	C	C	C
Tolerance	ISO 2 / 6H	ISO 2 / 6H	ISO 3 / 6G	ISO 2 / 6H
Cutting direction	right-hand	right-hand	right-hand	right-hand
Discount group	103	103	103	103
Techn. data page	799	797	787	799



d1	P	d2	SW	dk	l1	l2	836	843	844	889
	mm	mm		mm	mm	mm	Availability			
M 2	0.40	2.800	2.10	1.600	45.00	4.50	●	●		●
M 2,2	0.45	2.800	2.10	1.750	45.00	5.00				●
M 2,3	0.40	2.800	2.10	1.900	45.00	4.50				●
M 2,5	0.45	2.800	2.10	2.050	50.00	5.00		❍		●
M 2,6	0.45	2.800	2.10	2.150	50.00	5.00				●
M 3	0.50	3.500	2.70	2.500	56.00	6.00	●	●	●	●
M 3,5	0.60	4.000	3.00	2.900	56.00	7.00		●		●
M 4	0.70	4.500	3.40	3.300	63.00	7.50	●	●	●	●
M 5	0.80	6.000	4.90	4.200	70.00	8.50	●	●	●	●
M 6	1.00	6.000	4.90	5.000	80.00	11.00	●	●	●	●
M 7	1.00	7.000	5.50	6.000	80.00	11.00				
M 8	1.25	8.000	6.20	6.800	90.00	14.00	●	●	●	●
M10	1.50	10.000	8.00	8.500	100.00	16.00	●	●	●	●

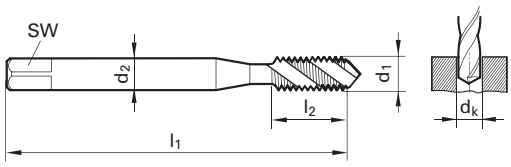
○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

913	914	946	947	1252	1916	2425	2440
DIN 2184-1							
DIN 371							
HSS-E							
S	S			C	C	M	S
N R15	N R40	N R15	H R40	N R40	H R40	N R40	N R40
C	C	C	C	C	C	C	C
ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H
right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand
103	103	103	103	103	103	103	103
787	787	787	793	787	793	799	799

Availability							
●	●	●	●		●		●
	○						
○	○						
●	●						
○	●	●					
●	●	●	●	○	●	●	●
●	●		○		●		
●	●	●	●	●	●	●	●
●	●	●	●	●	●	●	●
●	●	●	●	●	●	●	●
			●				
●	●	●	●	●	●	●	●
●	●	●	●	○	●	●	●

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

Guhring no.	2790	2850	2862
Standard	DIN 2184-1		
Standard	DIN 371		
Tool material	HSS-E		
Surface	○	●	●
Type	N R40	H R40	VA R40
Form	E	C	C
Tolerance	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H
Cutting direction	right-hand	right-hand	right-hand
Discount group	103	103	103
Techn. data page	799	793	796



d1	P	d2	SW	dk	l1	l2	Availability		
	mm	mm		mm	mm	mm			
M 2	0.40	2.800	2.10	1.600	45.00	4.50		●	
M 2,3	0.40	2.800	2.10	1.900	45.00	4.50		○	
M 2,5	0.45	2.800	2.10	2.050	50.00	5.00		●	
M 2,6	0.45	2.800	2.10	2.150	50.00	5.00		●	
M 3	0.50	3.500	2.70	2.500	56.00	6.00	●	●	●
M 3,5	0.60	4.000	3.00	2.900	56.00	7.00		●	
M 4	0.70	4.500	3.40	3.300	63.00	7.50	●	●	●
M 5	0.80	6.000	4.90	4.200	70.00	8.50	●	●	●
M 6	1.00	6.000	4.90	5.000	80.00	11.00	●	●	●
M 7	1.00	7.000	5.50	6.000	80.00	11.00		○	
M 8	1.25	8.000	6.20	6.800	90.00	14.00	●	●	●
M10	1.50	10.000	8.00	8.500	100.00	16.00	●	●	●
M12	1.75	9.000	7.00	10.200	110.00	18.50			
M16	2.00	12.000	9.00	14.000	110.00	20.00			
M20	2.50	16.000	12.00	17.500	140.00	25.00			

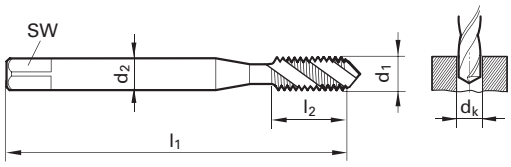
○ bright ● steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

2896	2984	2985	2986	2994	2995	4154	4155
DIN 2184-1							
DIN 371							
HSS-E							
S	○	●	S	●	S	C	C
VA R15	H R40	H R40	H R40	N R40	N R40	N R15	N R15
C	C	C	C	C	C	C	E
ISO 2 / 6H	ISO 3 / 6G	ISO 3 / 6G	ISO 3 / 6G	ISO 3 / 6G	ISO 3 / 6G	ISO 2 / 6H	ISO 2 / 6H
right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand
103	103	103	103	103	103	103	103
797	793	793	793	799	799	799	799
						NEW	NEW

Availability							
	❍	●	❍				
		●	●				
●	❍	●	●	●	●	●	●
●	❍	●	●	●	●	●	●
●	❍	●	●	●	●	●	●
●	●	●	●	●	●	●	●
●	●	●	●	●	●	●	●
						●	●
						●	●
						●	●

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

Guhring no.	59	767
Standard	DIN 2184-1	
Standard	DIN 371	
Tool material	HSS-E-PM	
Surface	S	S
Type	VA R40	N R50
Form	C	C
Tolerance	ISO 2 / 6H	ISO 2 / 6H
Cutting direction	right-hand	right-hand
Discount group	103	103
Techn. data page	797	799



d1	P	d2	SW	dk	l1	l2	Availability	
	mm	mm		mm	mm	mm		
M 2	0.40	2.800	2.10	1.600	45.00	4.50		
M 3	0.50	3.500	2.70	2.500	56.00	6.00	●	●
M 4	0.70	4.500	3.40	3.300	63.00	7.50	●	●
M 5	0.80	6.000	4.90	4.200	70.00	8.50	●	●
M 6	1.00	6.000	4.90	5.000	80.00	11.00	●	●
M 8	1.25	8.000	6.20	6.800	90.00	14.00	●	●
M10	1.50	10.000	8.00	8.500	100.00	16.00	●	●
M12	1.75	9.000	7.00	10.200	110.00	18.50		
M16	2.00	12.000	9.00	14.000	110.00	20.00		
M20	2.50	16.000	12.00	17.500	140.00	25.00		

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

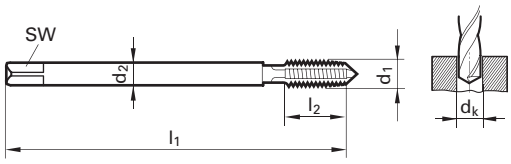
872	909	1288	1290	1577
DIN 2184-1				
DIN 371				
HSS-E-PM				
○	○	S	C	A
H R15	VA R40	N R40	N R40	H R15
C	C	C	C	C
ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H
right-hand	right-hand	right-hand	right-hand	right-hand
103	103	103	103	103
792	797	799	799	792

Availability				
●	●	●	●	●
●	●	●	●	●
●	●	●	●	●
●	●	●	●	●
●	●	●	●	●
			●	
			●	
			●	
			●	

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

Guhring no.	778	785	787	825
Standard	DIN 2184-1			
Standard	DIN 376			
Tool material	HSS-E			
Surface	C			
Type	H	VA R15	N L40-LH	VA R40
Form	C	C	C	C
Tolerance	6HX	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H
Cutting direction	right-hand	right-hand	left-hand	right-hand
Discount group	103	103	103	103
Techn. data page	792	797	787	797

NEW



d1	P	d2	SW	dk	l1	l2	778	785	787	825
	mm	mm		mm	mm	mm	Availability			
M12	1.75	9.000	7.00	10.200	110.00	18.50		●	●	●
M14	2.00	11.000	9.00	12.000	110.00	20.00		●	●	●
M16	2.00	12.000	9.00	14.000	110.00	20.00	●	●	●	●
M18	2.50	14.000	11.00	15.500	125.00	25.00			◐	●
M20	2.50	16.000	12.00	17.500	140.00	25.00	●	●	●	●
M22	2.50	18.000	14.50	19.500	140.00	27.00				●
M24	3.00	18.000	14.50	21.000	160.00	30.00	●	●		●
M27	3.00	20.000	16.00	24.000	160.00	30.00	●			
M30	3.50	22.000	18.00	26.500	180.00	35.00	●			●
M33	3.50	25.000	20.00	29.500	180.00	35.00	●			
M36	4.00	28.000	22.00	32.000	200.00	40.00	●			
M39	4.00	32.000	24.00	35.000	200.00	40.00	●			

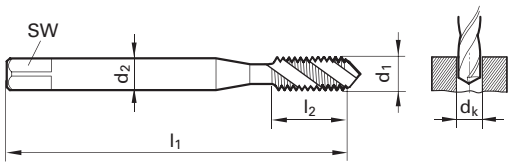
○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

1254	2863	2895	60	910	935	1098	1289	1578
DIN 2184-1								
DIN 376								
HSS-E			HSS-E-PM					
C		S	S			S	S	A
N R40	VA R40	VA R15	VA R40	VA R40	H R15	N R50	N R40	H R15
C	C	C	C	C	C	C	C	C
ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H
right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand
103	103	103	103	103	103	103	103	103
787	797	797	797	797	792	799	799	792

Availability								
●	●	●	●	●	●	●	●	●
❍	●		●	●		●	●	
❍	●	●	●	●	●	●	●	●
	●	❍		❍			●	
	●	●	●	●	●	●	●	●
	●	●						
	●	●		●				

C TiCN Cb Carbo D Cristall F FIRE/nanoFIRE P AlCrN S TiN S+ TiN+ M MolyGlide Y Signum

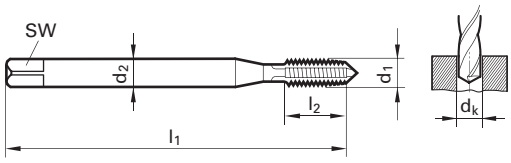
Guhring no.	761	763
Standard	DIN 2184-1	
Standard	DIN 371	DIN 376
Tool material	HSS-E-PM	
Surface	S	S
Type	VA R50	VA R50
Form	C	C
Tolerance	6HX	6HX
Cutting direction	right-hand	right-hand
Discount group	103	103
Techn. data page	797	797



d1	P	d2	SW	dk	l1	l2	Availability	
	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		●

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

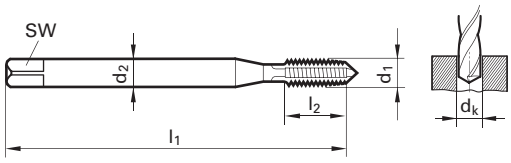
Guhring no.	942
Standard	DIN 2184-1
Standard	~ DIN 371
Tool material	Solid carbide
Surface	C
Type	N
Form	B
Tolerance	6HX
Cutting direction	right-hand
Discount group	103
Techn. data page	798



d1	P	d2	SW	dk	l1	l2	Availability
	mm	mm		mm	mm	mm	
M 5	0.80	6.000	4.90	4.200	70.00	12.00	●
M 6	1.00	6.000	4.90	5.000	80.00	15.00	●
M 8	1.25	8.000	6.20	6.800	90.00	19.00	●
M10	1.50	10.000	8.00	8.500	100.00	22.00	❍
M12	1.75	12.000	9.00	10.200	110.00	26.50	●

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

Guhring no.	313	733	788	789
Standard	DIN 2184-1			
Standard	DIN 371			
Tool material	HSS-E			
Surface	(S)	◯	●	○
Type	N	H	H AZ	N-LH
Form	B	B	C	B
Tolerance	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H
Cutting direction	right-hand	right-hand	right-hand	left-hand
Discount group	103	103	103	103
Techn. data page	798	790	808	787



d1	P	d2	SW	dk	l1	l2	313	733	788	789
	mm	mm		mm	mm	mm	Availability			
M 1,4	0.30	2.500	2.10	1.100	40.00	7.00				
M 1,6	0.35	2.500	2.10	1.250	40.00	8.00				
M 1,7	0.35	2.500	2.10	1.350	40.00	8.00				
M 1,8	0.35	2.500	2.10	1.450	40.00	8.00				
M 2	0.40	2.800	2.10	1.600	45.00	8.00		●	●	
M 2,2	0.45	2.800	2.10	1.750	45.00	9.00		◯	●	
M 2,3	0.40	2.800	2.10	1.900	45.00	9.00				
M 2,5	0.45	2.800	2.10	2.050	50.00	9.00		●	●	
M 2,6	0.45	2.800	2.10	2.150	50.00	9.00		●		
M 3	0.50	3.500	2.70	2.500	56.00	10.00	●	●	●	◯
M 3,5	0.60	4.000	3.00	2.900	56.00	12.00		●	◯	
M 4	0.70	4.500	3.40	3.300	63.00	12.00	●	●	●	◯
M 5	0.80	6.000	4.90	4.200	70.00	14.00	●	●	●	●
M 6	1.00	6.000	4.90	5.000	80.00	16.00	●	●	●	●
M 7	1.00	7.000	5.50	6.000	80.00	16.00				
M 8	1.25	8.000	6.20	6.800	90.00	17.00	●	●	●	●
M10	1.50	10.000	8.00	8.500	100.00	20.00	●	●	◯	●

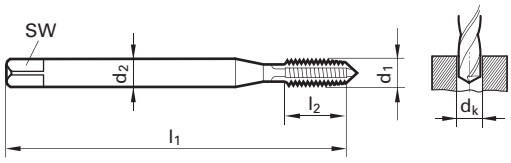
○ bright ◯ steam tempered ◒ nitrided lands ● nitrided ● golden brown (A) TiAlN (a) TiAlN nanoA (A) TiAlN SuperA

791	794	796	797	800	801	802	803	804	805
DIN 2184-1									
DIN 371									
HSS-E									
○	○	○	○	○	○	○	○	○	○
H AZ	N	N	N	Ms	N	N	N	H	Al
B	B	B	B	E	D	B	B	B	B
ISO 2 / 6H	ISO 1 / 4H	ISO 3 / 6G	ISO 3 / 6G	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H
right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand
103	103	103	103	103	103	103	103	103	103
791	786	786	786	807	786	786	786	790	800

Availability									
							●		
							●		
							●		
							●		
●	●	○			●	●	●	●	●
○					○		●	●	○
					○		●		
●	●	○			●	●	●	●	●
					○		●	●	●
●	●	●		●	●	●	●	●	●
○					○		●	●	
●	●	●	●	●	●	●	●	●	●
●	●	●	●	●	●	●	●	●	●
●	●	●	●	●	●	●	●	●	●
	○	●					●		
●	●	○	●	●	●	○	●	●	●
●	●	●		●	●	○	●	●	●

C TiCN | Cb Carbo | D Cristall | F FIRE/nanoFIRE | P AlCrN | S TiN | S+ TiN+ | M MolyGlide | Y Signum

Guhring no.	807	808	837	838
Standard	DIN 2184-1			
Standard	DIN 371			
Tool material	HSS-E			
Surface	●	○	○	○
Type	GG	N L15	N	N
Form	C	D	B	B
Tolerance	6HX	ISO 2 / 6H	ISO 3 / 6G	ISO 2 / 6H
Cutting direction	right-hand	right-hand	right-hand	right-hand
Discount group	103	103	103	103
Techn. data page	802	787	786	786



d1	P	d2	SW	dk	l1	l2	Availability			
	mm	mm		mm	mm	mm				
M 1	0.25	2.500	2.10	0.750	40.00	5.50				
M 1,1	0.25	2.500	2.10	0.850	40.00	5.50				
M 1,2	0.25	2.500	2.10	0.950	40.00	5.50				
M 1,4	0.30	2.500	2.10	1.100	40.00	7.00			●	●
M 1,6	0.35	2.500	2.10	1.250	40.00	8.00			●	●
M 1,7	0.35	2.500	2.10	1.350	40.00	8.00				●
M 1,8	0.35	2.500	2.10	1.450	40.00	8.00				
M 2	0.40	2.800	2.10	1.600	45.00	8.00			●	●
M 2,2	0.45	2.800	2.10	1.750	45.00	9.00			◐	●
M 2,3	0.40	2.800	2.10	1.900	45.00	9.00				◐
M 2,5	0.45	2.800	2.10	2.050	50.00	9.00			●	●
M 2,6	0.45	2.800	2.10	2.150	50.00	9.00				◐
M 3	0.50	3.500	2.70	2.500	56.00	10.00	●	●	●	◐
M 3,5	0.60	4.000	3.00	2.900	56.00	12.00	●	◐	●	●
M 4	0.70	4.500	3.40	3.300	63.00	12.00	●	◐	●	●
M 5	0.80	6.000	4.90	4.200	70.00	14.00	●	●	●	●
M 6	1.00	6.000	4.90	5.000	80.00	16.00	●	●	●	●
M 7	1.00	7.000	5.50	6.000	80.00	16.00				
M 8	1.25	8.000	6.20	6.800	90.00	17.00	●	●	●	●
M10	1.50	10.000	8.00	8.500	100.00	20.00	●	●	●	●

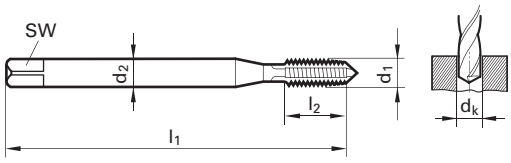
○ bright ◐ steam tempered ◒ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

839	869	912	930	945	1246	1870	1871	1875	1914
DIN 2184-1									
DIN 371									
HSS-E									
○	○	S	S	●	C	○	○	S	C
N	N	N	GG	N	N	VA	VA AZ	GGT	H
B	B	B	C	B	B	B	B	C	B
ISO 2 / 6H	ISO 3 / 6G	ISO 2 / 6H	6HX	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H
right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand
103	103	103	103	103	103	103	103	103	103
786	786	786	802	786	786	796	796	802	791

Availability									
● ○ ●				● ● ●					
●		● ● ●		● ● ●					
● ○		● ● ●		○ ● ●		●			● ●
● ○ ○		○ ● ○		● ● ●		● ●			● ● ●
○ ●	● ● ●	● ● ● ●	● ● ●	● ● ● ●	● ● ●	● ● ●	● ● ●	○ ● ●	● ● ● ●
	●	● ●	● ●	● ●	● ●	● ●	● ●	● ●	● ●

C TiCN | Cb Carbo | D Cristall | F FIRE/nanoFIRE | P AlCrN | S TiN | S+ TiN+ | M MolyGlide | Y Signum

Guhring no.	1918	2086	2427
Standard	DIN 2184-1		
Standard	DIN 371		
Tool material	HSS-E		
Surface	A	S	A + M
Type	GG	VA	N
Form	C	B	B
Tolerance	6HX	ISO 2 / 6H	ISO 2 / 6H
Cutting direction	right-hand	right-hand	right-hand
Discount group	103	103	103
Techn. data page	802	796	798



d1	P	d2	SW	dk	l1	l2	Availability		
	mm	mm		mm	mm	mm			
M 2	0.40	2.800	2.10	1.600	45.00	8.00			
M 2,5	0.45	2.800	2.10	2.050	50.00	9.00			
M 3	0.50	3.500	2.70	2.500	56.00	10.00	●	●	●
M 3,5	0.60	4.000	3.00	2.900	56.00	12.00	❍		❍
M 4	0.70	4.500	3.40	3.300	63.00	12.00	●	●	●
M 5	0.80	6.000	4.90	4.200	70.00	14.00	●	●	●
M 6	1.00	6.000	4.90	5.000	80.00	16.00	●	●	●
M 8	1.25	8.000	6.20	6.800	90.00	17.00	●	●	●
M10	1.50	10.000	8.00	8.500	100.00	20.00	●	●	●

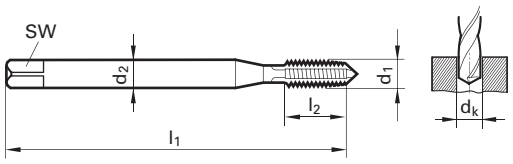
○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

2465	2710	2869	2876	2941	2990	2991
DIN 2184-1						
DIN 371						
HSS-E						
○	S	●	●	●	●	S
H	H	VA	N	H	N	N
B	B	B	B	B	B	B
ISO 3 / 6G	ISO 3 / 6G	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 3 / 6G	ISO 3 / 6G
right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand
103	103	103	103	103	103	103
790	791	796	798	791	798	798

Availability						
○	●		●	●	●	
○	●			●		
○	●	●	●	●	●	●
●	●	●	●	●	●	●
○	●	●	●	●	●	●
○	●	●	●	●	●	●
●	●	●	●	●	●	●
○	●	●	●	●	●	●

C TiCN Cb Carbo D Cristall F FIRE/nanoFIRE P AlCrN S TiN S+ TiN+ M MolyGlide Y Signum

Guhring no.	57	875
Standard	DIN 2184-1	
Standard	DIN 371	
Tool material	HSS-E-PM	
Surface	S	○
Type	H	H
Form	B	B
Tolerance	ISO 2 / 6H	ISO 2 / 6H
Cutting direction	right-hand	right-hand
Discount group	103	103
Techn. data page	791	791



d1	P	d2	SW	dk	l1	l2	Availability	
	mm	mm		mm	mm	mm		
M 2	0.40	2.800	2.10	1.600	45.00	8.00		
M 2,5	0.45	2.800	2.10	2.050	50.00	9.00		
M 3	0.50	3.500	2.70	2.500	56.00	10.00	●	●
M 4	0.70	4.500	3.40	3.300	63.00	12.00	●	●
M 5	0.80	6.000	4.90	4.200	70.00	14.00	●	●
M 6	1.00	6.000	4.90	5.000	80.00	16.00	●	●
M 8	1.25	8.000	6.20	6.800	90.00	17.00	●	●
M10	1.50	10.000	8.00	8.500	100.00	20.00	●	●
M12	1.75	9.000	7.00	10.200	110.00	24.00		
M16	2.00	12.000	9.00	14.000	110.00	26.00		
M20	2.50	16.000	12.00	17.500	140.00	32.00		

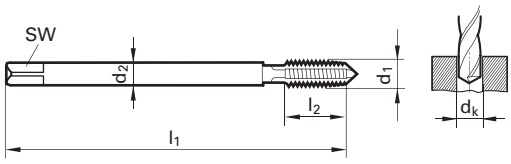
○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

877	1002	1084	1285	1287	1575
DIN 2184-1					
DIN 371					
HSS-E-PM					
○	C	○	S	C	A
VA	VA	Ms	N	N	H
B	B	E	B	B	B
ISO 2 / 6H	ISO 2 / 6H	ISO 3 / 6G	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H
right-hand	right-hand	right-hand	right-hand	right-hand	right-hand
103	103	103	103	103	103
796	796	807	798	798	791
	NEW				

Availability					
●	●		●		
●					
●	●	●	●	●	●
●	●	●	●	●	●
●	●	●	●	●	●
●	●	●	●	●	●
●	●	●	●	●	●
●	●	●	●	●	●
				●	
				●	

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

Guhring no.	790	792	817	849
Standard	DIN 2184-1			
Standard	DIN 376			
Tool material	HSS-E			
Surface	○	○	○	○
Type	N-LH	VA AZ	Al	H AZ
Form	B	B	B	B
Tolerance	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H
Cutting direction	left-hand	right-hand	right-hand	right-hand
Discount group	103	103	103	103
Techn. data page	787	796	800	791



d1	P	d2	SW	dk	l1	l2	Availability			
	mm	mm		mm	mm	mm				
M 3	0.50	3.500	2.70	2.500	56.00	10.00				
M 4	0.70	4.500	3.40	3.300	63.00	12.00				
M 5	0.80	6.000	4.90	4.200	70.00	14.00				
M 6	1.00	6.000	4.90	5.000	80.00	16.00				
M 8	1.25	8.000	6.20	6.800	90.00	17.00				
M10	1.50	10.000	8.00	8.500	100.00	20.00				
M12	1.75	9.000	7.00	10.200	110.00	24.00	●	●	●	●
M14	2.00	11.000	9.00	12.000	110.00	26.00	❍	❍	❍	❍
M16	2.00	12.000	9.00	14.000	110.00	26.00	●	❍	●	●
M18	2.50	14.000	11.00	15.500	125.00	30.00			❍	❍
M20	2.50	16.000	12.00	17.500	140.00	32.00	●		●	
M22	2.50	18.000	14.50	19.500	140.00	32.00			❍	
M24	3.00	18.000	14.50	21.000	160.00	36.00			❍	
M30	3.50	22.000	18.00	26.500	180.00	40.00				

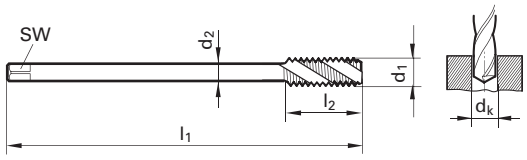
○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

1249	58	879	1286	1576	2901	2909	2916	2920
DIN 2184-1								
		DIN 376				DIN 371/DIN 376		
HSS-E	HSS-E-PM							
C	S	○	S	A	C	C	A	A
N	H	VA	N	H	Ti	Ti R15	Ni	Ni R10
B	B	B	B	B	B	C	B	C
ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	6HX	6HX	6HX	6HX
right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand
103	103	103	103	103	103	103	103	103
786	791	796	798	791	804	804	804	804

Availability								
					●	●	●	●
					●	●	●	●
					●	●	●	●
					●	●	●	●
					●	●	●	●
					●	●	●	●
●	●	●	●	●	●	●	●	●
○	●	●	●	●				
●	●	●	●	●	●	●	●	●
	●		○					
	●	●	●	●				
	●			●				
				●				

C TiCN | Cb Carbo | D Cristall | F FIRE/nanoFIRE | P AlCrN | S TiN | S+ TiN+ | M MolyGlide | Y Signum

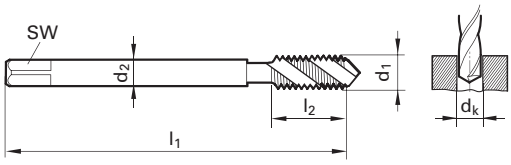
Guhring no.	888
Standard	
Standard	Guhring std.
Tool material	HSS-E
Surface	○
Type	N R40
Form	C
Tolerance	ISO 2 / 6H
Cutting direction	right-hand
Discount group	103
Techn. data page	789



d1	P	d2	SW	dk	l1	l2	Availability
	mm	mm		mm	mm	mm	
M 3	0.50	3.500	2.70	2.500	90.00	6.00	●
M 4	0.70	4.500	3.40	3.300	125.00	7.50	●
M 5	0.80	6.000	4.90	4.200	140.00	8.50	●
M 6	1.00	6.000	4.90	5.000	160.00	11.00	●
M 8	1.25	6.000	4.90	6.800	180.00	14.00	●
M10	1.50	7.000	5.50	8.500	200.00	16.00	●
M12	1.75	9.000	7.00	10.200	220.00	18.50	●
M14	2.00	11.000	9.00	12.000	220.00	20.00	●
M16	2.00	12.000	9.00	14.000	220.00	20.00	●
M20	2.50	16.000	12.00	17.500	280.00	25.00	●

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

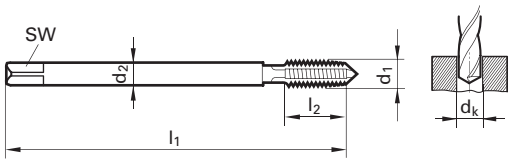
Guhring no.	196	916	2791	2851
Standard	DIN 2184-1			
Standard	DIN 376			
Tool material	HSS-E			
Surface	S	S	○	●
Type	N R40	N R15	N R40	H R40
Form	C(K)	C	E	C
Tolerance	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H
Cutting direction	right-hand	right-hand	right-hand	right-hand
Discount group	103	103	103	103
Techn. data page	799	787	799	793



d1	P	d2	SW	dk	l1	l2	Availability			
	mm	mm		mm	mm	mm				
M 3,5	0.60	2.500	2.10	2.900	56.00	7.00		❍		
M 4	0.70	2.800	2.10	3.300	63.00	7.50		●	●	●
M 5	0.80	3.500	2.70	4.200	70.00	8.50	●	●	●	●
M 6	1.00	4.500	3.40	5.000	80.00	11.00	●	●	●	●
M 8	1.25	6.000	4.90	6.800	90.00	14.00	●	●	●	●
M10	1.50	7.000	5.50	8.500	100.00	16.00	●	●	●	●
M12	1.75	9.000	7.00	10.200	110.00	18.50	●	●	●	●
M14	2.00	11.000	9.00	12.000	110.00	20.00		❍	●	●
M16	2.00	12.000	9.00	14.000	110.00	20.00	●	●	●	●
M18	2.50	14.000	11.00	15.500	125.00	25.00		❍		❍
M20	2.50	16.000	12.00	17.500	140.00	25.00	●	●		●
M22	2.50	18.000	14.50	19.500	140.00	27.00		❍		
M24	3.00	18.000	14.50	21.000	160.00	30.00	●	●		●
M30	3.50	22.000	18.00	26.500	180.00	35.00	●			●

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

Guhring no.	846	1876	2870
Standard	DIN 2184-1		
Standard	DIN 376		
Tool material	HSS-E		
Surface	bright	S	steam tempered
Type	N	GGT	VA
Form	B	C	B
Tolerance	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H
Cutting direction	right-hand	right-hand	right-hand
Discount group	103	103	103
Techn. data page	800	802	796

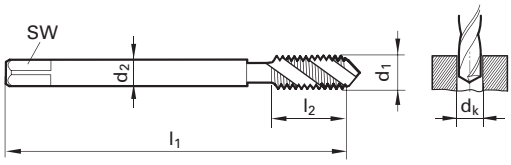


d1	P	d2	SW	dk	l1	l2	846	1876	2870
	mm	mm		mm	mm	mm	Availability		
M 4	0.70	2.800	2.10	3.300	63.00	12.00	●	❍	●
M 5	0.80	3.500	2.70	4.200	70.00	14.00		●	●
M 6	1.00	4.500	3.40	5.000	80.00	16.00		❍	●
M 8	1.25	6.000	4.90	6.800	90.00	17.00	●	●	●
M10	1.50	7.000	5.50	8.500	100.00	20.00		●	●
M12	1.75	9.000	7.00	10.200	110.00	24.00	●	●	●
M14	2.00	11.000	9.00	12.000	110.00	26.00	❍	●	●
M16	2.00	12.000	9.00	14.000	110.00	26.00	❍	●	●
M18	2.50	14.000	11.00	15.500	125.00	30.00		❍	●
M20	2.50	16.000	12.00	17.500	140.00	32.00			●
M24	3.00	18.000	14.50	21.000	160.00	36.00			●

○ bright ● steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

Guhring no.	4153
Standard	
Standard	Guhring std.
Tool material	HSS-E
Surface	S
Type	N R40
Form	C
Tolerance	6HX
Cutting direction	right-hand
Discount group	103
Techn. data page	799

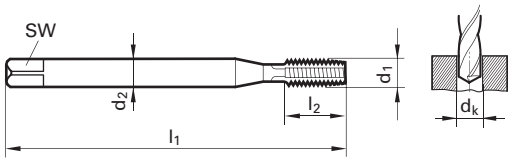
NEW



d1	P	d2	SW	dk	l1	l2	Availability
	mm	mm		mm	mm	mm	
M 3	0.50	3.500	2.70	2.500	112.00	6.00	●
M 4	0.70	2.800	2.10	3.300	112.00	7.50	●
M 5	0.80	3.500	2.70	4.200	125.00	8.50	●
M 6	1.00	4.500	3.40	5.000	125.00	11.00	●
M 8	1.25	6.000	4.90	6.800	140.00	14.00	●
M10	1.50	7.000	5.50	8.500	160.00	16.00	●
M12	1.75	9.000	7.00	10.200	180.00	18.50	●
M16	2.00	12.000	9.00	14.000	220.00	20.00	●
M20	2.50	16.000	12.00	17.500	280.00	25.00	●

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

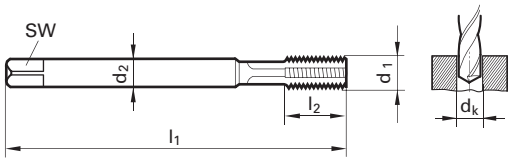
Guhring no.	1201
Standard	DIN 2184-1
Standard	DIN 371/DIN 376
Tool material	HSS-E-PM
Surface	C
Type	H
Form	D
Tolerance	6HX
Cutting direction	right-hand
Discount group	103
Techn. data page	794



d1	P	d2	SW	dk	l1	l2	Availability
	mm	mm		mm	mm	mm	
M 3	0.50	3.500	2.70	2.600	56.00	10.00	●
M 4	0.70	4.500	3.40	3.400	63.00	12.00	●
M 5	0.80	6.000	4.90	4.300	70.00	14.00	●
M 6	1.00	6.000	4.90	5.100	80.00	16.00	●
M 8	1.25	8.000	6.20	6.900	90.00	17.00	●
M10	1.50	10.000	8.00	8.600	100.00	20.00	●
M12	1.75	12.000	9.00	10.400	110.00	24.00	●
M14	2.00	11.000	9.00	12.100	110.00	26.00	●
M16	2.00	12.000	9.00	14.100	110.00	26.00	●

bright · steam tempered · nitrided lands · nitrided · golden brown · A TiAlN · a TiAlN nanoA · A TiAlN SuperA

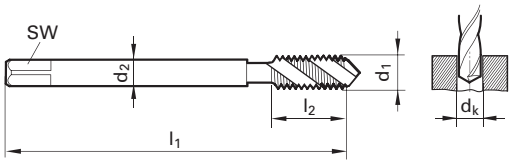
Guhring no.	2944
Standard	Guhring std.
Standard	~ DIN 371
Tool material	Solid carbide
Surface	C
Type	H
Form	D
Tolerance	ISO 2 / 6H
Cutting direction	right-hand
Discount group	103
Techn. data page	794



d1	P	d2	SW	dk	l1	l2	Availability
	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	●
M16	2.00	16.000	12.00	14.100	110.00	40.00	●

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

Guhring no.	362	784	818	821	822
Standard	DIN 2184-1				
Standard	DIN 376				
Tool material	HSS-E				
Surface	S	●	○	○	○
Type	H R40	N R40	N	N R15	N R40
Form	C	C	C	C	C
Tolerance	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H
Cutting direction	right-hand	right-hand	right-hand	right-hand	right-hand
Discount group	103	103	103	103	103
Techn. data page	793	787	787	787	787



d1	P	d2	SW	dk	l1	l2	Availability				
	mm	mm		mm	mm	mm					
M 1,6	0.35	1.200		1.250	40.00	4.50			●		
M 1,7	0.35	1.200		1.350	40.00	4.50			●		
M 2	0.40	1.400		1.600	45.00	4.50			●		
M 2,2	0.45	1.600		1.750	45.00	5.00			○		
M 2,3	0.40	1.600		1.900	45.00	4.50			○		
M 2,5	0.45	1.800		2.050	50.00	5.00			●		
M 2,6	0.45	1.800		2.150	50.00	5.00			○		
M 3	0.50	2.200		2.500	56.00	6.00	●	○	●	●	●
M 3,5	0.60	2.500	2.10	2.900	56.00	7.00			○	○	○
M 4	0.70	2.800	2.10	3.300	63.00	7.50	●	●	●	●	●
M 5	0.80	3.500	2.70	4.200	70.00	8.50	●	●	●	●	●
M 6	1.00	4.500	3.40	5.000	80.00	11.00	●	●	●	●	●
M 7	1.00	5.500	4.30	6.000	80.00	11.00		○			●
M 8	1.25	6.000	4.90	6.800	90.00	14.00	●	●	●	●	●
M10	1.50	7.000	5.50	8.500	100.00	16.00	●	●	●	●	●
M12	1.75	9.000	7.00	10.200	110.00	18.50	●	●	●	●	●
M14	2.00	11.000	9.00	12.000	110.00	20.00	●	●	●	●	●
M16	2.00	12.000	9.00	14.000	110.00	20.00	●	●	●	●	●
M18	2.50	14.000	11.00	15.500	125.00	25.00	●	●	●	○	●
M20	2.50	16.000	12.00	17.500	140.00	25.00	●	●	●	●	●
M22	2.50	18.000	14.50	19.500	140.00	27.00	●	●	●		●
M24	3.00	18.000	14.50	21.000	160.00	30.00	●	●	●	●	●
M27	3.00	20.000	16.00	24.000	160.00	30.00		●	○		●
M30	3.50	22.000	18.00	26.500	180.00	35.00	●	●	●	●	●
M36	4.00	28.000	22.00	32.000	200.00	40.00			●		
M42	4.50	32.000	24.00	37.500	200.00	45.00			●		
M48	5.00	36.000	29.00	43.000	250.00	50.00			●		

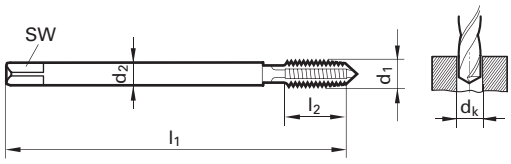
○ bright ● steam tempered ◒ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

823	824	826	848	890	917	949	950	1917	2426	2441
DIN 2184-1										
DIN 376										
HSS-E										
○	○	●	○	○	S	●	●	C	A+M	S
H R40	Al R45	N R40	N R40	N R40	N R40	N R15	H R40	H R40	N R40	N R40
C	C	C	C	C	C	C	C	C	C	C
ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 3 / 6G	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	6HX
right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand
103	103	103	103	103	103	103	103	103	103	103
793	800	799	787	799	787	787	793	793	799	799

Availability										
● ○	●	●	●	● ○	● ●	○ ○	● ○	●	○	●
● ● ●	● ● ●	● ● ●	● ● ●	● ● ●	● ● ●	● ○ ○	● ● ●	○ ● ●	○ ● ●	● ● ●
● ●	● ●	● ●	● ● ●	● ● ●	● ● ●	● ○	● ●	● ●	○ ○	● ●
● ● ●	● ● ●	● ● ●	● ● ●	● ● ●	● ● ●	● ● ●	● ● ●	● ● ●	● ○ ●	● ● ●
● ● ●	● ○	● ● ●	● ● ○	● ● ●	● ● ●	●	●	● ●		●
●	○	● ● ● ●	●	●	● ● ●		○ ●	●		●

C TiCN Cb Carbo D Cristall F FIRE/nanoFIRE P AlCrN S TiN S+ TiN+ M MolyGlide Y Signum

Guhring no.	315	734	813
Standard	DIN 2184-1		
Standard	DIN 376		
Tool material	HSS-E		
Surface	(S)	●	○
Type	N	H	N
Form	B	B	D
Tolerance	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H
Cutting direction	right-hand	right-hand	right-hand
Discount group	103	103	103
Techn. data page	798	790	786



d1	P	d2	SW	dk	l1	l2	315	734	813
	mm	mm		mm	mm	mm	Availability		
M 1,6	0.35	1.200		1.250	40.00	8.00			
M 1,8	0.35	1.200		1.450	40.00	8.00			
M 2	0.40	1.400		1.600	45.00	8.00			○
M 2,2	0.45	1.600		1.750	45.00	9.00			
M 2,3	0.40	1.600		1.900	45.00	9.00			
M 2,5	0.45	1.800		2.050	50.00	9.00			●
M 2,6	0.45	1.800		2.150	50.00	9.00			○
M 3	0.50	2.200		2.500	56.00	10.00	●	○	○
M 3,5	0.60	2.500	2.10	2.900	56.00	12.00			
M 4	0.70	2.800	2.10	3.300	63.00	12.00	●	●	●
M 5	0.80	3.500	2.70	4.200	70.00	14.00	●	●	●
M 6	1.00	4.500	3.40	5.000	80.00	16.00	●	●	●
M 7	1.00	5.500	4.30	6.000	80.00	16.00			
M 8	1.25	6.000	4.90	6.800	90.00	17.00	●	●	●
M10	1.50	7.000	5.50	8.500	100.00	20.00	●	○	●
M12	1.75	9.000	7.00	10.200	110.00	24.00	●	●	●
M14	2.00	11.000	9.00	12.000	110.00	26.00	●	●	○
M16	2.00	12.000	9.00	14.000	110.00	26.00	●	●	○
M18	2.50	14.000	11.00	15.500	125.00	30.00	●	○	○
M20	2.50	16.000	12.00	17.500	140.00	32.00	●	●	○
M22	2.50	18.000	14.50	19.500	140.00	32.00			○
M24	3.00	18.000	14.50	21.000	160.00	36.00	●	○	
M27	3.00	20.000	16.00	24.000	160.00	36.00			○
M30	3.50	22.000	18.00	26.500	180.00	40.00			
M33	3.50	25.000	20.00	29.500	180.00	40.00			
M36	4.00	28.000	22.00	32.000	200.00	50.00			
M39	4.00	32.000	24.00	35.000	200.00	50.00			
M42	4.50	32.000	24.00	37.500	200.00	56.00			
M45	4.50	36.000	29.00	40.500	220.00	58.00			
M48	5.00	36.000	29.00	43.000	250.00	65.00			
M52	5.00	40.000	32.00	47.000	250.00	65.00			

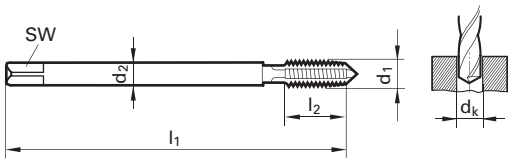
○ bright ● steam tempered ◓ nitrided lands ● nitrided ● golden brown (A) TiAlN (a) TiAlN nanoA (A) TiAlN SuperA

815	816	819	820	845	847	915
DIN 2184-1						
DIN 376						
HSS-E						
○	○	●	○	○	○	S
N	H	GG	N L15	N	N	N
B	B	C	D	B	B	B
ISO 2 / 6H	ISO 2 / 6H	6HX	ISO 2 / 6H	ISO 3 / 6G	ISO 2 / 6H	ISO 2 / 6H
right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand
103	103	103	103	103	103	103
786	790	802	787	786	786	786

Availability						
●						○
●				○		●
				○		○
●						○
●						●
●						○
●	●	○	●	●	○	○
●						●
●	●	●	○	●	○	●
●	●	●	○	●	○	●
●	●	●	○	●	○	●
●						○
●	●	●	●	●	●	●
●	●	●	○	●	○	●
●	●	●	●	●		●
●	●	●	○	○		●
●	●	●	○	●		●
●	●	●		○		●
●	●	●	○	●		●
●		○	○			●
●	●	●				●
●		○				●
●		●				●
●						●
●						●
						○
						●
				●		
●						●
						●

C TiCN Cb Carbo D Cristall F FIRE/nanoFIRE P AlCrN S TiN S+ TiN+ M MolyGlide Y Signum

Guhring no.	931	948	1872
Standard	DIN 2184-1		
Standard	DIN 376		
Tool material	HSS-E		
Surface	S	●	○
Type	GG	N	VA
Form	C	B	B
Tolerance	6HX	ISO 2 / 6H	ISO 2 / 6H
Cutting direction	right-hand	right-hand	right-hand
Discount group	103	103	103
Techn. data page	802	786	796



d1	P	d2	SW	dk	l1	l2	Availability		
	mm	mm		mm	mm	mm			
M 2,5	0.45	1.800		2.050	50.00	9.00		●	
M 2,6	0.45	1.800		2.150	50.00	9.00		●	
M 3	0.50	2.200		2.500	56.00	10.00	❍	❍	●
M 3,5	0.60	2.500	2.10	2.900	56.00	12.00		●	
M 4	0.70	2.800	2.10	3.300	63.00	12.00	●	●	●
M 5	0.80	3.500	2.70	4.200	70.00	14.00	●	●	●
M 6	1.00	4.500	3.40	5.000	80.00	16.00	●	●	●
M 8	1.25	6.000	4.90	6.800	90.00	17.00	●	●	●
M10	1.50	7.000	5.50	8.500	100.00	20.00	●	●	●
M12	1.75	9.000	7.00	10.200	110.00	24.00	●	●	●
M14	2.00	11.000	9.00	12.000	110.00	26.00	●	●	●
M16	2.00	12.000	9.00	14.000	110.00	26.00	●	●	●
M18	2.50	14.000	11.00	15.500	125.00	30.00	●	●	●
M20	2.50	16.000	12.00	17.500	140.00	32.00	●	●	●
M22	2.50	18.000	14.50	19.500	140.00	32.00		❍	
M24	3.00	18.000	14.50	21.000	160.00	36.00	●	●	●
M27	3.00	20.000	16.00	24.000	160.00	36.00			
M30	3.50	22.000	18.00	26.500	180.00	40.00		●	●
M36	4.00	28.000	22.00	32.000	200.00	50.00		●	

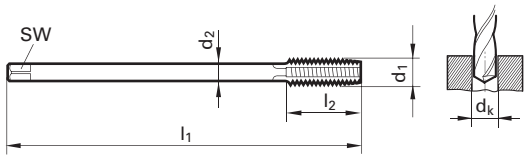
○ bright ● steam tempered ◓ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

1915	1919	2087	2428	2877	2942
DIN 2184-1					
DIN 376					
HSS-E					
C	A	S	A + M	○	●
H	GG	VA	N	N	H
B	C	B	B	B	B
ISO 2 / 6H	6HX	6HX	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H
right-hand	right-hand	right-hand	right-hand	right-hand	right-hand
103	103	103	103	103	103
791	802	796	798	798	791

Availability					
○	○	●	○	●	○
○	○	●	○	●	○
●	●	●	○	●	●
●	●	●	○	●	●
●	●	●	○	●	●
●	●	●	●	●	●
●	●	●	○	●	●
●	●	●	●	●	●
○	●	○		●	○
●	●	●		●	●
				●	
●		●		●	●
				●	
		○		●	
				●	

C TiCN Cb Carbo D Cristall F FIRE/nanoFIRE P AlCrN S TiN S+ TiN+ M MolyGlide Y Signum

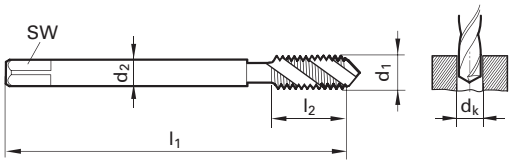
Guhring no.	998
Standard	
Standard	Guhring std.
Tool material	HSS-E
Surface	○
Type	N
Form	B
Tolerance	ISO 2 / 6H
Cutting direction	right-hand
Discount group	103
Techn. data page	789



d1	P	d2	SW	dk	l1	l2	Availability
	mm	mm		mm	mm	mm	
M 3	0.50	2.200		2.500	70.00	18.00	●
M 4	0.70	2.800	2.10	3.300	90.00	22.00	●
M 5	0.80	3.500	2.70	4.200	100.00	24.00	●
M 6	1.00	4.500	3.40	5.000	110.00	25.00	●
M 8	1.25	6.000	4.90	6.800	125.00	28.00	●
M10	1.50	7.000	5.50	8.500	140.00	30.00	●
M12	1.75	9.000	7.00	10.200	180.00	35.00	●
M14	2.00	11.000	9.00	12.000	200.00	35.00	●
M16	2.00	12.000	9.00	14.000	200.00	40.00	●
M20	2.50	16.000	12.00	17.500	250.00	45.00	●

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

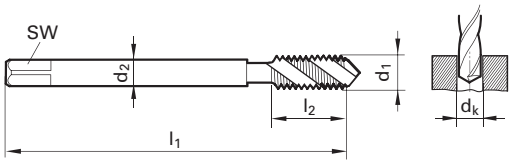
Guhring no.	**764**
Standard	**DIN 2184-1**
Standard	**DIN 374**
Tool material	**HSS-E-PM**
Surface	**S**
Type	**VA R50**
Form	**C**
Tolerance	**6HX**
Cutting direction	**right-hand**
Discount group	**103**
Techn. data page	**787**



d1 X P	d2	SW	dk	l1	l2	Code no.	Availability
	mm		mm	mm	mm		
M 8 X1	6.000	4.90	7.000	90.00	5.00	8.005	●
M10 X1	7.000	5.50	9.000	90.00	5.00	10.005	●
M12 X1	9.000	7.00	11.000	100.00	5.00	12.005	●
M12 X1,5	9.000	7.00	10.500	100.00	7.50	12.007	●
M14 X1,5	11.000	9.00	12.500	100.00	7.50	14.007	●
M16 X1,5	12.000	9.00	14.500	100.00	7.50	16.007	●
M18 X1,5	14.000	11.00	16.500	110.00	7.50	18.007	❍
M20 X1,5	16.000	12.00	18.500	125.00	7.50	20.007	●

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

Guhring no.	273	829	830	833	834
Standard	DIN 2184-1				
Standard	DIN 374				
Tool material	HSS-E				
Surface	S	○	○	○	○
Type	N R40	N	N	N R15	N R40
Form	C(K)	C	C	C	C
Tolerance	ISO 2 / 6H	ISO 3 / 6G	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H
Cutting direction	right-hand	right-hand	right-hand	right-hand	right-hand
Discount group	103	103	103	103	103
Techn. data page	799	786	786	787	787



d1 X P	d2	SW	dk	l1	l2	Code no.	273	829	830	833	834
	mm		mm	mm	mm		Availability				
M 3 X0,35	2.200		2.650	56.00	4.00	3.002			●		❍
M 3,5X0,35	2.500	2.10	3.150	56.00	4.00	3.502			●		
M 4 X0,5	2.800	2.10	3.500	63.00	5.00	4.003			●		●
M 5 X0,5	3.500	2.70	4.500	70.00	5.00	5.003			●	❍	●
M 6 X0,5	4.500	3.40	5.500	80.00	5.00	6.003			●		●
M 6 X0,75	4.500	3.40	5.200	80.00	8.00	6.004	❍	●	●	●	●
M 7 X0,75	5.500	4.30	6.200	80.00	8.00	7.004			●		
M 8 X0,5	6.000	4.90	7.500	80.00	8.00	8.003			●		
M 8 X0,75	6.000	4.90	7.200	80.00	8.00	8.004			●	●	●
M 8 X1	6.000	4.90	7.000	90.00	11.00	8.005	●	●	●	●	●
M 9 X1	7.000	5.50	8.000	90.00	11.00	9.005			●		
M10 X0,75	7.000	5.50	9.200	90.00	11.00	10.004			●		
M10 X1	7.000	5.50	9.000	90.00	11.00	10.005	●	●	●	●	●
M10 X1,25	7.000	5.50	8.800	100.00	14.00	10.006	●	●	●	●	●
M11 X1	8.000	6.20	10.000	90.00	11.00	11.005			●		
M12 X1	9.000	7.00	11.000	100.00	11.00	12.005	●		●	●	●
M12 X1,25	9.000	7.00	10.800	100.00	16.00	12.006	●	●	●	●	●
M12 X1,5	9.000	7.00	10.500	100.00	16.00	12.007	●	●	●	●	●
M14 X1	11.000	9.00	13.000	100.00	11.00	14.005			●	●	●
M14 X1,25	11.000	9.00	12.800	100.00	15.00	14.006			❍	●	●
M14 X1,5	11.000	9.00	12.500	100.00	15.00	14.007	●	●	●	●	●
M15 X1	12.000	9.00	14.000	100.00	11.00	15.005			●		
M16 X1	12.000	9.00	15.000	100.00	11.00	16.005			●	❍	●
M16 X1,5	12.000	9.00	14.500	100.00	15.00	16.007	●	●	●	●	●
M18 X1	14.000	11.00	17.000	110.00	12.00	18.005			●		●
M18 X1,5	14.000	11.00	16.500	110.00	16.00	18.007	●	●	●	●	●
M18 X2	14.000	11.00	16.000	125.00	20.00	18.008			●		
M20 X1	16.000	12.00	19.000	125.00	12.00	20.005			●	●	
M20 X1,5	16.000	12.00	18.500	125.00	16.00	20.007	●	❍	●	●	●
M20 X2	16.000	12.00	18.000	140.00	20.00	20.008			●		
M22 X1	18.000	14.50	21.000	125.00	12.00	22.005			●		
M22 X1,5	18.000	14.50	20.500	125.00	16.00	22.007	●	●	●	●	●
M22 X2	18.000	14.50	20.000	140.00	22.00	22.008			●		
M24 X1,5	18.000	14.50	22.500	140.00	16.00	24.007	●		●	●	●
M24 X2	18.000	14.50	22.000	140.00	22.00	24.008			●	●	●
M25 X1,5	18.000	14.50	23.500	140.00	20.00	25.007		●			

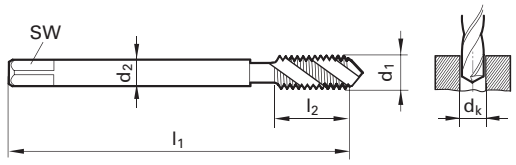
○ bright ◐ steam tempered ◒ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

835	852	1049	1874	1971	2424	2792	2838	2843	2852	2853
DIN 2184-1										
DIN 374										
HSS-E										
○	S	S	●	S	○	○	●	●	●	●
H R40	N R40	N R40	VA R15	N R15	N R40	N R40	N R15	N R40	H R40	N R40
C	C	C	C	C	C	E	C	C	C	C
ISO 2 / 6H	ISO 2 / 6H	ISO 3 / 6G	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H
right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand
103	103	103	103	103	103	103	103	103	103	103
793	787	799	797	787	799	799	787	787	793	799

Availability										
	● ● ●		● ● ●	○ ● ●			● ● ○			
	● ● ●		● ● ●	● ● ●				○ ○ ○	○	● ● ●
● ●	● ● ●			○ ● ●	● ● ●		○ ○ ○	● ● ●	● ● ●	
● ● ●	● ● ●	● ● ●	● ● ●	● ● ●	● ● ●	● ● ●	● ● ●	● ● ●	● ● ●	● ● ●
● ● ●	● ● ●	● ● ●	● ● ●	● ● ●	● ● ●	● ○ ○	● ● ●	● ● ●	● ● ●	● ● ●
● ○ ●	● ○ ●	● ● ●	● ● ●	● ● ●	○ ○ ●	○ ● ●	○ ○ ●	● ● ●	● ● ●	● ● ●
● ●	● ● ●	● ●	● ●	● ● ●	● ● ●		○ ●	● ● ●	● ●	● ● ●
● ●	● ● ●	● ●	● ○	● ● ●	● ○			○ ● ●	● ●	● ● ●
● ●	● ● ●	● ●	○ ● ●	○ ● ●	● ●		● ●	● ● ●	● ●	● ● ●
● ●	● ●			● ●	○ ●		○ ●	○ ●	● ●	● ●
● ●	● ● ●			● ● ○	● ● ○		● ●	● ●	● ●	● ●

C TiCN | Cb Carbo | D Cristall | F FIRE/nanoFIRE | P AlCrN | S TiN | S+ TiN+ | M MolyGlide | Y Signum

Guhring no.	273	829	830	833	834
Standard	DIN 2184-1				
Standard	DIN 374				
Tool material	HSS-E				
Surface	S	○	○	○	○
Type	N R40	N	N	N R15	N R40
Form	C(K)	C	C	C	C
Tolerance	ISO 2 / 6H	ISO 3 / 6G	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H
Cutting direction	right-hand	right-hand	right-hand	right-hand	right-hand
Discount group	103	103	103	103	103
Techn. data page	799	786	786	787	787



d1 X P	d2	SW	dk	l1	l2	Code no.	Availability				
	mm		mm	mm	mm						
M26 X1,5	18.000	14.50	24.500	140.00	20.00	26.007			●		●
M27 X1,5	20.000	16.00	25.500	140.00	20.00	27.007					●
M27 X2	20.000	16.00	25.000	140.00	28.00	27.008			●		●
M28 X1,5	20.000	16.00	26.500	140.00	20.00	28.007			❍		●
M30 X1,5	22.000	18.00	28.500	150.00	20.00	30.007			●	●	●
M30 X2	22.000	18.00	28.000	150.00	20.00	30.008			●	●	●
M32 X1,5	22.000	18.00	30.500	150.00	25.00	32.007		❍	●		
M35 X1,5	28.000	22.00	33.500	170.00	25.00	35.007			●		
M36 X1,5	28.000	22.00	34.500	170.00	25.00	36.007			●		
M38 X1,5	28.000	22.00	36.500	170.00	25.00	38.007			●		
M40 X1,5	32.000	24.00	38.500	170.00	25.00	40.007		●			
M50 X1,5	36.000	29.00	48.500	190.00	27.00	50.007		●			
M63 X1,5	50.000	39.00	61.500	275.00	25.00	63.007		●			

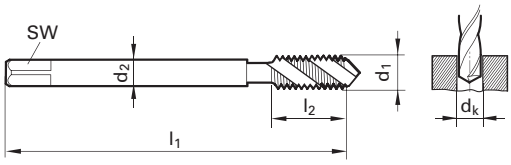
○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

835	852	1049	1874	1971	2424	2792	2838	2843	2852	2853
DIN 2184-1										
DIN 374										
HSS-E										
○	S	S	●	S	○	○	●	●	●	●
H R40	N R40	N R40	VA R15	N R15	N R40	N R40	N R15	N R40	H R40	N R40
C	C	C	C	C	C	E	C	C	C	C
ISO 2 / 6H	ISO 2 / 6H	ISO 3 / 6G	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H
right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand
103	103	103	103	103	103	103	103	103	103	103
793	787	799	797	797	799	799	787	787	793	799

Availability										
				●				●		●●●
				●			○●	●		●●●

C TiCN Cb Carbo D Cristall F FIRE/nanoFIRE P AlCrN S TiN S+ TiN+ M MolyGlide Y Signum

Guhring no.	2864	2897	2940	2987	2988
Standard	DIN 2184-1				
Standard	DIN 374				
Tool material	HSS-E				
Surface	●	S	●	○	●
Type	VA R40	VA R15	H R40	H R40	H R40
Form	C	C	C	C	C
Tolerance	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 3 / 6G	ISO 3 / 6G
Cutting direction	right-hand	right-hand	right-hand	right-hand	right-hand
Discount group	103	103	103	103	103
Techn. data page	797	797	793	793	793



d1 X P	d2	SW	dk	l1	l2	Code no.	Availability				
	mm		mm	mm	mm						
M 3 X0,35	2.200		2.650	56.00	4.00	3.002	●				
M 4 X0,5	2.800	2.10	3.500	63.00	5.00	4.003	●	●			
M 5 X0,5	3.500	2.70	4.500	70.00	5.00	5.003	●	●			
M 6 X0,5	4.500	3.40	5.500	80.00	5.00	6.003	●	●			
M 6 X0,75	4.500	3.40	5.200	80.00	8.00	6.004	●	●	●		
M 8 X0,5	6.000	4.90	7.500	80.00	8.00	8.003	●				
M 8 X0,75	6.000	4.90	7.200	80.00	8.00	8.004	●		❍		
M 8 X1	6.000	4.90	7.000	90.00	11.00	8.005	●	❍	❍	●	●
M10 X1	7.000	5.50	9.000	90.00	11.00	10.005	●	●	●		
M10 X1,25	7.000	5.50	8.800	100.00	14.00	10.006					
M12 X1	9.000	7.00	11.000	100.00	11.00	12.005	●	●			
M12 X1,25	9.000	7.00	10.800	100.00	16.00	12.006					
M12 X1,5	9.000	7.00	10.500	100.00	16.00	12.007	●	❍	❍		
M14 X1,25	11.000	9.00	12.800	100.00	15.00	14.006					
M14 X1,5	11.000	9.00	12.500	100.00	15.00	14.007	●	●	●		●
M16 X1,5	12.000	9.00	14.500	100.00	15.00	16.007	●	❍		❍	❍
M18 X1,5	14.000	11.00	16.500	110.00	16.00	18.007	●	●			❍
M20 X1,5	16.000	12.00	18.500	125.00	16.00	20.007	●		●	❍	❍
M20 X2	16.000	12.00	18.000	140.00	20.00	20.008		●			
M22 X1,5	18.000	14.50	20.500	125.00	16.00	22.007	●	●			
M24 X1,5	18.000	14.50	22.500	140.00	16.00	24.007	●	❍			
M24 X2	18.000	14.50	22.000	140.00	22.00	24.008					

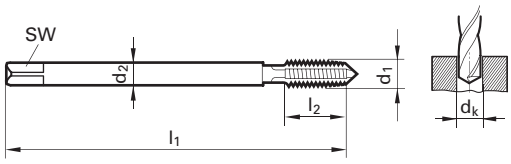
○ bright ● steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

2989	2998	2999	4156	4157	874	936	1004	1100	1292
DIN 2184-1									
DIN 374									
HSS-E					HSS-E-PM				
S	○	●	C	C	○	○	S	S	S
H R40	N R40	N R40	N R15	N R15	H R15	VA R40	VA R40	N R50	N R40
C	C	C	C	E	C	C	C	C	C
ISO 3 / 6G	ISO 3 / 6G	ISO 3 / 6G	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H
right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand
103	103	103	103	103	103	103	103	103	103
793	799	799	799	799	792	797	797	799	799
			NEW	NEW			NEW		

Availability									
●	●	●	●	●	●	●		●	●
●	●		●	●					●
○	●		●	●		○		○	●
									●
●			●	●	●	●	●	●	●
●	○	●	●	●	●	●	●	●	●
●	●	○	●	●	●	●	●	●	●
●		○				●	○	○	●
○	●					●	○	○	●
									●
									○
									●

C TiCN | Cb Carbo | D Cristall | F FIRE/nanoFIRE | P AlCrN | S TiN | S+ TiN+ | M MolyGlide | Y Signum

Guhring no.	169	316	828	831	1873
Standard	DIN 2184-1				
Standard	DIN 374				
Tool material	HSS-E				
Surface	A	○	○	●	○
Type	GG	N	H	GG	VA
Form	C	B	B	C	B
Tolerance	6HX	ISO 3 / 6G	ISO 2 / 6H	6HX	ISO 2 / 6H
Cutting direction	right-hand	right-hand	right-hand	right-hand	right-hand
Discount group	103	103	103	103	103
Techn. data page	802	786	790	802	796



d1 X P	d2	SW	dk	l1	l2	Code no.	Availability				
	mm		mm	mm	mm						
M 3 X0,35	2.200		2.650	56.00	7.00	3.002	◐		●	●	
M 4 X0,5	2.800	2.10	3.500	63.00	8.00	4.003	◐		●	◐	
M 5 X0,5	3.500	2.70	4.500	70.00	10.00	5.003	◐		●	◐	
M 6 X0,5	4.500	3.40	5.500	80.00	13.00	6.003			●		
M 6 X0,75	4.500	3.40	5.200	80.00	13.00	6.004	◐	●	●	◐	●
M 7 X0,75	5.500	4.30	6.200	80.00	13.00	7.004					◐
M 8 X0,75	6.000	4.90	7.200	80.00	14.00	8.004			●	◐	
M 8 X1	6.000	4.90	7.000	90.00	17.00	8.005	◐	●	●	●	●
M 9 X1	7.000	5.50	8.000	90.00	17.00	9.005				◐	
M10 X1	7.000	5.50	9.000	90.00	17.00	10.005	●	●	●	●	●
M12 X1	9.000	7.00	11.000	100.00	20.00	12.005			●	●	●
M12 X1,5	9.000	7.00	10.500	100.00	20.00	12.007	●	●	●	●	●
M14 X1,5	11.000	9.00	12.500	100.00	20.00	14.007	●		●	●	●
M16 X1,5	12.000	9.00	14.500	100.00	22.00	16.007	●	●	●	●	●
M18 X1	14.000	11.00	17.000	110.00	25.00	18.005					●
M18 X1,5	14.000	11.00	16.500	110.00	25.00	18.007	●		●	●	●
M20 X1,5	16.000	12.00	18.500	125.00	25.00	20.007	●	●	●	●	
M22 X1,5	18.000	14.50	20.500	125.00	25.00	22.007	●		◐	●	
M24 X1,5	18.000	14.50	22.500	140.00	28.00	24.007	◐			●	◐
M24 X2	18.000	14.50	22.000	140.00	28.00	24.008					◐
M26 X1,5	18.000	14.50	24.500	140.00	28.00	26.007					
M27 X1,5	20.000	16.00	25.500	140.00	28.00	27.007				●	
M27 X2	20.000	16.00	25.000	140.00	28.00	27.008					
M28 X1,5	20.000	16.00	26.500	140.00	28.00	28.007					
M30 X1,5	22.000	18.00	28.500	150.00	28.00	30.007			◐	●	
M30 X2	22.000	18.00	28.000	150.00	28.00	30.008					
M32 X1,5	22.000	18.00	30.500	150.00	28.00	32.007					
M36 X1,5	28.000	22.00	34.500	170.00	30.00	36.007					
M40 X1,5	32.000	24.00	38.500	170.00	30.00	40.007					
M42 X1,5	32.000	24.00	40.500	170.00	30.00	42.007					
M45 X1,5	36.000	29.00	43.500	180.00	32.00	45.007					
M48 X1,5	36.000	29.00	46.500	190.00	32.00	48.007					
M50 X1,5	36.000	29.00	48.500	190.00	32.00	50.007					

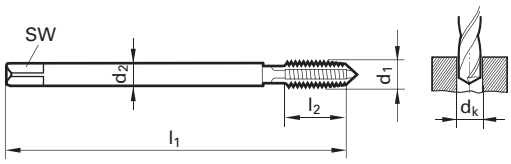
○ bright ◐ steam tempered ◒ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

2871	2878	2879	2943	2982	2983	2992	2993	887	1001
DIN 2184-1									
DIN 374									
HSS-E									HSS-E-PM
○	A+M	○	●	○	S	○	S	○	S
VA	N	N	H	H	H	N	N	VA	VA
B	B	B	B	B	B	B	B	B	B
ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 3 / 6G	ISO 3 / 6G	ISO 3 / 6G	ISO 3 / 6G	ISO 2 / 6H	ISO 2 / 6H
right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand
103	103	103	103	103	103	103	103	103	103
796	798	798	791	790	791	798	798	796	796
									NEW

Availability									
● ● ●		● ●	○ ● ●						● ●
●	○	●	○						●
● ●	○	● ●	 ○	 ○	●	●	●	 ○	● ●
● ● ●	○	● ● ●	● ●	 ○	● ●	● ○	● ●	● ●	● ● ●
● ●	○ ○	● ●	● ●		● ●	 ○	● ●	○	● ●
 ● ●	○ ○ ○	● ● ○	 ●	○ ●	○ ●	○	●		● ●
●	○	● ● ●							
		● ● ○							
		● ● ●							
		● ● ●							
		● ● ●							

C TiCN Cb Carbo D Cristall F FIRE/nanoFIRE P AlCrN S TiN S+ TiN+ M MolyGlide Y Signum

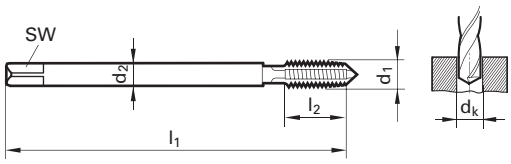
Guhring no.	**944**
Standard	**DIN 2184-1**
Standard	**DIN 374**
Tool material	**Solid carbide**
Surface	C
Type	**N**
Form	**B**
Tolerance	**6HX**
Cutting direction	**right-hand**
Discount group	**103**
Techn. data page	**798**



d1 X P	d2	SW	dk	l1	l2	Code no.	Availability
	mm		mm	mm	mm		
M14 X1,25	11.000	9.00	12.800	100.00	19.00	14.006	❍
M14 X1,5	11.000	9.00	12.500	100.00	22.00	14.007	●
M16 X1	12.000	9.00	15.000	100.00	15.00	16.005	❍
M16 X1,5	12.000	9.00	14.500	100.00	22.00	16.007	●

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

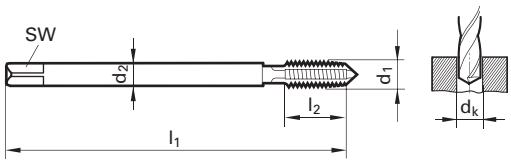
Guhring no.	827	832	932
Standard	DIN 2184-1		
Standard	DIN 374		
Tool material	HSS-E		
Surface	○	S	S
Type	N	N	GG
Form	B	B	C
Tolerance	ISO 2 / 6H	ISO 2 / 6H	6HX
Cutting direction	right-hand	right-hand	right-hand
Discount group	103	103	103
Techn. data page	786	786	802



d1 X P	d2	SW	dk	l1	l2	Code no.	827	832	932
	mm		mm	mm	mm		Availability		
M 3 X0,35	2.200		2.650	56.00	7.00	3.002	❍	❍	❍
M 3,5X0,35	2.500	2.10	3.150	56.00	8.00	3.502	❍	●	
M 4 X0,5	2.800	2.10	3.500	63.00	8.00	4.003	●	●	❍
M 5 X0,5	3.500	2.70	4.500	70.00	10.00	5.003	●	●	●
M 6 X0,5	4.500	3.40	5.500	80.00	13.00	6.003	●	●	
M 6 X0,75	4.500	3.40	5.200	80.00	13.00	6.004	●	●	●
M 7 X0,75	5.500	4.30	6.200	80.00	13.00	7.004	●	●	
M 8 X0,5	6.000	4.90	7.500	80.00	14.00	8.003	●	●	
M 8 X0,75	6.000	4.90	7.200	80.00	14.00	8.004	●	❍	
M 8 X1	6.000	4.90	7.000	90.00	17.00	8.005	●	●	●
M 9 X1	7.000	5.50	8.000	90.00	17.00	9.005	●	●	
M10 X0,75	7.000	5.50	9.200	90.00	17.00	10.004	●	●	
M10 X1	7.000	5.50	9.000	90.00	17.00	10.005	●	●	●
M10 X1,25	7.000	5.50	8.800	100.00	20.00	10.006	●	●	●
M11 X1	8.000	6.20	10.000	90.00	20.00	11.005	●	●	
M12 X1	9.000	7.00	11.000	100.00	20.00	12.005	●	●	●
M12 X1,25	9.000	7.00	10.800	100.00	20.00	12.006	●	●	●
M12 X1,5	9.000	7.00	10.500	100.00	20.00	12.007	●	●	●
M14 X1	11.000	9.00	13.000	100.00	20.00	14.005	●	●	
M14 X1,25	11.000	9.00	12.800	100.00	20.00	14.006	●	❍	●
M14 X1,5	11.000	9.00	12.500	100.00	20.00	14.007	●	●	●
M15 X1	12.000	9.00	14.000	100.00	20.00	15.005	●	❍	
M15 X1,5	12.000	9.00	13.500	100.00	20.00	15.007	●	●	
M16 X1	12.000	9.00	15.000	100.00	22.00	16.005	●	❍	
M16 X1,5	12.000	9.00	14.500	100.00	22.00	16.007	●	●	●
M18 X1	14.000	11.00	17.000	110.00	25.00	18.005	●	❍	
M18 X1,5	14.000	11.00	16.500	110.00	25.00	18.007	●	●	●
M18 X2	14.000	11.00	16.000	125.00	30.00	18.008	●	❍	
M20 X1	16.000	12.00	19.000	125.00	25.00	20.005	●	●	
M20 X1,5	16.000	12.00	18.500	125.00	25.00	20.007	●	●	●
M20 X2	16.000	12.00	18.000	140.00	32.00	20.008	●	❍	
M22 X1	18.000	14.50	21.000	125.00	25.00	22.005		❍	
M22 X1,5	18.000	14.50	20.500	125.00	25.00	22.007	●	❍	●
M22 X2	18.000	14.50	20.000	140.00	32.00	22.008	●	❍	
M24 X1	18.000	14.50	23.000	140.00	28.00	24.005	●	●	
M24 X1,5	18.000	14.50	22.500	140.00	28.00	24.007	●	❍	

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

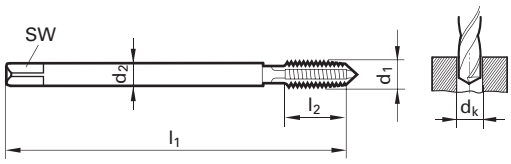
Guhring no.	827	832	932
Standard	DIN 2184-1		
Standard	DIN 374		
Tool material	HSS-E		
Surface	○	S	S
Type	N	N	GG
Form	B	B	C
Tolerance	ISO 2 / 6H	ISO 2 / 6H	6HX
Cutting direction	right-hand	right-hand	right-hand
Discount group	103	103	103
Techn. data page	786	786	802



d1 X P	d2	SW	dk	l1	l2	Code no.	Availability	
	mm		mm	mm	mm			
M24 X2	18.000	14.50	22.000	140.00	28.00	24.008	●	●
M26 X1,5	18.000	14.50	24.500	140.00	28.00	26.007	●	●
M27 X1,5	20.000	16.00	25.500	140.00	28.00	27.007	●	
M27 X2	20.000	16.00	25.000	140.00	28.00	27.008	●	●
M28 X1,5	20.000	16.00	26.500	140.00	28.00	28.007	●	●
M30 X1,5	22.000	18.00	28.500	150.00	28.00	30.007	●	●
M30 X2	22.000	18.00	28.000	150.00	28.00	30.008	●	●
M32 X1,5	22.000	18.00	30.500	150.00	28.00	32.007	●	◐
M33 X1,5	25.000	20.00	31.500	160.00	30.00	33.007	●	●
M35 X1,5	28.000	22.00	33.500	170.00	30.00	35.007	●	
M36 X1,5	28.000	22.00	34.500	170.00	30.00	36.007	●	●
M38 X1,5	28.000	22.00	36.500	170.00	30.00	38.007	●	
M40 X1,5	32.000	24.00	38.500	170.00	30.00	40.007	●	
M45 X1,5	36.000	29.00	43.500	180.00	32.00	45.007	●	

○ bright ◐ steam tempered ◒ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

Guhring no.	2888	1291
Standard	DIN 2184-1	
Standard	DIN 374	
Tool material	HSS-E	HSS-E-PM
Surface	●	S
Type	N	N
Form	B	B
Tolerance	ISO 2 / 6H	ISO 2 / 6H
Cutting direction	right-hand	right-hand
Discount group	103	103
Techn. data page	786	798



d1 X P	d2	SW	dk	l1	l2	Code no.	Availability	
	mm		mm	mm	mm			
M 3 X0,35	2.200		2.650	56.00	7.00	3.002	●	
M 4 X0,5	2.800	2.10	3.500	63.00	8.00	4.003	○	
M 5 X0,5	3.500	2.70	4.500	70.00	10.00	5.003	●	
M 6 X0,5	4.500	3.40	5.500	80.00	13.00	6.003	●	
M 6 X0,75	4.500	3.40	5.200	80.00	13.00	6.004	●	
M 8 X0,5	6.000	4.90	7.500	80.00	14.00	8.003	●	
M 8 X0,75	6.000	4.90	7.200	80.00	14.00	8.004	●	
M 8 X1	6.000	4.90	7.000	90.00	17.00	8.005	●	●
M10 X0,75	7.000	5.50	9.200	90.00	17.00	10.004	●	
M10 X1	7.000	5.50	9.000	90.00	17.00	10.005	●	●
M10 X1,25	7.000	5.50	8.800	100.00	20.00	10.006	●	●
M12 X1	9.000	7.00	11.000	100.00	20.00	12.005	●	●
M12 X1,25	9.000	7.00	10.800	100.00	20.00	12.006	●	●
M12 X1,5	9.000	7.00	10.500	100.00	20.00	12.007	●	●
M14 X1	11.000	9.00	13.000	100.00	20.00	14.005	●	
M14 X1,25	11.000	9.00	12.800	100.00	20.00	14.006	○	○
M14 X1,5	11.000	9.00	12.500	100.00	20.00	14.007	●	●
M16 X1	12.000	9.00	15.000	100.00	22.00	16.005	●	
M16 X1,5	12.000	9.00	14.500	100.00	22.00	16.007	●	●
M18 X1	14.000	11.00	17.000	110.00	25.00	18.005	●	
M18 X1,5	14.000	11.00	16.500	110.00	25.00	18.007	●	●
M20 X1	16.000	12.00	19.000	125.00	25.00	20.005	●	
M20 X1,5	16.000	12.00	18.500	125.00	25.00	20.007	●	●
M20 X2	16.000	12.00	18.000	140.00	32.00	20.008	○	
M22 X1,5	18.000	14.50	20.500	125.00	25.00	22.007	○	○
M22 X2	18.000	14.50	20.000	140.00	32.00	22.008	●	
M24 X1,5	18.000	14.50	22.500	140.00	28.00	24.007	●	○
M24 X2	18.000	14.50	22.000	140.00	28.00	24.008	●	●
M27 X1,5	20.000	16.00	25.500	140.00	28.00	27.007	○	
M30 X1,5	22.000	18.00	28.500	150.00	28.00	30.007	●	
M30 X2	22.000	18.00	28.000	150.00	28.00	30.008	●	
M32 X1,5	22.000	18.00	30.500	150.00	28.00	32.007	○	

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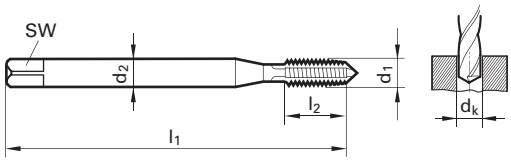
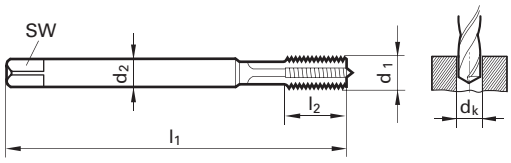
Guhring no.	943
Standard	DIN 2184-1
Standard	~ DIN 371
Tool material	Solid carbide
Surface	C
Type	N
Form	B
Tolerance	6HX
Cutting direction	right-hand
Discount group	103
Techn. data page	798



d1 X P	d2	SW	dk	l1	l2	Code no.	Availability
	mm		mm	mm	mm		
M 5 X0,5	6.000	4.90	4.500	70.00	7.50	5.003	●
M 6 X0,5	6.000	4.90	5.500	80.00	7.50	6.003	❍
M 6 X0,75	6.000	4.90	5.200	80.00	11.50	6.004	●
M 8 X1	8.000	6.20	7.000	90.00	15.00	8.005	●
M10 X1	10.000	8.00	9.000	90.00	15.00	10.005	●
M10 X1,25	10.000	8.00	8.800	100.00	19.00	10.006	●
M12 X1	12.000	9.00	11.000	100.00	15.00	12.005	❍
M12 X1,25	12.000	9.00	10.800	100.00	19.00	12.006	●
M12 X1,5	12.000	9.00	10.500	100.00	22.00	12.007	❍

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

Guhring no.	1058	1062	1066
Standard	DIN 2184-1		
Standard	DIN 371		
Tool material	HSS-E-PM		
Surface	C	C	A
Type	Ti	Ti R15	Ni R10
Form	B	C	C
Tolerance	4HX	4HX	4HX
Cutting direction	right-hand	right-hand	right-hand
Discount group	103	103	103
Techn. data page	805	805	805
	NEW	NEW	NEW



d1 X P	d2	SW	dk	l1	l2	Code no.	Availability		
	mm		mm	mm	mm				
MJ 6X0,5	6.000	4.90	5.500	80.00	11.00	6.003	●	●	●
MJ 6X0,75	6.000	4.90	5.200	80.00	11.00	6.004	●	●	●
MJ 8X0,5	8.000	6.20	7.500	80.00	14.00	8.003			●
MJ 8X0,75	8.000	6.20	7.200	80.00	14.00	8.004		●	●
MJ 8X1	8.000	6.20	7.000	90.00	14.00	8.005	●	❍	●
MJ10X1	10.000	8.00	9.000	90.00	16.00	10.005	●	●	●
MJ10X1,25	10.000	8.00	8.800	100.00	20.00	10.006	●	●	●

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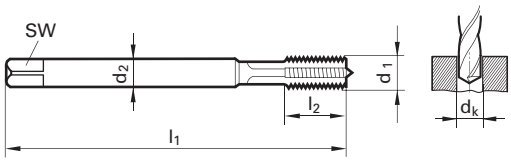
Guhring no.	2903	2910	2917	2921
Standard	DIN 2184-1			
Standard	DIN 371			
Tool material	HSS-E-PM			
Surface	C	C	A	A
Type	Ti	Ti R15	Ni	Ni R10
Form	B	C	B	C
Tolerance	6HX	6HX	6HX	6HX
Cutting direction	right-hand	right-hand	right-hand	right-hand
Discount group	103	103	103	103
Techn. data page	804	804	804	804
	NEW	NEW		

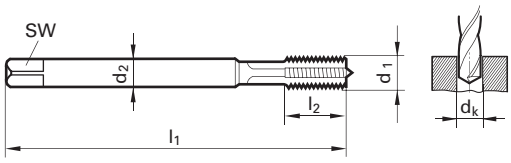


d1 X P	d2	SW	dk	l1	l2	Code no.	Availability			
	mm		mm	mm	mm					
M 3 X0,35	3.500	2.70	2.650	56.00	6.00	3.002	○	●	●	●
M 4 X0,5	4.500	3.40	3.500	63.00	7.50	4.003	●	●	●	○
M 5 X0,5	6.000	4.90	4.500	70.00	8.50	5.003	●	●		●
MJ 6X0,5	6.000	4.90	5.500	80.00	11.00	6.003	○	●	●	○
MJ 6X0,75	6.000	4.90	5.200	80.00	11.00	6.004	●	●	●	●
MJ 8X0,5	8.000	6.20	7.500	80.00	14.00	8.003			●	○
MJ 8X0,75	8.000	6.20	7.200	80.00	14.00	8.004	●	●	●	○
MJ 8X1	8.000	6.20	7.000	90.00	14.00	8.005	●	●	●	●
MJ10X1	10.000	8.00	9.000	90.00	16.00	10.005	○	●	●	●
MJ10X1,25	10.000	8.00	8.800	100.00	20.00	10.006			○	○

○ bright ○ steam tempered ◒ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

Guhring no.	**4161**
Standard	**DIN 2184-1**
Standard	**DIN 371**
Tool material	**HSS-E-PM**
Surface	C
Type	**H**
Form	**D**
Tolerance	**6HX**
Cutting direction	**right-hand**
Discount group	**103**
Techn. data page	**794**

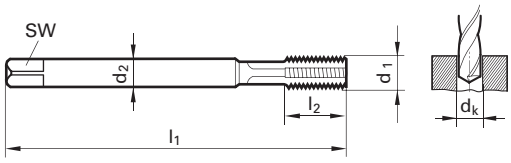
NEW



d1 X P	d2	SW	dk	l1	l2	Code no.	Availability
	mm		mm	mm	mm		
M 8 X1	8.000	6.20	7.000	90.00	17.00	8.005	●
M10 X1	10.000	8.00	9.000	90.00	17.00	10.005	●
M12 X1	12.000	9.00	11.000	100.00	20.00	12.005	●
M12 X1,50	12.000	9.00	10.500	100.00	20.00	12.007	●

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

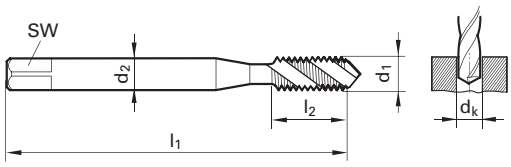
Guhring no.	1161
Standard	Guhring std.
Standard	~ DIN 371
Tool material	Solid carbide
Surface	C
Type	H
Form	D
Tolerance	ISO 2 / 6H
Cutting direction	right-hand
Discount group	103
Techn. data page	794



d1 X P	d2	SW	dk	l1	l2	Code no.	Availability
	mm		mm	mm	mm		
M 6 X0,5	6.000	4.90	5.600	80.00	15.00	6.003	●
M 8 X1	8.000	6.20	7.100	90.00	18.00	8.005	●
M10 X1	10.000	8.00	9.100	90.00	22.00	10.005	●
M12 X1	12.000	9.00	11.100	100.00	25.00	12.005	●
M12 X1,5	12.000	9.00	10.600	100.00	28.00	12.007	●

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

Guhring no.	876	1837	1977	1978	1981
Standard	DIN 2184-1				
Standard	~ DIN 371				
Tool material	HSS-E				
Surface	○	S	○	○	○
Type	N R40	N R40	N	N R15	VA R40
Form	C	C(K)	C	C	C
Tolerance	2B	2B	2B	2B	2B
Cutting direction	right-hand	right-hand	right-hand	right-hand	right-hand
Discount group	103	103	103	103	103
Techn. data page	787	799	786	787	797



d1 - P	d2	SW	dk	l1	l2	Code no.	Availability				
	mm		mm	mm	mm						
NR. 2 -56	2.800	2.10	1.850	45.00	5.00	2.184	●				●
NR. 3 -48	2.800	2.10	2.100	50.00	6.00	2.515			❍	❍	
NR. 4 -40	3.500	2.70	2.350	56.00	7.00	2.845	●		●	●	●
NR. 5 -40	3.500	2.70	2.650	56.00	7.00	3.175	●		❍	●	❍
NR. 6 -32	4.000	3.00	2.850	56.00	8.00	3.505	●		●		●
NR. 8 -32	4.500	3.40	3.500	63.00	8.00	4.166	●		❍	❍	●
NR.10 -24	6.000	4.90	3.900	70.00	11.00	4.826	●	●	❍		●
NR.12 -24	6.000	4.90	4.500	80.00	11.00	5.486		❍	❍	❍	❍
1/4 -20	7.000	5.50	5.100	80.00	13.00	6.350	●	●	●	●	●
5/16-18	8.000	6.20	6.600	90.00	14.00	7.938	●	●	❍	●	●
3/8 -16	10.000	8.00	8.000	100.00	16.00	9.525	●	●	❍	●	●

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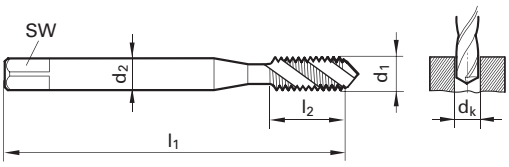
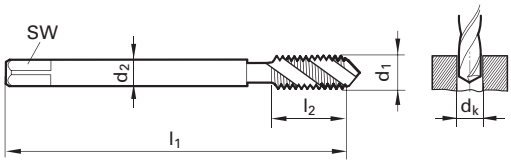
Guhring no.	2839	2844	2854	2855	2865
Standard	DIN 2184-1				
Standard	~ DIN 371				
Tool material	HSS-E				
Surface	steam tempered	steam tempered	bright	steam tempered	steam tempered
Type	N R15	N R40	N R40	N R40	VA R40
Form	C	C	C	C	C
Tolerance	2B	2B	2B	2B	2B
Cutting direction	right-hand	right-hand	right-hand	right-hand	right-hand
Discount group	103	103	103	103	103
Techn. data page	787	787	799	799	797



d1 - P	d2	SW	dk	l1	l2	Code no.	Availability				
	mm		mm	mm	mm						
NR. 2 -56	2.800	2.10	1.850	45.00	5.00	2.184		●		●	●
NR. 3 -48	2.800	2.10	2.100	50.00	6.00	2.515			●		
NR. 4 -40	3.500	2.70	2.350	56.00	7.00	2.845	●	●		●	●
NR. 5 -40	3.500	2.70	2.650	56.00	7.00	3.175		●			
NR. 6 -32	4.000	3.00	2.850	56.00	8.00	3.505	❍	❍		●	●
NR. 8 -32	4.500	3.40	3.500	63.00	8.00	4.166	●	●		●	●
NR.10 -24	6.000	4.90	3.900	70.00	11.00	4.826	❍	●	❍	●	●
NR.12 -24	6.000	4.90	4.500	80.00	11.00	5.486		❍			
1/4 -20	7.000	5.50	5.100	80.00	13.00	6.350		●	●	●	●
5/16-18	8.000	6.20	6.600	90.00	14.00	7.938		●	●	●	●
3/8 -16	10.000	8.00	8.000	100.00	16.00	9.525	●	●	●	●	●

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

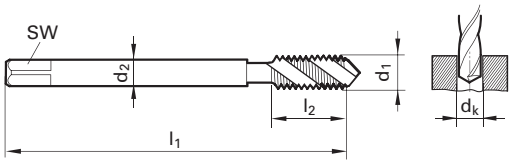
Guhring no.	881	1982	1983	1986	2840
Standard	DIN 2184-1				
Standard	~ DIN 376				
Tool material	HSS-E				
Surface	○	○	○	○	●
Type	N R40	N	N R15	VA R40	N R15
Form	C	C	C	C	C
Tolerance	2B	2B	2B	2B	2B
Cutting direction	right-hand	right-hand	right-hand	right-hand	right-hand
Discount group	103	103	103	103	103
Techn. data page	787	787	787	787	787



d1 - P	d2	SW	dk	l1	l2	Code no.	881	1982	1983	1986	2840
	mm		mm	mm	mm		Availability				
7/16-14	8.000	6.20	9.400	100.00	18.00	11.113	●	○	○	●	
1/2 -13	9.000	7.00	10.800	110.00	20.00	12.700	●	●	○	●	●
9/16-12	11.000	9.00	12.200	110.00	21.00	14.288	○	○	○	○	○
5/8 -11	12.000	9.00	13.500	110.00	24.00	15.875	●	○	●	●	
3/4 -10	14.000	11.00	16.500	125.00	25.00	19.050	●	●		●	
7/8 - 9	18.000	14.50	19.500	140.00	28.00	22.225	●	●	○	●	●
1 - 8	18.000	14.50	22.250	160.00	32.00	25.400	●	○			●

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

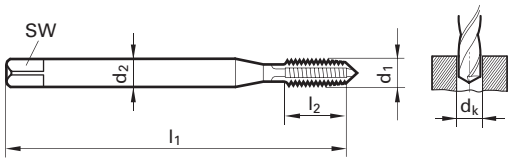
Guhring no.	2845	2856	2857	2866
Standard	DIN 2184-1			
Standard	~ DIN 376			
Tool material	HSS-E			
Surface	steam tempered	bright	steam tempered	steam tempered
Type	N R40	N R40	N R40	VA R40
Form	C	C	C	C
Tolerance	2B	2B	2B	2B
Cutting direction	right-hand	right-hand	right-hand	right-hand
Discount group	103	103	103	103
Techn. data page	787	799	799	797



d1 - P	d2	SW	dk	l1	l2	Code no.	2845	2856	2857	2866
	mm		mm	mm	mm		Availability			
7/16-14	8.000	6.20	9.400	100.00	18.00	11.113	●	●	●	●
1/2 -13	9.000	7.00	10.800	110.00	20.00	12.700	●	●	●	●
9/16-12	11.000	9.00	12.200	110.00	21.00	14.288	●	●	◐	
5/8 -11	12.000	9.00	13.500	110.00	24.00	15.875	●	●	●	●
3/4 -10	14.000	11.00	16.500	125.00	25.00	19.050	●	●	●	●
7/8 - 9	18.000	14.50	19.500	140.00	28.00	22.225	●	●	●	●
1 - 8	18.000	14.50	22.250	160.00	32.00	25.400	●	●		

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

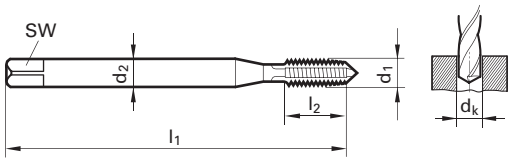
Guhring no.	873	1979	1980	2872	2880
Standard	DIN 2184-1				
Standard	~ DIN 371				
Tool material	HSS-E				
Surface	○	●	○	●	A+M
Type	N	GG	VA	VA	N
Form	B	C	B	B	B
Tolerance	2B	2B	2B	2B	2B
Cutting direction	right-hand	right-hand	right-hand	right-hand	right-hand
Discount group	103	103	103	103	103
Techn. data page	786	802	796	796	798



d1 - P	d2	SW	dk	l1	l2	Code no.	Availability				
	mm		mm	mm	mm						
NR. 1 -64	2.800	2.10	1.550	45.00	8.00	1.854	❍				
NR. 2 -56	2.800	2.10	1.850	45.00	9.00	2.184	●				
NR. 3 -48	2.800	2.10	2.100	50.00	9.00	2.515	●	❍			
NR. 4 -40	3.500	2.70	2.350	56.00	11.00	2.845	●		●	●	❍
NR. 5 -40	3.500	2.70	2.650	56.00	11.00	3.175	●	●		❍	
NR. 6 -32	4.000	3.00	2.850	56.00	12.00	3.505	●		●	●	●
NR. 8 -32	4.500	3.40	3.500	63.00	13.00	4.166	●	❍	●	●	❍
NR.10 -24	6.000	4.90	3.900	70.00	14.00	4.826	●	●	●	●	❍
NR.12 -24	6.000	4.90	4.500	80.00	16.00	5.486	●	❍	●		❍
1/4 -20	7.000	5.50	5.100	80.00	16.00	6.350	●	●	●	●	
5/16-18	8.000	6.20	6.600	90.00	18.00	7.938	●	●	●	●	
3/8 -16	10.000	8.00	8.000	100.00	20.00	9.525	●	●	●	●	

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

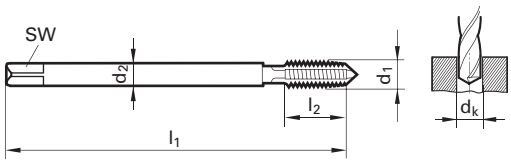
Guhring no.	2881	2889	2905	2918
Standard	DIN 2184-1			
Standard	~ DIN 371			
Tool material	HSS-E		HSS-E-PM	
Surface	●	●	C	A
Type	N	N	Ti	Ni
Form	B	B	B	B
Tolerance	2B	2B	2BX	2BX
Cutting direction	right-hand	right-hand	right-hand	right-hand
Discount group	103	103	103	103
Techn. data page	798	786	804	804



d1 - P	d2	SW	dk	l1	l2	Code no.	Availability			
	mm		mm	mm	mm					
NR. 3 -48	2.800	2.10	2.100	50.00	9.00	2.515		❍		
NR. 4 -40	3.500	2.70	2.350	56.00	11.00	2.845	●	❍		
NR. 5 -40	3.500	2.70	2.650	56.00	11.00	3.175	❍			
NR. 6 -32	4.000	3.00	2.850	56.00	12.00	3.505	●	●	●	●
NR. 8 -32	4.500	3.40	3.500	63.00	13.00	4.166	●	●	❍	●
NR.10 -24	6.000	4.90	3.900	70.00	14.00	4.826	●	●	●	●
NR.12 -24	6.000	4.90	4.500	80.00	16.00	5.486	●	❍	●	●
1/4 -20	7.000	5.50	5.100	80.00	16.00	6.350	●	●	●	●
5/16-18	8.000	6.20	6.600	90.00	18.00	7.938	●	●	●	●
3/8 -16	10.000	8.00	8.000	100.00	20.00	9.525	●	●	●	●

○ bright ● steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

Guhring no.	878	1984	1985	2873	2883
Standard	DIN 2184-1				
Standard	~ DIN 376				
Tool material	HSS-E				
Surface	○	●	○	●	●
Type	N	GG	VA	VA	N
Form	B	C	B	B	B
Tolerance	2B	2B	2B	2B	2B
Cutting direction	right-hand	right-hand	right-hand	right-hand	right-hand
Discount group	103	103	103	103	103
Techn. data page	786	802	796	796	798



d1 - P	d2	SW	dk	l1	l2	Code no.	878	1984	1985	2873	2883
	mm		mm	mm	mm		Availability				
7/16-14	8.000	6.20	9.400	100.00	22.00	11.113	●	●			●
1/2 -13	9.000	7.00	10.800	110.00	25.00	12.700	●	●	●	●	●
9/16-12	11.000	9.00	12.200	110.00	30.00	14.288		●	❍		
5/8 -11	12.000	9.00	13.500	110.00	30.00	15.875	●	●	●	●	●
3/4 -10	14.000	11.00	16.500	125.00	33.00	19.050	●	●	●		●
7/8 - 9	18.000	14.50	19.500	140.00	35.00	22.225	●		●		●
1 - 8	18.000	14.50	22.250	160.00	38.00	25.400	●		●	●	❍
1 1/8 - 7	22.000	18.00	25.000	180.00	44.00	28.575	❍				
1 1/4 - 7	22.000	18.00	28.000	180.00	44.00	31.750	●				

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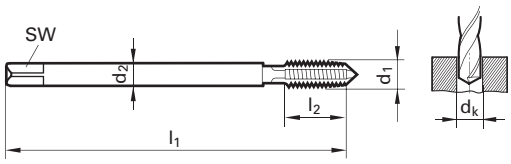
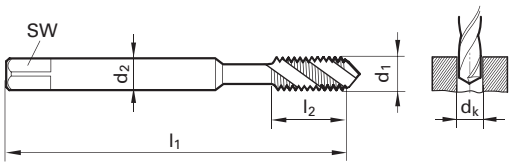
Guhring no.	2890
Standard	DIN 2184-1
Standard	~ DIN 376
Tool material	HSS-E
Surface	●
Type	N
Form	B
Tolerance	2B
Cutting direction	right-hand
Discount group	103
Techn. data page	786



d1 - P	d2	SW	dk	l1	l2	Code no.	Availability
	mm		mm	mm	mm		
1/2 -13	9.000	7.00	10.800	110.00	25.00	12.700	●
5/8 -11	12.000	9.00	13.500	110.00	30.00	15.875	●
3/4 -10	14.000	11.00	16.500	125.00	33.00	19.050	●
7/8 - 9	18.000	14.50	19.500	140.00	35.00	22.225	●
1 - 8	18.000	14.50	22.250	160.00	38.00	25.400	❍
1 1/8 - 7	22.000	18.00	25.000	180.00	44.00	28.575	❍
1 1/4 - 7	22.000	18.00	28.000	180.00	44.00	31.750	❍

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

Guhring no.	2912	2922
Standard	DIN 2184-1	
Standard	~ DIN 371 / ~ DIN 376	
Tool material	HSS-E-PM	
Surface	C	A
Type	Ti R15	Ni R10
Form	C	C
Tolerance	2BX	2BX
Cutting direction	right-hand	right-hand
Discount group	103	103
Techn. data page	804	804



d1 - P	d2	SW	dk	l1	l2	Code no.	Availability	
	mm		mm	mm	mm			
NR. 4 -40	3.500	2.70	2.350	56.00	11.00	2.845	●	●
NR. 5 -40	3.500	2.70	2.650	56.00	11.00	3.175	○	●
NR. 6 -32	4.000	3.00	2.850	56.00	12.00	3.505	●	●
NR. 8 -32	4.500	3.40	3.500	63.00	13.00	4.166	●	●
NR.10 -24	6.000	4.90	3.900	70.00	14.00	4.826	●	●
NR.12 -24	6.000	4.90	4.500	80.00	16.00	5.486	●	●
1/4 -20	7.000	5.50	5.100	80.00	16.00	6.350	●	●
5/16-18	8.000	6.20	6.600	90.00	18.00	7.938	○	●
3/8 -16	10.000	8.00	8.000	100.00	20.00	9.525	●	●
7/16-14	8.000	6.20	9.400	100.00	22.00	11.113	○	●
1/2 -13	9.000	7.00	10.800	110.00	25.00	12.700	●	●
5/8 -11	12.000	9.00	13.500	110.00	30.00	15.875	●	○

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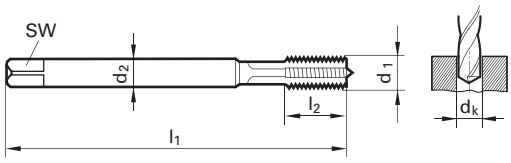
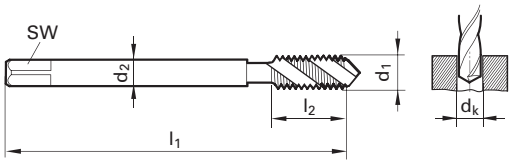
Guhring no.	1059	1063	1067
Standard	DIN 2184-1		
Standard	~ DIN 371 / ~ DIN 376		
Tool material	HSS-E-PM		
Surface	C	C	A
Type	Ti	Ti R15	Ni R10
Form	B	C	C
Tolerance	3BX	3BX	3BX
Cutting direction	right-hand	right-hand	right-hand
Discount group	103	103	103
Techn. data page	805	805	805
	NEW	NEW	NEW



d1 - P	d2	SW	dk	l1	l2	Code no.	Availability		
	mm		mm	mm	mm				
NR. 6 -32	4.000	3.00	2.850	56.00	12.00	3.505	●	○	●
NR. 8 -32	4.500	3.40	3.500	63.00	13.00	4.166	●	●	●
NR.10 -24	6.000	4.90	3.900	70.00	14.00	4.826	●	●	●
NR.12 -24	6.000	4.90	4.500	80.00	16.00	5.486	●	●	●
1/4 -20	7.000	5.50	5.100	80.00	16.00	6.350	○	●	●
5/16-18	8.000	6.20	6.600	90.00	18.00	7.938	●	●	●
3/8 -16	10.000	8.00	8.000	100.00	20.00	9.525	●	●	●
7/16-14	8.000	6.20	9.400	100.00	22.00	11.113	●	●	●
1/2 -13	9.000	7.00	10.800	110.00	25.00	12.700	●	●	●
5/8 -11	12.000	9.00	13.500	110.00	30.00	15.875	●	●	●

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

Guhring no.	911	1838	1987	1988	1991
Standard	DIN 2184-1				
Standard	~ DIN 374				
Tool material	HSS-E				
Surface	○	S	○	○	●
Type	N R40	N R40	N	N R15	VA R15
Form	C	C(K)	C	C	C
Tolerance	2B	2B	2B	2B	2B
Cutting direction	right-hand	right-hand	right-hand	right-hand	right-hand
Discount group	103	103	103	103	103
Techn. data page	787	799	786	787	797



d1 - P	d2	SW	dk	l1	l2	Code no.	Availability				
	mm		mm	mm	mm						
NR. 3 -56	1.800		2.150	50.00	5.00	2.515	●		○	○	
NR. 4 -48	2.200		2.400	56.00	6.00	2.845			○	○	
NR. 5 -44	2.500	2.10	2.700	56.00	6.00	3.175	○		○		
NR. 6 -40	2.500	2.10	2.950	56.00	6.50	3.505	○		○	○	
NR. 8 -36	2.800	2.10	3.500	63.00	7.00	4.166	●		○	○	
NR.10 -32	3.500	2.70	4.100	70.00	8.50	4.826	●	●	●		●
NR.12 -28	4.000	3.00	4.600	80.00	9.00	5.486	○	●	○	○	
1/4 -28	4.500	3.40	5.500	80.00	9.00	6.350	●	●	○	●	●
5/16-24	6.000	4.90	6.900	90.00	11.00	7.938	●	●	●	●	●
3/8 -24	7.000	5.50	8.500	90.00	11.00	9.525	●	○	●	●	●
7/16-20	8.000	6.20	9.900	100.00	13.00	11.113	●	○	○	○	●
1/2 -20	9.000	7.00	11.500	100.00	13.00	12.700	●	○	○	○	●
9/16-18	11.000	9.00	12.900	100.00	14.00	14.288	●		○	●	
5/8 -18	12.000	9.00	14.500	100.00	15.00	15.875	●	●	●	○	●
3/4 -16	14.000	11.00	17.500	110.00	16.00	19.050	●		●	●	
7/8 -14	18.000	14.50	20.400	125.00	19.00	22.225	●	○	●		
1 -12	18.000	14.50	23.250	140.00	22.00	25.400	○	○	○	○	

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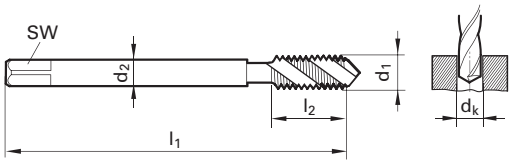
Guhring no.	2841	2846
Standard	DIN 2184-1	
Standard	~ DIN 374	
Tool material	HSS-E	
Surface	●	●
Type	N R15	N R40
Form	C	C
Tolerance	2B	2B
Cutting direction	right-hand	right-hand
Discount group	103	103
Techn. data page	787	787



d1 - P	d2	SW	dk	l1	l2	Code no.	Availability	
	mm		mm	mm	mm			
NR. 3 -56	1.800		2.150	50.00	5.00	2.515		
NR. 4 -48	2.200		2.400	56.00	6.00	2.845		
NR. 5 -44	2.500	2.10	2.700	56.00	6.00	3.175		
NR. 6 -40	2.500	2.10	2.950	56.00	6.50	3.505		
NR. 8 -36	2.800	2.10	3.500	63.00	7.00	4.166		
NR.10 -32	3.500	2.70	4.100	70.00	8.50	4.826		●
NR.12 -28	4.000	3.00	4.600	80.00	9.00	5.486		◐
1/4 -28	4.500	3.40	5.500	80.00	9.00	6.350		●
5/16-24	6.000	4.90	6.900	90.00	11.00	7.938		●
3/8 -24	7.000	5.50	8.500	90.00	11.00	9.525	●	●
7/16-20	8.000	6.20	9.900	100.00	13.00	11.113		●
1/2 -20	9.000	7.00	11.500	100.00	13.00	12.700	●	●
5/8 -18	12.000	9.00	14.500	100.00	15.00	15.875		●
3/4 -16	14.000	11.00	17.500	110.00	16.00	19.050	●	●
7/8 -14	18.000	14.50	20.400	125.00	19.00	22.225		◐
1 -12	18.000	14.50	23.250	140.00	22.00	25.400		

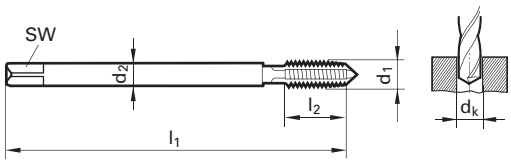
○ bright ● steam tempered ◓ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

2858	2859	2867	2868	2898
DIN 2184-1				
~ DIN 374				
HSS-E				
○	●	○	●	(S)
N R40	N R40	VA R40	VA R40	VA R15
C	C	C	C	C
2B	2B	2B	2B	2B
right-hand	right-hand	right-hand	right-hand	right-hand
103	103	103	103	103
799	799	797	797	797

Availability				
			○	
	○		●	●
	●		○	○
				○
○				○
	●		●	●
			○	○
○	●	○	●	○
●	●		●	○
●	●	●	●	○
	●		●	●
	●		●	○
	●		●	○
○	●	●	●	○
		○		○

C TiCN Cb Carbo D Cristall F FIRE/nanoFIRE P AlCrN S TiN S+ TiN+ M MolyGlide Y Signum

Guhring no.	908	1989
Standard	DIN 2184-1	
Standard	~ DIN 374	
Tool material	HSS-E	
Surface	○	●
Type	N	GG
Form	B	C
Tolerance	2B	2B
Cutting direction	right-hand	right-hand
Discount group	103	103
Techn. data page	786	802



d1 - P	d2	SW	dk	l1	l2	Code no.	Availability	
	mm		mm	mm	mm			
NR. 3 -56	1.800		2.150	50.00	9.00	2.515	❍	❍
NR. 4 -48	2.200		2.400	56.00	10.00	2.845	❍	❍
NR. 5 -44	2.500	2.10	2.700	56.00	10.00	3.175	❍	
NR. 6 -40	2.500	2.10	2.950	56.00	11.00	3.505	❍	❍
NR. 8 -36	2.800	2.10	3.500	63.00	12.00	4.166	❍	
NR.10 -32	3.500	2.70	4.100	70.00	14.00	4.826	●	
NR.12 -28	4.000	3.00	4.600	80.00	16.00	5.486	●	●
1/4 -28	4.500	3.40	5.500	80.00	16.00	6.350	●	●
5/16-24	6.000	4.90	6.900	90.00	18.00	7.938	●	●
3/8 -24	7.000	5.50	8.500	90.00	18.00	9.525	●	●
7/16-20	8.000	6.20	9.900	100.00	22.00	11.113	●	●
1/2 -20	9.000	7.00	11.500	100.00	20.00	12.700	●	●
9/16-18	11.000	9.00	12.900	100.00	22.00	14.288	●	●
5/8 -18	12.000	9.00	14.500	100.00	22.00	15.875	●	
3/4 -16	14.000	11.00	17.500	110.00	25.00	19.050	●	●
7/8 -14	18.000	14.50	20.400	125.00	25.00	22.225	●	●
1 -12	18.000	14.50	23.250	140.00	28.00	25.400	●	❍
1 1/8 -12	22.000	18.00	26.500	150.00	28.00	28.575	●	
1 1/4 -12	22.000	18.00	29.500	150.00	28.00	31.750	●	

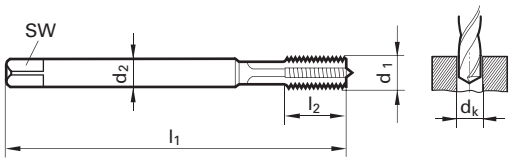
○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

1990	2874	2884	2885	2891
DIN 2184-1				
~ DIN 374				
HSS-E				
○	●	A + M	●	●
VA	VA	N	N	N
B	B	B	B	B
2B	2B	2B	2B	2B
right-hand	right-hand	right-hand	right-hand	right-hand
103	103	103	103	103
796	796	798	798	786

Availability				
❍				❍
❍		❍	❍	
	●	❍	❍	❍
●	●		●	●
●	❍	❍		
●	●	❍	●	●
●		●	●	●
				●
				●
	❍	❍	●	
	❍	●	❍	●
		❍		
				●

C TiCN Cb Carbo D Cristall F FIRE/nanoFIRE P AlCrN S TiN S+ TiN+ M MolyGlide Y Signum

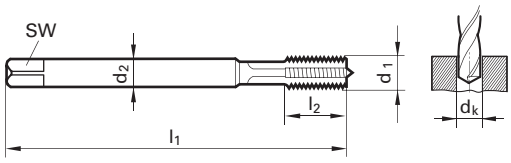
Guhring no.	2907	2919	2914	2923
Standard	DIN 2184-1			
Standard	~ DIN 371		~ DIN 371 / ~ DIN 374	
Tool material	HSS-E-PM			
Surface	C	A	C	A
Type	Ti	Ni	Ti R15	Ni R10
Form	B	B	C	C
Tolerance	2BX	2BX	2BX	2BX
Cutting direction	right-hand	right-hand	right-hand	right-hand
Discount group	103	103	103	103
Techn. data page	804	804	804	804



d1 - P	d2	SW	dk	l1	l2	Code no.	2907	2919	2914	2923
	mm		mm	mm	mm		Availability			
NR. 4 -48	3.500	2.70	2.400	56.00	10.00	2.845			●	●
NR. 5 -44	3.500	2.70	2.700	56.00	10.00	3.175			●	●
NR. 6 -40	4.000	3.00	2.950	56.00	11.00	3.505	●	❍	❍	●
NR. 8 -36	4.500	3.40	3.500	63.00	12.00	4.166	●	●	●	●
NR.10 -32	6.000	4.90	4.100	70.00	14.00	4.826	●	●	●	●
NR.12 -28	6.000	4.90	4.600	80.00	16.00	5.486	●	❍	●	●
1/4 -28	7.000	5.50	5.500	80.00	16.00	6.350	●	●	●	●
5/16-24	8.000	6.20	6.900	90.00	17.00	7.938	●	●	❍	●
3/8 -24	10.000	8.00	8.500	90.00	16.00	9.525	●	❍	●	●
7/16-20	8.000	6.20	9.900	100.00	22.00	11.113			●	●
1/2 -20	9.000	7.00	11.500	100.00	20.00	12.700			●	●
5/8 -18	12.000	9.00	14.500	100.00	22.00	15.875			●	●

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

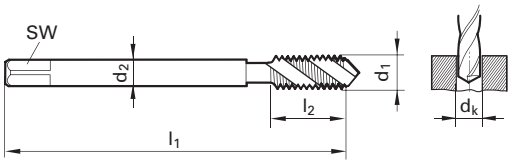
Guhring no.	1060	1064	1068
Standard	DIN 2184-1		
Standard	~ DIN 371 / ~ DIN 374		
Tool material	HSS-E-PM		
Surface	C	C	A
Type	Ti	Ti R15	Ni R10
Form	B	C	C
Tolerance	3BX	3BX	3BX
Cutting direction	right-hand	right-hand	right-hand
Discount group	103	103	103
Techn. data page	805	805	805
	NEW	NEW	NEW



d1 - P	d2	SW	dk	l1	l2	Code no.	Availability		
	mm		mm	mm	mm				
NR. 6 -40	4.000	3.00	2.950	56.00	12.00	3.505	●	●	●
NR. 8 -36	4.500	3.40	3.500	63.00	13.00	4.166	●	●	●
NR.10 -32	6.000	4.90	4.100	70.00	14.00	4.826	●	●	●
NR.12 -28	6.000	4.90	4.600	80.00	16.00	5.486	●	●	●
1/4 -28	7.000	5.50	5.500	80.00	16.00	6.350	●	●	●
5/16-24	8.000	6.20	6.900	90.00	18.00	7.938	●	●	●
3/8 -24	10.000	8.00	8.500	100.00	20.00	9.525	●	●	●
7/16-20	8.000	6.20	9.900	100.00	22.00	11.113	●	●	●
1/2 -20	9.000	7.00	11.500	100.00	20.00	12.700	●	●	●
5/8 -18	12.000	9.00	14.500	100.00	22.00	15.875	●	●	●

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

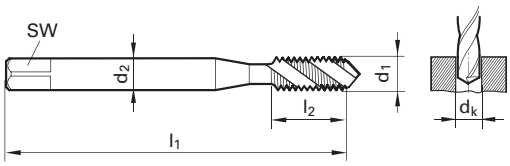
Guhring no.	2848
Standard	DIN 2184-1
Standard	~ DIN 376
Tool material	HSS-E
Surface	●
Type	N R40
Form	C
Tolerance	
Cutting direction	right-hand
Discount group	103
Techn. data page	787



d1	P	d2	SW	dk	l1	l2	Code no.	Availability
	G/inch	mm		mm	mm	mm		
W 3/8	16.00	7.000	5.50	7.900	100.00	16.00	9.525	●
W 7/16	14.00	8.000	6.20	9.200	100.00	18.00	11.113	●
W 1/2	12.00	9.000	7.00	10.500	110.00	20.00	12.700	●
W 9/16	12.00	11.000	9.00	12.000	110.00	21.00	14.287	❍
W 5/8	11.00	12.000	9.00	13.500	110.00	24.00	15.876	●
W 3/4	10.00	14.000	11.00	16.250	125.00	25.00	19.051	●
W 7/8	9.00	18.000	14.50	19.250	140.00	28.00	22.226	●
W1	8.00	18.000	14.50	22.000	160.00	32.00	25.401	❍

○ bright ● steam tempered ◓ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

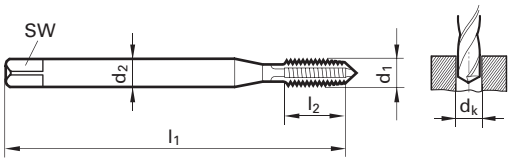
Guhring no.	2847	2893
Standard	DIN 2184-1	
Standard	~ DIN 371	~ DIN 376
Tool material	HSS-E	
Surface		
Type	N R40	N
Form	C	B
Tolerance		
Cutting direction	right-hand	right-hand
Discount group	103	103
Techn. data page	787	786



d1	P	d2	SW	dk	l1	l2	Code no.	Availability	
	G/inch	mm		mm	mm	mm			
W 1/8	40.00	3.500	2.70	2.500	56.00	7.00	3.175	●	
W 3/16	24.00	6.000	4.90	3.600	70.00	11.00	4.762	●	
W 1/4	20.00	7.000	5.50	5.100	80.00	13.00	6.350	●	
W 5/16	18.00	8.000	6.20	6.500	90.00	14.00	7.938	●	
W 3/8	16.00	10.000	8.00	7.900	100.00	16.00	9.525	●	
W 7/16	14.00	8.000	6.20	9.200	100.00	22.00	11.113		●
W 1/2	12.00	9.000	7.00	10.500	110.00	25.00	12.700		●
W 9/16	12.00	11.000	9.00	12.000	110.00	30.00	14.287		○
W 5/8	11.00	12.000	9.00	13.500	110.00	30.00	15.876		●
W 3/4	10.00	14.000	11.00	16.250	125.00	33.00	19.051		●
W 7/8	9.00	18.000	14.50	19.250	140.00	35.00	22.226		○
W1	8.00	18.000	14.50	22.000	160.00	38.00	25.401		○

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

Guhring no.	2892
Standard	DIN 2184-1
Standard	~ DIN 371
Tool material	HSS-E
Surface	steam tempered
Type	N
Form	B
Tolerance	
Cutting direction	right-hand
Discount group	103
Techn. data page	786

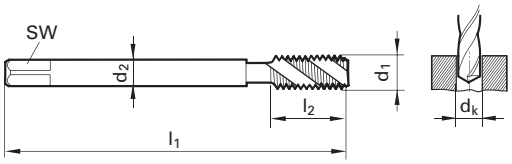


d1	P	d2	SW	dk	l1	l2	Code no.	Availability
	G/inch	mm		mm	mm	mm		
W 1/8	40.00	3.500	2.70	2.500	56.00	11.00	3.175	●
W 5/32	32.00	4.500	3.40	3.200	63.00	13.00	3.969	●
W 3/16	24.00	6.000	4.90	3.600	70.00	14.00	4.762	●
W 1/4	20.00	7.000	5.50	5.100	80.00	16.00	6.350	●
W 5/16	18.00	8.000	6.20	6.500	90.00	18.00	7.938	●
W 3/8	16.00	10.000	8.00	7.900	100.00	20.00	9.525	●

bright · steam tempered · nitrided lands · nitrided · golden brown · TiAlN · TiAlN nanoA · TiAlN SuperA

Guhring no.	4159
Standard	DIN 2184-1
Standard	DIN 5156
Tool material	HSS-E-PM
Surface	S
Type	VA R40
Form	C
Tolerance	
Cutting direction	right-hand
Discount group	103
Techn. data page	797

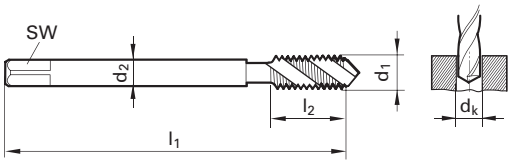
NEW



d1	P	d2	SW	dk	l1	l2	Code no.	Availability
	G/inch	mm		mm	mm	mm		
G 1/16	28.00	6.000	4.90	6.800	90.00	4.50	7.723	●
G 1/8	28.00	7.000	5.50	8.800	90.00	4.50	9.728	●
G 1/4	19.00	11.000	9.00	11.800	100.00	6.70	13.157	●
G 3/8	19.00	12.000	9.00	15.250	100.00	6.70	16.662	●
G 1/2	14.00	16.000	12.00	19.000	125.00	9.10	20.955	●

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

Guhring no.	937	963	964
Standard	DIN 2184-1		
Standard	DIN 5156		
Tool material	HSS-E		
Surface	S	○	○
Type	N R40	N	N R15
Form	C(K)	C	C
Tolerance			
Cutting direction	right-hand	right-hand	right-hand
Discount group	103	103	103
Techn. data page	799	786	787



d1	P	d2	SW	dk	l1	l2	Code no.	Availability		
	G/inch	mm		mm	mm	mm				
G 1/16	28.00	6.000	4.90	6.800	90.00	11.00	7.723		❍	
G 1/8	28.00	7.000	5.50	8.800	90.00	11.00	9.728	●	●	●
G 1/4	19.00	11.000	9.00	11.800	100.00	14.00	13.157	●	●	●
G 3/8	19.00	12.000	9.00	15.250	100.00	14.00	16.662	●	●	●
G 1/2	14.00	16.000	12.00	19.000	125.00	18.00	20.955	●	●	●
G 5/8	14.00	18.000	14.50	21.000	125.00	18.00	22.911		●	
G 3/4	14.00	20.000	16.00	24.500	140.00	20.00	26.441	●	●	●
G 7/8	14.00	22.000	18.00	28.250	150.00	22.00	30.201	❍		
G1	11.00	25.000	20.00	30.750	160.00	24.00	33.249	●	●	●
G1 1/8	11.00	28.000	22.00	35.500	170.00	24.00	37.897	❍		
G1 1/4	11.00	32.000	24.00	39.500	170.00	25.00	41.910		●	
G1 3/8	11.00	36.000	29.00	41.750	180.00	27.00	44.323		❍	
G1 1/2	11.00	36.000	29.00	45.250	190.00	27.00	47.803	❍	●	
G2	11.00	45.000	35.00	57.000	220.00	32.00	59.614		●	

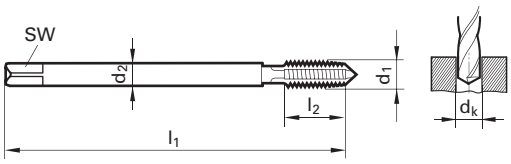
○ bright ◐ steam tempered ◒ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

965	968	2842	2849	2860	2861	4158	939
DIN 2184-1							
DIN 5156							
HSS-E							HSS-E-PM
○	●	●	●	○	●	C	○
N R40	VA R40	N R15	N R40	N R40	N R40	N R15	VA R40
C	C	C	C	C	C	E	C
right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand
103	103	103	103	103	103	103	103
787	797	787	787	799	799	799	797
						NEW	

Availability							
●	❍					●	
●	●	●	●	●	●	●	●
●	●	●	●	●	●	●	●
●	●	●	●	●	●	●	●
●	●	●	●	●	●	●	●
				❍			
●	●	●	●	●	●	●	
	❍				❍		
●	●	●	●	●	●	●	
●	●				●		
	❍						
●	●				●		
					●		

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

Guhring no.	961	962
Standard	DIN 2184-1	
Standard	DIN 5156	
Tool material	HSS-E	
Surface	●	○
Type	GG	N
Form	C	B
Tolerance		
Cutting direction	right-hand	right-hand
Discount group	103	103
Techn. data page	802	786



d1	P	d2	SW	dk	l1	l2	Code no.	Availability	
	G/inch	mm		mm	mm	mm			
G 1/16	28.00	6.000	4.90	6.800	90.00	18.00	7.723	◐	
G 1/8	28.00	7.000	5.50	8.800	90.00	18.00	9.728	●	●
G 1/4	19.00	11.000	9.00	11.800	100.00	20.00	13.157	●	●
G 3/8	19.00	12.000	9.00	15.250	100.00	22.00	16.662	●	●
G 1/2	14.00	16.000	12.00	19.000	125.00	25.00	20.955	●	●
G 5/8	14.00	18.000	14.50	21.000	125.00	25.00	22.911		◐
G 3/4	14.00	20.000	16.00	24.500	140.00	28.00	26.441	●	●
G 7/8	14.00	22.000	18.00	28.250	150.00	28.00	30.201		
G1	11.00	25.000	20.00	30.750	160.00	30.00	33.249	●	●
G1 1/8	11.00	28.000	22.00	35.500	170.00	30.00	37.897	◐	
G1 1/4	11.00	32.000	24.00	39.500	170.00	30.00	41.910	●	●
G1 3/8	11.00	36.000	29.00	41.750	180.00	32.00	44.323	◐	
G1 1/2	11.00	36.000	29.00	45.250	190.00	32.00	47.803	●	●
G2	11.00	45.000	35.00	57.000	220.00	40.00	59.614	●	●

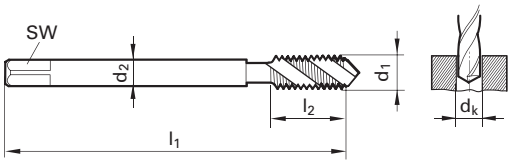
○ bright ◯ steam tempered ◒ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

967	2875	2886	2887	2894	938
DIN 2184-1					
DIN 5156					
HSS-E					HSS-E-PM
○	●	A + M	●	●	○
VA	VA	N	N	N	VA
B	B	B	B	B	B
right-hand	right-hand	right-hand	right-hand	right-hand	right-hand
103	103	103	103	103	103
796	796	798	798	786	796

Availability					
○					
●	●	●	●	●	●
●	●		●	●	
●	●		●	●	
		○			
●	●		●	●	
●					
	●		●	●	
			●		
			●		
			●		

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

Guhring no.	1088	1087
Standard		
Standard	Guhring std.	
Tool material	HSS-E	
Surface	S	
Type	VA R25	VA R25
Form	C	C
Tolerance		
Cutting direction	right-hand	right-hand
Discount group	103	103
Techn. data page	797	797

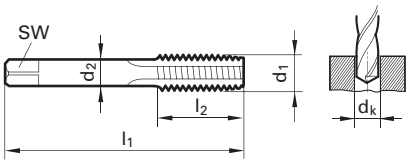


d1	P	d2	SW	dk	l1	l2	Code no.	Availability	
	G/inch	mm		mm	mm	mm			
1/8	27.00	11.000	9.00	8.500	90.00	15.00	10.620	●	●
1/4	18.00	14.000	11.00	11.200	100.00	21.00	14.140	●	●
3/8	18.00	16.000	12.00	14.400	110.00	21.00	17.570	●	●
1/2	14.00	18.000	14.50	18.000	125.00	27.00	21.900	●	●
3/4	14.00	22.000	18.00	23.400	140.00	27.00	27.230	●	●

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

Guhring no.	4127
Standard	
Standard	Guhring std.
Tool material	HSS-E
Surface	S
Type	VA R25
Form	C
Tolerance	
Cutting direction	right-hand
Discount group	103
Techn. data page	797

NEW

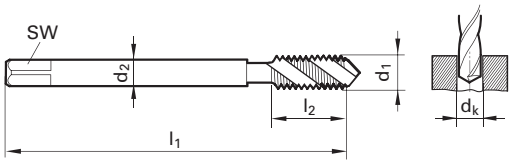


d1	P	d2	SW	dk	l1	l2	Code no.	Availability
	G/inch	mm		mm	mm	mm		
1/16	27.00	8.000	6.20	6.250	90.00	14.00	8.190	●
1/8	27.00	11.000	9.00	8.500	90.00	15.00	10.620	●
1/4	18.00	14.000	11.00	11.200	100.00	21.00	14.140	●
3/8	18.00	16.000	12.00	14.400	110.00	21.00	17.570	●
1/2	14.00	18.000	14.50	18.000	125.00	27.00	21.900	●
3/4	14.00	22.000	18.00	23.400	140.00	27.00	27.230	●
1	11.50	25.000	20.00	29.100	170.00	32.00	34.180	●

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

Guhring no.	1011
Standard	
Standard	DIN 40435
Tool material	HSS-E
Surface	S
Type	N R40
Form	C
Tolerance	6H mod
Cutting direction	right-hand
Discount group	103
Techn. data page	799

NEW

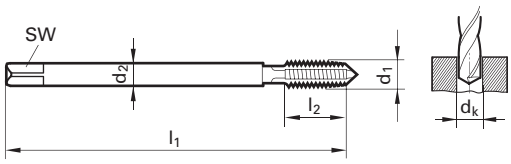


d1	P	d2	SW	dk	l1	l2	Availability
	mm	mm		mm	mm	mm	
EG M 4	0.70	6.000	4.90	4.200	70.00	7.50	●
EG M 5	0.80	6.000	4.90	5.250	80.00	8.50	●
EG M 6	1.00	8.000	6.20	6.300	90.00	11.00	●
EG M 8	1.25	10.000	8.00	8.400	100.00	14.00	●
EG M10	1.50	9.000	7.00	10.500	100.00	16.00	●
EG M12	1.75	11.000	9.00	12.500	110.00	18.50	●
EG M14	2.00	12.000	9.00	14.500	110.00	20.00	●
EG M16	2.00	14.000	11.00	16.500	125.00	20.00	●

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

Guhring no.	**1010**
Standard	
Standard	**DIN 40435**
Tool material	**HSS-E**
Surface	**S**
Type	**N**
Form	**B**
Tolerance	**6H mod**
Cutting direction	**right-hand**
Discount group	**103**
Techn. data page	**798**

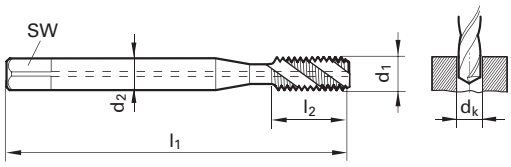
NEW



d1	P	d2	SW	dk	l1	l2	Availability
	mm	mm		mm	mm	mm	
EG M 4	0.70	6.000	4.90	4.200	70.00	12.00	●
EG M 5	0.80	6.000	4.90	5.250	80.00	14.00	●
EG M 6	1.00	8.000	6.20	6.300	90.00	17.00	●
EG M 8	1.25	10.000	8.00	8.400	100.00	20.00	●
EG M10	1.50	9.000	7.00	10.500	100.00	20.00	●
EG M12	1.75	11.000	9.00	12.500	110.00	30.00	●
EG M14	2.00	12.000	9.00	14.500	110.00	26.00	●
EG M16	2.00	14.000	11.00	16.500	125.00	33.00	○

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

Guhring no.	1891	1892	1893
Standard	DIN 2184-1		
Standard	DIN 371		
Tool material	HSS-E		
Surface	○	○	○
Type	N R15	VA R40	N R40
Form	C	C	C
Tolerance	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H
Cutting direction	right-hand	right-hand	right-hand
Discount group	103	103	103
Techn. data page	806	797	787



d1	P	d2	SW	dk	l1	l2	Availability		
	mm	mm		mm	mm	mm			
M 5	0.80	6.000	4.90	4.200	70.00	8.50	●	●	●
M 6	1.00	6.000	4.90	5.000	80.00	11.00	●	●	●
M 8	1.25	8.000	6.20	6.800	90.00	14.00	●	●	●
M10	1.50	10.000	8.00	8.500	100.00	16.00	●	●	●

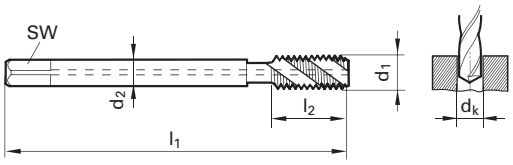
○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

1894	2436	2438	2514	1152	1188
DIN 2184-1					
DIN 371					
HSS-E				HSS-E-PM	
○	S	S	A + M	C	C
H R40	N R15	N R40	N R40	N R50	H R15
C	C	C	C	C	C
ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	6HX
right-hand	right-hand	right-hand	right-hand	right-hand	right-hand
103	103	103	103	103	103
793	787	787	799	799	792

Availability					
●	❍	●	●	●	
●	●	●	●	●	●
●	●	●	●	●	●
❍	●	●	●	●	●

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

Guhring no.	1898	1899
Standard	DIN 2184-1	
Standard	DIN 376	
Tool material	HSS-E	
Surface	○	○
Type	N R15	VA R40
Form	C	C
Tolerance	ISO 2 / 6H	ISO 2 / 6H
Cutting direction	right-hand	right-hand
Discount group	103	103
Techn. data page	806	797



d1	P	d2	SW	dk	l1	l2	Availability	
	mm	mm		mm	mm	mm		
M12	1.75	9.000	7.00	10.200	110.00	18.50	●	●
M14	2.00	11.000	9.00	12.000	110.00	20.00	●	❍
M16	2.00	12.000	9.00	14.000	110.00	20.00	❍	●
M18	2.50	14.000	11.00	15.500	125.00	25.00		
M20	2.50	16.000	12.00	17.500	140.00	25.00		❍
M22	2.50	18.000	14.50	19.500	140.00	27.00		
M24	3.00	18.000	14.50	21.000	160.00	30.00		

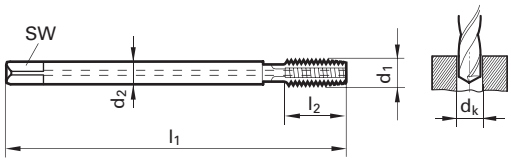
○ bright ● steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

1901	2437	2439	1194	1293
DIN 2184-1				
DIN 376				
HSS-E			HSS-E-PM	
○	S	S	C	S
H R40	N R15	N R40	H R15	N R50
C	C	C	C	C
ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	6HX	ISO 2 / 6H
right-hand	right-hand	right-hand	right-hand	right-hand
103	103	103	103	103
793	787	787	792	799

Availability				
●	●	●	●	●
●	●	●	●	●
●	●	●	●	●
●	●	●		
●	●	●	●	●
			●	
			●	
			●	

C TiCN Cb Carbo D Cristall F FIRE/nanoFIRE P AlCrN S TiN S+ TiN+ M MolyGlide Y Signum

Guhring no.	969	971
Standard	DIN 2184-1	
Standard	DIN 371	
Tool material	Solid carbide	
Surface	○	○
Type	H	N R15
Form	C	C
Tolerance	6HX	6HX
Cutting direction	right-hand	right-hand
Discount group	103	103
Techn. data page	801	801



d1	P	d2	SW	dk	l1	l2	Availability	
	mm	mm		mm	mm	mm		
M 3	0.50	3.500	2.70	2.500	56.00	8.00	●	●
M 4	0.70	4.500	3.40	3.300	63.00	10.00	●	●
M 5	0.80	6.000	4.90	4.200	70.00	10.00	●	●
M 6	1.00	6.000	4.90	5.000	80.00	12.00	●	●
M 8	1.25	8.000	6.20	6.800	90.00	16.00	●	●
M10	1.50	10.000	8.00	8.500	100.00	18.00	●	●

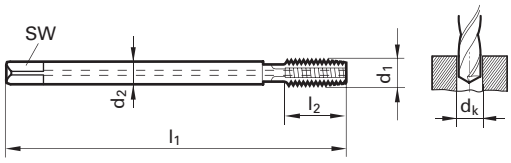
○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

1008	1858	2311	2506	2510	2516
DIN 2184-1					
DIN 371					
Solid carbide					
○	○	A	A	A	M
H	H	H	H	N R15	N R15
E	C	C	C	C	C
6HX	6HX	6HX	6HX	6HX	6HX
right-hand	right-hand	right-hand	right-hand	right-hand	right-hand
103	103	103	103	103	103
801	801	803	803	803	801
NEW					

Availability					
●					
●					
●	●	●	●	●	○
●	●	●	●	●	●
●	●	●	●	●	○
●	●	●	●	●	●

C TiCN Cb Carbo D Cristall F FIRE/nanoFIRE P AlCrN S TiN S+ TiN+ M MolyGlide Y Signum

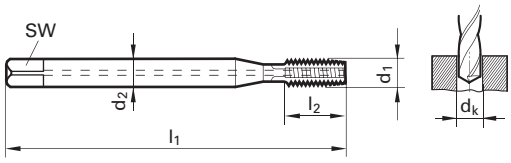
Guhring no.	1859	1883
Standard	DIN 2184-1	
Standard	DIN 376	
Tool material	Solid carbide	
Surface	○	○
Type	H	H
Form	C	C
Tolerance	6HX	6HX
Cutting direction	right-hand	right-hand
Discount group	103	103
Techn. data page	801	801



d1	P	d2	SW	dk	l1	l2	Availability	
	mm	mm		mm	mm	mm		
M12	1.75	9.000	7.00	10.200	110.00	22.00	●	●
M14	2.00	11.000	9.00	12.000	110.00	22.00	●	●
M16	2.00	12.000	9.00	14.000	110.00	22.00	●	●
M18	2.50	14.000	11.00	15.500	125.00	24.00	●	●
M20	2.50	16.000	12.00	17.500	140.00	25.00	●	●

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

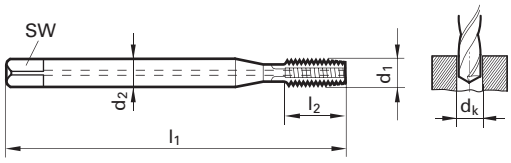
Guhring no.	318	1890	2517	302	1091
Standard	DIN 2184-1				
Standard	DIN 371				
Tool material	HSS-E			HSS-E-PM	
Surface	A	●	A+M	C	C
Type	GG	GG	N	H	H
Form	C	C	B	C	E
Tolerance	6HX	6HX	ISO 2 / 6H	6HX	6HX
Cutting direction	right-hand	right-hand	right-hand	right-hand	right-hand
Discount group	103	103	103	103	103
Techn. data page	802	802	798	800	800



d1	P	d2	SW	dk	l1	l2	Availability				
	mm	mm		mm	mm	mm					
M 5	0.80	6.000	4.90	4.200	70.00	14.00	●	●	●	●	●
M 6	1.00	6.000	4.90	5.000	80.00	16.00	●	●	●	●	●
M 8	1.25	8.000	6.20	6.800	90.00	17.00	●	●	●	●	●
M10	1.50	10.000	8.00	8.500	100.00	20.00	●	●	●	●	●

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

Guhring no.	319	1897
Standard	DIN 2184-1	
Standard	DIN 376	
Tool material	HSS-E	
Surface	A	●
Type	GG	GG
Form	C	C
Tolerance	6HX	6HX
Cutting direction	right-hand	right-hand
Discount group	103	103
Techn. data page	802	802

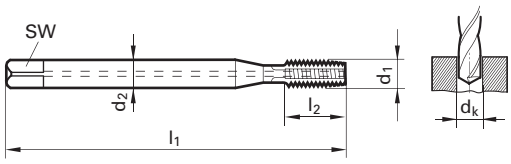


d1	P	d2	SW	dk	l1	l2	Availability	
	mm	mm		mm	mm	mm		
M12	1.75	9.000	7.00	10.200	110.00	24.00	●	●
M14	2.00	11.000	9.00	12.000	110.00	26.00	●	●
M16	2.00	12.000	9.00	14.000	110.00	26.00	●	●
M18	2.50	14.000	11.00	15.500	125.00	30.00	●	●
M20	2.50	16.000	12.00	17.500	140.00	32.00	●	●

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

Guhring no.	2899	297	4165
Standard	DIN 2184-1		
Standard	DIN 376		
Tool material	HSS-E	HSS-E-PM	
Surface	A+M	C	C
Type	N AZ	H	H
Form	E	C	E
Tolerance	ISO 2 / 6H	6HX	6HX
Cutting direction	right-hand	right-hand	right-hand
Discount group	103	103	103
Techn. data page	803	790	793

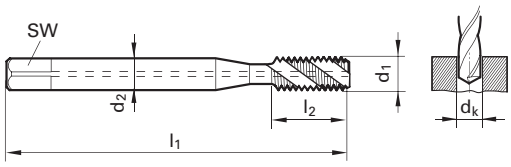
NEW



d1	P	d2	SW	dk	l1	l2	2899	297	4165
	mm	mm		mm	mm	mm	Availability		
M 5	0.80	3.500	2.70	4.200	70.00	14.00	❍		
M 6	1.00	4.500	3.40	5.000	80.00	16.00	❍		
M 8	1.25	6.000	4.90	6.800	90.00	17.00	●		
M10	1.50	7.000	5.50	8.500	100.00	20.00	●	●	●
M12	1.75	9.000	7.00	10.200	110.00	24.00	❍	●	●
M14	2.00	11.000	9.00	12.000	110.00	26.00		●	
M16	2.00	12.000	9.00	14.000	110.00	26.00			●
M20	2.50	16.000	12.00	17.500	140.00	32.00			●

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

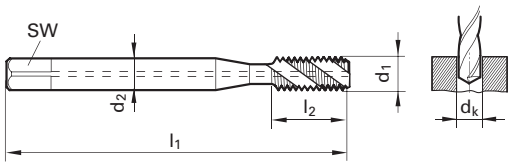
Guhring no.	1139	1142
Standard	DIN 2184-1	
Standard	DIN 371	DIN 376
Tool material	HSS-E-PM	
Surface	C	C
Type	VA R50	VA R50
Form	C	C
Tolerance	6HX	6HX
Cutting direction	right-hand	right-hand
Discount group	103	103
Techn. data page	797	797



d1	P	d2	SW	dk	l1	l2	Availability	
	mm	mm		mm	mm	mm		
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		●

bright · steam tempered · nitrided lands · nitrided · golden brown · TiAlN · TiAlN nanoA · TiAlN SuperA

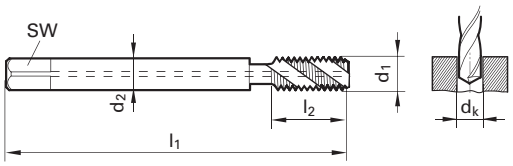
Guhring no.	**1144**
Standard	**DIN 2184-1**
Standard	**DIN 374**
Tool material	**HSS-E-PM**
Surface	C
Type	**VA R50**
Form	**C**
Tolerance	**6HX**
Cutting direction	**right-hand**
Discount group	**103**
Techn. data page	**797**



d1 X P	d2	SW	dk	l1	l2	Code no.	Availability
	mm		mm	mm	mm		
M 8 X1	6.000	4.90	7.000	90.00	5.00	8.005	●
M10 X1	7.000	5.50	9.000	90.00	5.00	10.005	●
M12 X1	9.000	7.00	11.000	100.00	5.00	12.005	●
M12 X1,5	9.000	7.00	10.500	100.00	7.50	12.007	●
M14 X1,5	11.000	9.00	12.500	100.00	7.50	14.007	●
M16 X1,5	12.000	9.00	14.500	100.00	7.50	16.007	●
M18 X1,5	14.000	11.00	16.500	110.00	7.50	18.007	●
M20 X1,5	16.000	12.00	18.500	125.00	7.50	20.007	●

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

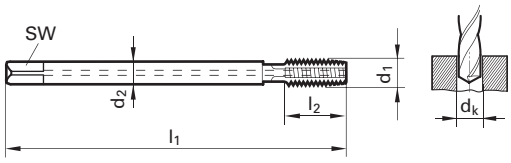
Guhring no.	1905	1906	1907	1200	1294
Standard	DIN 2184-1				
Standard	DIN 374				
Tool material	HSS-E			HSS-E-PM	
Surface	○	○	○	C	S
Type	N R15	VA R40	H R40	H R15	N R50
Form	C	C	C	C	C
Tolerance	ISO 2 / 6H	ISO 2 / 6H	ISO 2 / 6H	6HX	ISO 2 / 6H
Cutting direction	right-hand	right-hand	right-hand	right-hand	right-hand
Discount group	103	103	103	103	103
Techn. data page	787	797	793	792	799



d1 X P	d2	SW	dk	l1	l2	Code no.	Availability				
	mm		mm	mm	mm						
M 5 X0,5	3.500	2.70	4.500	70.00	5.00	5.003	❍	❍			
M 6 X0,5	4.500	3.40	5.500	80.00	5.00	6.003		❍			
M 6 X0,75	4.500	3.40	5.200	80.00	8.00	6.004	❍	●	❍	●	
M 8 X0,75	6.000	4.90	7.200	80.00	8.00	8.004	●	❍	❍	●	
M 8 X1	6.000	4.90	7.000	90.00	11.00	8.005	❍	❍	❍	●	●
M 9 X1	7.000	5.50	8.000	90.00	11.00	9.005				●	
M10 X1	7.000	5.50	9.000	90.00	11.00	10.005	●	●	❍	●	❍
M10 X1,25	7.000	5.50	8.800	100.00	14.00	10.006	●				
M12 X1	9.000	7.00	11.000	100.00	11.00	12.005			❍	●	●
M12 X1,25	9.000	7.00	10.800	100.00	16.00	12.006	●			●	
M12 X1,5	9.000	7.00	10.500	100.00	16.00	12.007	❍	❍	●	●	●
M14 X1	11.000	9.00	13.000	100.00	11.00	14.005	❍				
M14 X1,25	11.000	9.00	12.800	100.00	15.00	14.006	●				
M14 X1,5	11.000	9.00	12.500	100.00	15.00	14.007			❍	●	●
M16 X1	12.000	9.00	15.000	100.00	11.00	16.005	❍				
M16 X1,5	12.000	9.00	14.500	100.00	15.00	16.007	●	❍	●	●	●
M18 X1	14.000	11.00	17.000	110.00	12.00	18.005	●				
M18 X1,5	14.000	11.00	16.500	110.00	16.00	18.007				●	●
M20 X1	16.000	12.00	19.000	125.00	12.00	20.005	●				
M20 X1,5	16.000	12.00	18.500	125.00	16.00	20.007	❍		❍	●	●
M24 X1,5	18.000	14.50	22.500	140.00	16.00	24.007				●	

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

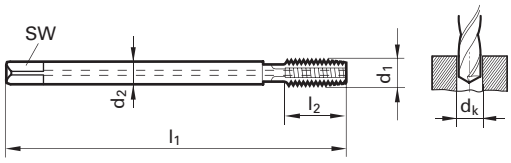
Guhring no.	347	1904	1007	1090
Standard	DIN 2184-1			
Standard	DIN 374			
Tool material	HSS-E		HSS-E-PM	
Surface	A	●	C	C
Type	GG	GG	H	H
Form	C	C	E	C
Tolerance	6HX	6HX	6HX	6HX
Cutting direction	right-hand	right-hand	right-hand	right-hand
Discount group	103	103	103	103
Techn. data page	802	802	802	802
			NEW	



d1 X P	d2	SW	dk	l1	l2	Code no.	347	1904	1007	1090
	mm		mm	mm	mm		Availability			
M 5 X0,50	3.500	2.70	4.500	70.00	10.00	5.003			●	●
M 6 X0,50	4.500	3.40	5.500	80.00	13.00	6.003			●	●
M 6 X0,75	4.500	3.40	5.200	80.00	13.00	6.004			●	●
M 8 X0,75	6.000	4.90	7.200	80.00	14.00	8.004			●	●
M 8 X1	6.000	4.90	7.000	90.00	17.00	8.005	●	●	●	❍
M 9 X1	7.000	5.50	8.000	90.00	17.00	9.005			●	
M10 X1	7.000	5.50	9.000	90.00	17.00	10.005	●	●	●	●
M10 X1,25	7.000	5.50	8.800	100.00	20.00	10.006			❍	●
M12 X1	9.000	7.00	11.000	100.00	20.00	12.005	●	●	●	❍
M12 X1,25	9.000	7.00	10.800	100.00	20.00	12.006			●	●
M12 X1,5	9.000	7.00	10.500	100.00	20.00	12.007	●	●	●	●
M14 X1	11.000	9.00	13.000	100.00	20.00	14.005			●	
M14 X1,25	11.000	9.00	12.800	100.00	20.00	14.006			●	
M14 X1,5	11.000	9.00	12.500	100.00	20.00	14.007	●	●	●	●
M16 X1	12.000	9.00	15.000	100.00	22.00	16.005			●	
M16 X1,5	12.000	9.00	14.500	100.00	22.00	16.007	●	●	●	●
M18 X1,5	14.000	11.00	16.500	110.00	25.00	18.007	●	●		
M20 X1,5	16.000	12.00	18.500	125.00	25.00	20.007	●	●		
M22 X1,5	18.000	14.50	20.500	125.00	25.00	22.007	●			
M24 X1,5	18.000	14.50	22.500	140.00	28.00	24.007	●			

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

Guhring no.	972	975	977
Standard	DIN 2184-1		
Standard	DIN 371		
Tool material	Solid carbide		
Surface	○	○	○
Type	H	N L15	N R15
Form	C	D	C
Tolerance	6HX	6HX	6HX
Cutting direction	right-hand	right-hand	right-hand
Discount group	103	103	103
Techn. data page	803	808	808



d1 X P	d2	SW	dk	l1	l2	Code no.	972	975	977
	mm		mm	mm	mm		Availability		
M 4 X0,5	4.500	3.40	3.500	63.00	10.00	4.003		●	●
M 5 X0,5	6.000	4.90	4.500	70.00	10.00	5.003	●	●	●
M 6 X0,5	6.000	4.90	5.500	80.00	12.00	6.003			●
M 8 X1	8.000	6.20	7.000	90.00	16.00	8.005	●	●	●
M10 X1	10.000	8.00	9.000	90.00	18.00	10.005	●		●
M12 X1	9.000	7.00	11.000	100.00	22.00	12.005			
M12 X1,5	9.000	7.00	10.500	100.00	22.00	12.007			
M14 X1,5	11.000	9.00	12.500	100.00	22.00	14.007			
M16 X1,5	12.000	9.00	14.500	100.00	22.00	16.007			
M18 X1,5	14.000	11.00	16.500	110.00	24.00	18.007			
M20 X1,5	16.000	12.00	18.500	125.00	25.00	20.007			

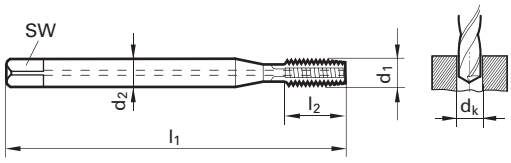
○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

1861	974	976	978	1009	1860
DIN 2184-1					
DIN 371			DIN 374		
Solid carbide					
○	○	○	○	○	○
H	H	N L15	N R15	H	H
C	C	D	C	E	C
6HX	6HX	6HX	6HX	6HX	6HX
right-hand	right-hand	right-hand	right-hand	right-hand	right-hand
103	103	103	103	103	103
808	808	808	808	808	808
				NEW	

Availability					
❍					
❍ ●				● ●	
	● ● ●	❍ ● ●	● ● ●	● ● ●	● ● ●
	● ●	●	● ❍		● ●

C TiCN Cb Carbo D Cristall F FIRE/nanoFIRE P AlCrN S TiN S+ TiN+ M MolyGlide Y Signum

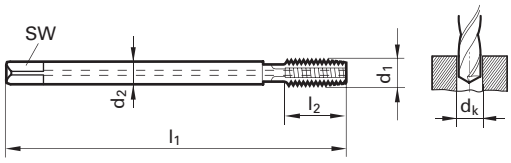
Guhring no.	1085	1086
Standard	DIN 2184-1	
Standard	~ DIN 371	~ DIN 376
Tool material	HSS-E	
Surface	A	A
Type	GG	GG
Form	C	C
Tolerance	2B	2B
Cutting direction	right-hand	right-hand
Discount group	103	103
Techn. data page	802	802



d1 - P	d2	SW	dk	l1	l2	Code no.	Availability	
	mm		mm	mm	mm			
NR.10 -24	6.000	4.90	3.900	70.00	14.00	4.826	❍	
NR.12 -24	6.000	4.90	4.500	80.00	16.00	5.486	●	
1/4 -20	7.000	5.50	5.100	80.00	16.00	6.350	●	
5/16-18	8.000	6.20	6.600	90.00	18.00	7.938	●	
3/8 -16	10.000	8.00	8.000	100.00	20.00	9.525	●	
7/16-14	8.000	6.20	9.400	100.00	22.00	11.113		❍
1/2 -13	9.000	7.00	10.800	110.00	25.00	12.700		●
5/8 -11	12.000	9.00	13.500	110.00	30.00	15.875		●
3/4 -10	14.000	11.00	16.500	125.00	33.00	19.050		●
7/8 - 9	18.000	14.50	19.500	140.00	35.00	22.225		●

○ bright ◐ steam tempered ◒ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

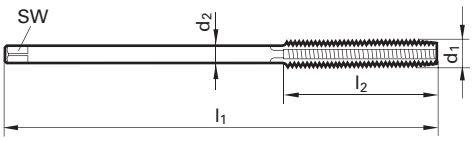
Guhring no.	1082
Standard	DIN 2184-1
Standard	~ DIN 374
Tool material	HSS-E
Surface	A
Type	GG
Form	C
Tolerance	2B
Cutting direction	right-hand
Discount group	103
Techn. data page	802



d1 - P	d2	SW	dk	l1	l2	Code no.	Availability
	mm		mm	mm	mm		
NR.10 -32	3.500	2.70	4.100	70.00	14.00	4.826	❍
NR.12 -28	4.000	3.00	4.600	80.00	16.00	5.486	●
1/4 -28	4.500	3.40	5.500	80.00	16.00	6.350	❍
5/16-24	6.000	4.90	6.900	90.00	18.00	7.938	❍
3/8 -24	7.000	5.50	8.500	90.00	18.00	9.525	●
7/16-20	8.000	6.20	9.900	100.00	22.00	11.113	❍
1/2 -20	9.000	7.00	11.500	100.00	20.00	12.700	❍
5/8 -18	12.000	9.00	14.500	100.00	22.00	15.875	❍
3/4 -16	14.000	11.00	17.500	110.00	25.00	19.050	❍
7/8 -14	18.000	14.50	20.400	125.00	25.00	22.225	●

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

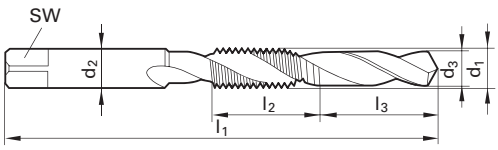
Guhring no.	851
Standard	
Standard	DIN 357
Tool material	HSS-E
Surface	◯
Type	N
Form	
Tolerance	ISO 2 / 6H
Cutting direction	right-hand
Discount group	103
Techn. data page	788



d1	P	d2	SW	dk	l1	l2	Availability
	mm	mm		mm	mm	mm	
M 3	0.50	2.200		2.500	70.00	22.00	●
M 4	0.70	2.800	2.10	3.300	90.00	25.00	●
M 5	0.80	3.500	2.70	4.200	100.00	28.00	●
M 6	1.00	4.500	3.40	5.000	110.00	32.00	●
M 8	1.25	6.000	4.90	6.800	125.00	40.00	●
M10	1.50	7.000	5.50	8.500	140.00	45.00	●
M12	1.75	9.000	7.00	10.200	180.00	50.00	●
M14	2.00	11.000	9.00	12.000	200.00	56.00	❍
M16	2.00	12.000	9.00	14.000	200.00	63.00	●
M18	2.50	14.000	11.00	15.500	220.00	63.00	❍
M20	2.50	16.000	12.00	17.500	250.00	70.00	●
M24	3.00	18.000	14.50	21.000	280.00	80.00	❍
M30	3.50	22.000	18.00	26.500	315.00	100.00	❍

ni- ni- Ti- A B TA

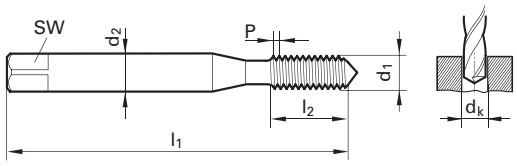
Guhring no.	**1839**
Standard	**Guhring std.**
Tool material	**HSS-E**
Surface	◯
Type	**N**
Form	**D**
Cutting direction	**right-hand**
Tolerance	**ISO 2 / 6H**
Discount group	**103**
Techn. data page	**789**



d1	P	d3	d2	SW	l1	l2	l3	Availability
	mm	mm	mm		mm	mm	mm	
M 3	0.50	2.500	3.500	2.70	62.00	12.00	9.00	●
M 4	0.70	3.300	4.500	3.40	66.00	16.00	10.00	●
M 5	0.80	4.200	6.000	4.90	75.00	18.00	12.00	●
M 6	1.00	5.000	6.000	4.90	81.00	20.00	14.00	●
M 8	1.25	6.800	6.000	4.90	93.00	12.00	20.00	●
M10	1.50	8.500	7.000	5.50	99.00	14.00	22.00	●
M12	1.75	10.200	9.000	7.00	106.00	16.00	25.00	●

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

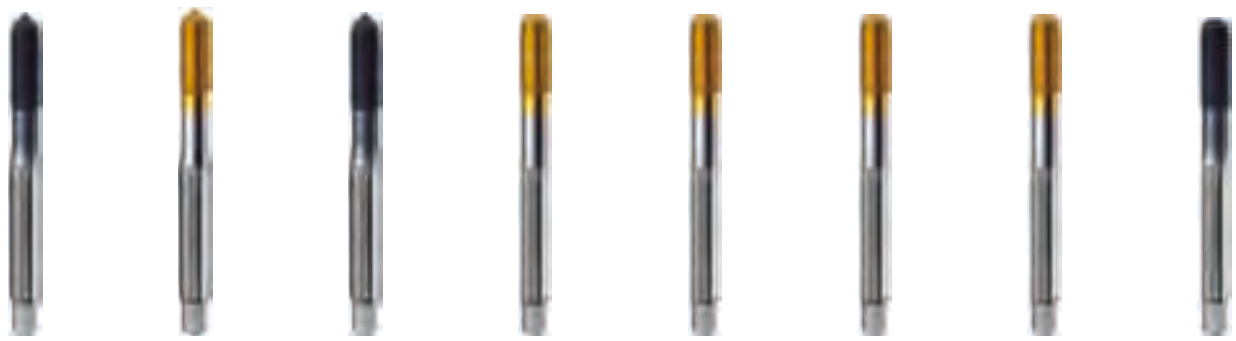
Guhring no.	921	920	1255
Standard	DIN 2174		
Standard	~ DIN 371		
Tool material	HSS-E		HSS-E-PM
Surface	S	S	S
Type	N	N	N
Form	C	C	C
Tolerance	6HX	6GX	6HX
Cutting direction	right-hand	right-hand	right-hand
Discount group	103	103	103
Techn. data page	814	814	814



d1	P	d2	SW	dk	l1	l2	Availability		
	mm	mm		mm	mm	mm			
M 2	0.40	2.800	2.10	1.850	45.00	8.00	●	●	●
M 2,5	0.45	2.800	2.10	2.300	50.00	9.00	●	●	●
M 3	0.50	3.500	2.70	2.800	56.00	10.00	●	●	●
M 3,5	0.60	4.000	3.00	3.250	56.00	12.00	●	●	
M 4	0.70	4.500	3.40	3.700	63.00	12.00	●	●	●
M 5	0.80	6.000	4.90	4.650	70.00	14.00	●	●	●
M 6	1.00	6.000	4.90	5.550	80.00	16.00	●	●	●
M 8	1.25	8.000	6.20	7.400	90.00	17.00	●	●	●
M10	1.50	10.000	8.00	9.300	100.00	20.00	●	●	●
M12	1.75	9.000	7.00	11.200	110.00	24.00			
M14	2.00	11.000	9.00	13.100	110.00	26.00			
M16	2.00	12.000	9.00	15.100	110.00	26.00			
M18	2.50	14.000	11.00	16.900	125.00	30.00			
M20	2.50	16.000	12.00	18.900	140.00	32.00			

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

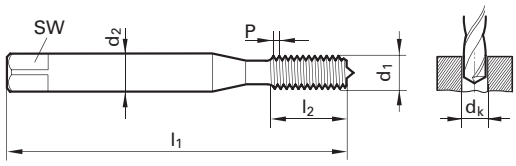
1347	903	1565	925	924	1256	952	1567
DIN 2174							
	~ DIN 371				~ DIN 376		
HSS-E-PM			HSS-E		HSS-E-PM		
Cb	S	Cb	S	S	S	S	Cb
N	N	N	N	N	N	N	N
C	C	C	C	C	C	C	C
6HX	6GX	6GX	6HX	6GX	6HX	6GX	6GX
right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand
103	103	103	103	103	103	103	103
814	814	814	814	814	814	814	814



Availability							
●	●						
●	●	●					
●	○	●					
●	●	●					
●	●	●					
●	●	●					
○	●						
			●	●	●	●	
			●	○	●	○	○
			●		○	○	●
			○	○	○		
				○	●	○	○

C TiCN Cb Carbo D Cristall F FIRE/nanoFIRE P AlCrN S TiN S+ TiN+ M MolyGlide Y Signum

Guhring no.	1280	1257
Standard	DIN 2174	
Standard	~ DIN 371	
Tool material	HSS-E	HSS-E-PM
Surface	S	S
Type	N	N
Form	C	C
Tolerance	6GX	6HX
Cutting direction	right-hand	right-hand
Discount group	103	103
Techn. data page	814	814



d1 X P	d2	SW	dk	l1	l2	Code no.	Availability	
	mm		mm	mm	mm			
M 8 X1	8.000	6.20	7.550	90.00	17.00	8.005		●
M 9 X1	9.000	7.00	8.550	90.00	17.00	9.005		●
M10 X1	10.000	8.00	9.550	90.00	17.00	10.005	●	●
M10 X1,25	10.000	8.00	9.400	100.00	20.00	10.006		
M12 X1	9.000	7.00	11.550	100.00	20.00	12.005		
M12 X1,25	9.000	7.00	11.400	100.00	20.00	12.006		
M12 X1,5	9.000	7.00	11.300	100.00	20.00	12.007		
M14 X1	11.000	9.00	13.550	100.00	20.00	14.005		
M14 X1,25	11.000	9.00	13.400	100.00	20.00	14.006		
M14 X1,5	11.000	9.00	13.300	100.00	20.00	14.007		
M16 X1	12.000	9.00	15.550	100.00	22.00	16.005		
M16 X1,5	12.000	9.00	15.300	100.00	22.00	16.007		
M20 X1	16.000	12.00	19.550	125.00	25.00	20.005		
M20 X1,5	16.000	12.00	19.300	125.00	25.00	20.007		
M24 X1,5	18.000	14.50	23.300	140.00	28.00	24.007		
M24 X2	18.000	14.50	23.100	140.00	28.00	24.008		

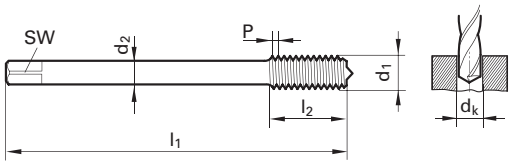
○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

1568	1740	1569	1258	1580
DIN 2174				
	~ DIN 371		~ DIN 374	
HSS-E-PM				
Cb	S	Cb	S	Cb
N	N	N	N	N
C	C	C	C	C
6HX	6GX	6GX	6HX	6GX
right-hand	right-hand	right-hand	right-hand	right-hand
103	103	103	103	103
814	814	814	814	814

Availability				
●	●	●		
●	○	●		
	●			
			○	○
			●	
			●	○
			○	
			●	
			●	●
			○	
			●	○
			○	
			○	●
			●	○
			●	

C TiCN Cb Carbo D Cristall F FIRE/nanoFIRE P AlCrN S TiN S+ TiN+ M MolyGlide Y Signum

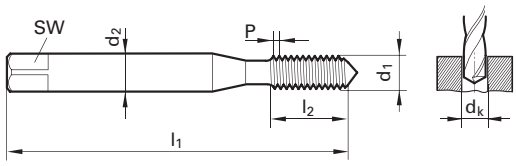
Guhring no.	929	928
Standard	DIN 2174	
Standard	~ DIN 374	
Tool material	HSS-E	
Surface	S	S
Type	N	N
Form	C	C
Tolerance	6HX	6GX
Cutting direction	right-hand	right-hand
Discount group	103	103
Techn. data page	814	814



d1 X P	d2	SW	dk	l1	l2	Code no.	Availability	
	mm		mm	mm	mm			
M 8 X1	6.000	4.90	7.550	90.00	17.00	8.005	●	●
M10 X1	7.000	5.50	9.550	90.00	17.00	10.005	●	
M12 X1,5	9.000	7.00	11.300	100.00	20.00	12.007		●
M14 X1	11.000	9.00	13.550	100.00	20.00	14.005	●	❍
M16 X1,5	12.000	9.00	15.300	100.00	22.00	16.007		❍
M18 X1	14.000	11.00	17.550	110.00	25.00	18.005	●	❍
M18 X1,5	14.000	11.00	17.300	110.00	25.00	18.007	●	●
M20 X1	16.000	12.00	19.550	125.00	25.00	20.005	❍	
M20 X1,5	16.000	12.00	19.300	125.00	25.00	20.007	●	
M22 X1,5	18.000	14.50	21.300	125.00	25.00	22.007	❍	
M24 X1,5	18.000	14.50	23.300	140.00	28.00	24.007	❍	

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

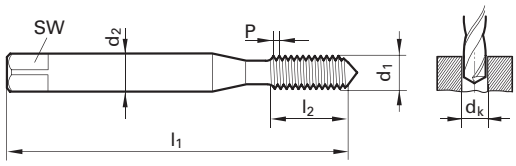
Guhring no.	2273	2274
Standard	DIN 2184-1	
Standard	~ DIN 371	~ DIN 376
Tool material	HSS-E	
Surface	S	S
Type	N	N
Form	C	C
Tolerance	2BX	2BX
Cutting direction	right-hand	right-hand
Discount group	103	103
Techn. data page	814	814



d1 - P	d2	SW	dk	l1	l2	Code no.	Availability	
	mm		mm	mm	mm			
NR.10 -24	6.000	4.90	4.350	70.00	14.00	4.826	●	
NR.12 -24	6.000	4.90	5.000	80.00	16.00	5.486	●	
1/4 -20	7.000	5.50	5.750	80.00	16.00	6.350	●	
5/16-18	8.000	6.20	7.300	90.00	18.00	7.938	●	
3/8 -16	10.000	8.00	8.800	100.00	20.00	9.525	●	
7/16-14	8.000	6.20	10.300	100.00	22.00	11.113		●
1/2 -13	9.000	7.00	11.800	110.00	25.00	12.700		●
9/16-12	11.000	9.00	13.300	110.00	30.00	14.288		●
5/8 -11	12.000	9.00	14.800	110.00	30.00	15.875		❍
3/4 -10	14.000	11.00	17.900	125.00	33.00	19.050		●
7/8 - 9	18.000	14.50	21.000	140.00	35.00	22.225		❍

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

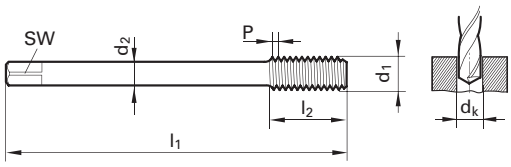
Guhring no.	1283
Standard	DIN 2184-1
Standard	~ DIN 371
Tool material	HSS-E
Surface	S
Type	N
Form	C
Tolerance	2BX
Cutting direction	right-hand
Discount group	103
Techn. data page	814



d1 - P	d2	SW	dk	l1	l2	Code no.	Availability
	mm		mm	mm	mm		
NR.10 -32	6.000	4.90	4.450	70.00	14.00	4.826	●
NR.12 -28	6.000	4.90	5.100	80.00	16.00	5.486	●
1/4 -28	7.000	5.50	5.950	80.00	16.00	6.350	❍
5/16-24	8.000	6.20	7.450	90.00	18.00	7.938	●
3/8 -24	10.000	8.00	9.050	90.00	18.00	9.525	❍

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

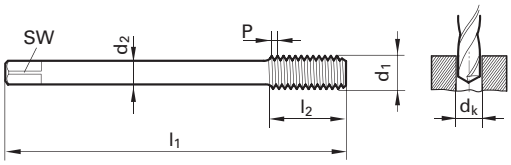
Guhring no.	2275
Standard	DIN 2184-1
Standard	~ DIN 374
Tool material	HSS-E
Surface	S
Type	N
Form	C
Tolerance	2BX
Cutting direction	right-hand
Discount group	103
Techn. data page	814



d1 - P	d2	SW	dk	l1	l2	Code no.	Availability
	mm		mm	mm	mm		
NR.10 -32	3.500	2.70	4.450	70.00	14.00	4.826	●
NR.12 -28	4.000	3.00	5.100	80.00	16.00	5.486	●
1/4 -28	4.500	3.40	5.950	80.00	16.00	6.350	●
5/16-24	6.000	4.90	7.450	90.00	18.00	7.938	❍
3/8 -24	7.000	5.50	9.050	90.00	18.00	9.525	❍
7/16-20	8.000	6.20	10.550	100.00	22.00	11.113	●
5/8 -18	12.000	9.00	15.250	100.00	22.00	15.875	●
3/4 -16	14.000	11.00	18.350	110.00	25.00	19.050	●
7/8 -14	18.000	14.50	21.400	125.00	25.00	22.225	●
1 -12	18.000	14.50	24.450	140.00	28.00	25.400	●

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

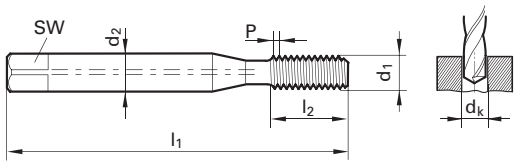
Guhring no.	966
Standard	DIN 2184-1
Standard	DIN 2189
Tool material	HSS-E
Surface	S
Type	N
Form	C
Tolerance	
Cutting direction	right-hand
Discount group	103
Techn. data page	814



d1	P	d2	SW	dk	l1	l2	Code no.	Availability
	G/inch	mm		mm	mm	mm		
G 1/8	28.00	7.000	5.50	9.300	90.00	18.00	9.728	●
G 1/4	19.00	11.000	9.00	12.500	100.00	20.00	13.157	●
G 3/8	19.00	12.000	9.00	16.000	100.00	22.00	16.662	●
G 1/2	14.00	16.000	12.00	20.000	125.00	25.00	20.955	●
G 3/4	14.00	20.000	16.00	25.500	140.00	28.00	26.441	●
G1 1/4	11.00	32.000	24.00	40.750	170.00	30.00	41.910	❍

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

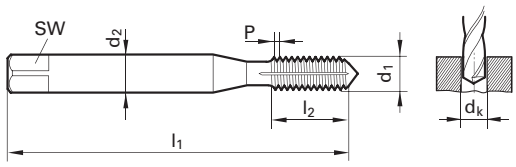
Guhring no.	2518
Standard	DIN 2174
Standard	~ DIN 371
Tool material	Solid carbide
Surface	S
Type	N
Form	C
Tolerance	6HX
Cutting direction	right-hand
Discount group	103
Techn. data page	814



d1	P	d2	SW	dk	l1	l2	Availability
	mm	mm		mm	mm	mm	
M 5	0.80	6.000	4.90	4.650	70.00	8.50	●
M 6	1.00	6.000	4.90	5.550	80.00	11.00	●
M 8	1.25	8.000	6.20	7.400	90.00	14.00	●
M10	1.50	10.000	8.00	9.300	100.00	16.00	●
M12	1.75	9.000	7.00	11.200	110.00	18.50	●
M16	2.00	12.000	9.00	15.100	110.00	20.00	●

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

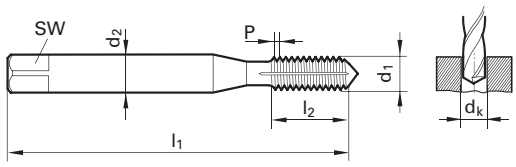
Guhring no.	322	339
Standard	DIN 2174	
Standard	~ DIN 371	~ DIN 376
Tool material	HSS-E-PM	
Surface	S	S
Type	N	N
Form	C	C
Tolerance	6HX	6HX
Cutting direction	right-hand	right-hand
Discount group	103	103
Techn. data page	813	813



d1	P	d2	SW	dk	l1	l2	Availability	
	mm	mm		mm	mm	mm		
M 3	0.50	3.500	2.70	2.800	56.00	6.00	●	
M 4	0.70	4.500	3.40	3.700	63.00	7.50	●	
M 5	0.80	6.000	4.90	4.650	70.00	8.50	●	
M 6	1.00	6.000	4.90	5.550	80.00	11.00	●	
M 8	1.25	8.000	6.20	7.400	90.00	14.00	●	
M10	1.50	10.000	8.00	9.300	100.00	16.00	●	
M12	1.75	9.000	7.00	11.200	110.00	18.50		●
M14	2.00	11.000	9.00	13.100	110.00	20.00		●
M16	2.00	12.000	9.00	15.100	110.00	20.00		●

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

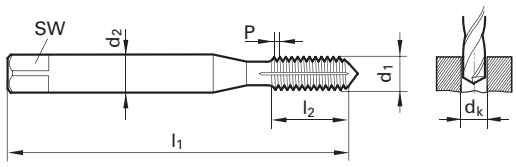
Guhring no.	**2012**
Standard	**DIN 2174**
Standard	**~ DIN 371**
Tool material	**HSS-E**
Surface	C
Type	**N**
Form	**C**
Tolerance	**6HX**
Cutting direction	**right-hand**
Discount group	**103**
Techn. data page	**812**



d1	P	d2	SW	dk	l1	l2	Availability
	mm	mm		mm	mm	mm	
M 3	0.50	3.500	2.70	2.800	56.00	10.00	●
M 4	0.70	4.500	3.40	3.700	63.00	12.00	●
M 5	0.80	6.000	4.90	4.650	70.00	14.00	●
M 6	1.00	6.000	4.90	5.550	80.00	16.00	●
M 8	1.25	8.000	6.20	7.400	90.00	17.00	●
M10	1.50	10.000	8.00	9.300	100.00	20.00	●

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

Guhring no.	919	1587	918	1588
Standard	DIN 2174			
Standard	~ DIN 371			
Tool material	HSS-E			
Surface	S	P	S	P
Type	N	N	N	N
Form	C	C	C	C
Tolerance	6HX	6HX	6GX	6GX
Cutting direction	right-hand	right-hand	right-hand	right-hand
Discount group	103	103	103	103
Techn. data page	812	812	812	812



d1	P	d2	SW	dk	l1	l2	919	1587	918	1588
	mm	mm		mm	mm	mm	Availability			
M 3	0.50	3.500	2.70	2.800	56.00	10.00	●	●	●	●
M 3,5	0.60	4.000	3.00	3.250	56.00	12.00	●		●	
M 4	0.70	4.500	3.40	3.700	63.00	12.00	●	●	●	●
M 5	0.80	6.000	4.90	4.650	70.00	14.00	●	●	●	●
M 6	1.00	6.000	4.90	5.550	80.00	16.00	●	●	●	●
M 8	1.25	8.000	6.20	7.400	90.00	17.00	●	●	●	●
M10	1.50	10.000	8.00	9.300	100.00	20.00	●	●	●	●
M12	1.75	9.000	7.00	11.200	110.00	24.00				
M14	2.00	11.000	9.00	13.100	110.00	26.00				
M16	2.00	12.000	9.00	15.100	110.00	26.00				
M18	2.50	14.000	11.00	16.900	125.00	30.00				
M20	2.50	16.000	12.00	18.900	140.00	32.00				

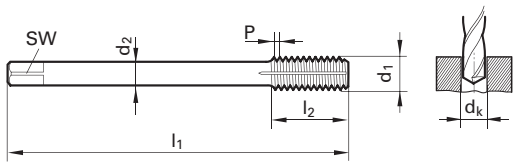
○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

1266	1599	1705	2013	1590	1267	1707	1708
DIN 2174							
	~ DIN 371				~ DIN 376		
HSS-E-PM			HSS-E		HSS-E-PM		
S	P	P	C	P	S	P	P
N	N	N	N	N	N	N	N
C	C	C	C	C	C	C	C
6HX	6HX	6GX	6HX	6GX	6HX	6HX	6GX
right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand
103	103	103	103	103	103	103	103
813	813	813	812	812	813	813	813

Availability							
●	●	○					
●	●	●					
●	●	●					
●	●	●					
●	●	●					
			●	●	●	●	●
				●	○	○	●
			●	○	●	●	○
					●		
			●	○	●	○	○

C TiCN Cb Carbo D Cristall F FIRE/nanoFIRE P AlCrN S TiN S+ TiN+ M MolyGlide Y Signum

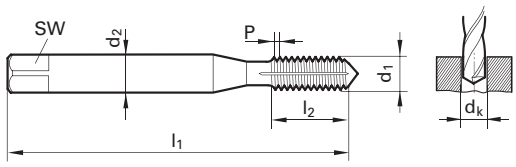
Guhring no.	923	1589	922
Standard	DIN 2174		
Standard	~ DIN 376		
Tool material	HSS-E		
Surface	S	P	S
Type	N	N	N
Form	C	C	C
Tolerance	6HX	6HX	6GX
Cutting direction	right-hand	right-hand	right-hand
Discount group	103	103	103
Techn. data page	812	812	812



d1	P	d2	SW	dk	l1	l2	Availability		
	mm	mm		mm	mm	mm			
M 6	1.00	4.500	3.40	5.550	80.00	16.00	●	●	●
M 8	1.25	6.000	4.90	7.400	90.00	17.00	●	●	●
M10	1.50	7.000	5.50	9.300	100.00	20.00	●	●	●
M12	1.75	9.000	7.00	11.200	110.00	24.00	●	●	●
M14	2.00	11.000	9.00	13.100	110.00	26.00	●	●	●
M16	2.00	12.000	9.00	15.100	110.00	26.00	●	●	●
M18	2.50	14.000	11.00	16.900	125.00	30.00	●		
M20	2.50	16.000	12.00	18.900	140.00	32.00	●	●	●
M22	2.50	18.000	14.50	20.900	140.00	27.00	●		
M24	3.00	18.000	14.50	22.700	160.00	30.00	●		
M27	3.00	20.000	16.00	25.700	160.00	30.00	●		
M30	3.50	22.000	18.00	28.500	180.00	35.00	●		
M33	3.50	25.000	20.00	31.500	180.00	35.00	●		
M36	4.00	28.000	22.00	34.300	200.00	40.00	●		
M39	4.00	32.000	24.00	37.300	200.00	40.00	●		

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

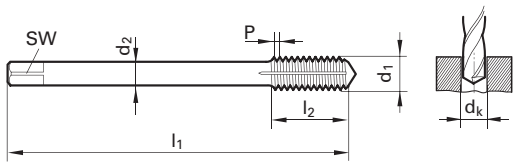
Guhring no.	**1284**
Standard	**DIN 2174**
Standard	**~ DIN 371**
Tool material	**HSS-E-PM**
Surface	**S**
Type	**N**
Form	**C**
Tolerance	**6HX**
Cutting direction	**right-hand**
Discount group	**103**
Techn. data page	**813**

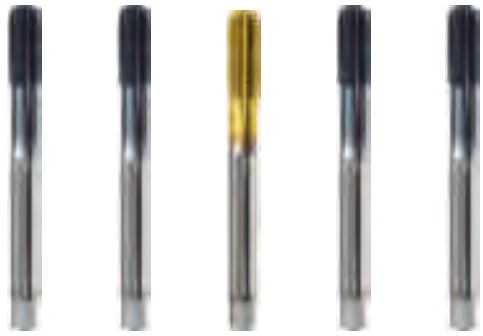


d1 X P	d2	SW	dk	l1	l2	Code no.	Availability
	mm		mm	mm	mm		
M 6 X0,75	6.000	4.90	5.650	80.00	8.00	6.004	●
M 8 X0,75	8.000	6.20	7.650	80.00	8.00	8.004	❍
M 8 X1	8.000	6.20	7.550	90.00	11.00	8.005	❍
M10 X1,25	10.000	8.00	9.400	100.00	14.00	10.006	●

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

Guhring no.	1593	1594	1269	1711	1712
Standard	DIN 2174				
Standard	~ DIN 374				
Tool material	HSS-E		HSS-E-PM		
Surface	P	P	S	P	P
Type	N	N	N	N	N
Form	C	C	C	C	C
Tolerance	6HX	6GX	6HX	6HX	6GX
Cutting direction	right-hand	right-hand	right-hand	right-hand	right-hand
Discount group	103	103	103	103	103
Techn. data page	812	812	813	813	813

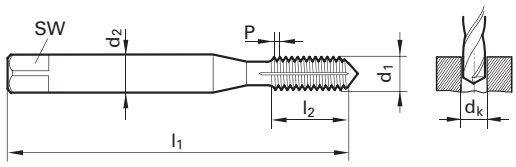




d1 X P	d2	SW	dk	l1	l2	Code no.	Availability				
	mm		mm	mm	mm						
M12 X1	9.000	7.00	11.550	100.00	20.00	12.005	❍	❍	❍	❍	❍
M12 X1,25	9.000	7.00	11.400	100.00	20.00	12.006	❍	●	●		●
M12 X1,5	9.000	7.00	11.300	100.00	20.00	12.007	❍		❍	●	●
M14 X1	11.000	9.00	13.550	100.00	20.00	14.005			●		
M14 X1,25	11.000	9.00	13.400	100.00	20.00	14.006			●		
M14 X1,5	11.000	9.00	13.300	100.00	20.00	14.007	●		●	●	
M16 X1	12.000	9.00	15.550	100.00	22.00	16.005			❍		
M16 X1,5	12.000	9.00	15.300	100.00	22.00	16.007	●	●	❍	❍	●
M18 X1,5	14.000	11.00	17.300	110.00	25.00	18.007	❍		●	●	●
M20 X1	16.000	12.00	19.550	125.00	25.00	20.005			●		
M20 X1,5	16.000	12.00	19.300	125.00	25.00	20.007			❍	❍	❍
M22 X1,5	18.000	14.50	21.300	125.00	25.00	22.007			●		
M24 X1,5	18.000	14.50	23.300	140.00	28.00	24.007	❍	●	●	❍	❍
M24 X2	18.000	14.50	23.100	140.00	28.00	24.008			❍		

○ bright ◐ steam tempered ◒ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

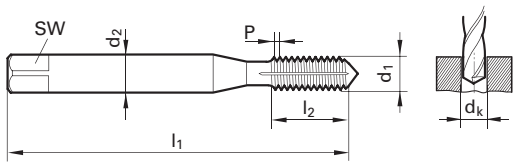
Guhring no.	1275	1591	1277	1592	1268
Standard	DIN 2174				
Standard	~ DIN 371				
Tool material	HSS-E				HSS-E-PM
Surface	S	P	S	P	S
Type	N	N	N	N	N
Form	C	C	C	C	C
Tolerance	6HX	6HX	6GX	6GX	6HX
Cutting direction	right-hand	right-hand	right-hand	right-hand	right-hand
Discount group	103	103	103	103	103
Techn. data page	812	812	812	812	813



d1 X P	d2	SW	dk	l1	l2	Code no.	Availability				
	mm		mm	mm	mm						
M 6 X0,75	6.000	4.90	5.650	80.00	13.00	6.004	●				
M 8 X0,75	8.000	6.20	7.650	80.00	14.00	8.004	●				
M 8 X1	8.000	6.20	7.550	90.00	17.00	8.005	●	●	●	❍	●
M 9 X1	9.000	7.00	8.550	90.00	17.00	9.005					●
M10 X1	10.000	8.00	9.550	90.00	17.00	10.005	●	●	●	●	❍
M10 X1,25	10.000	8.00	9.400	100.00	20.00	10.006	●				●

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

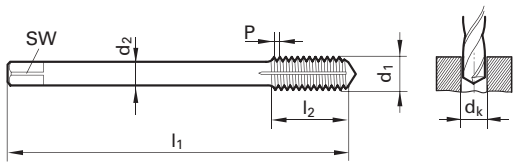
Guhring no.	1710
Standard	DIN 2174
Standard	~ DIN 371
Tool material	HSS-E-PM
Surface	P
Type	N
Form	C
Tolerance	6GX
Cutting direction	right-hand
Discount group	103
Techn. data page	813



d1 X P	d2	SW	dk	l1	l2	Code no.	Availability
	mm		mm	mm	mm		
M 8 X1	8.000	6.20	7.550	90.00	17.00	8.005	●
M10 X1	10.000	8.00	9.550	90.00	17.00	10.005	●

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

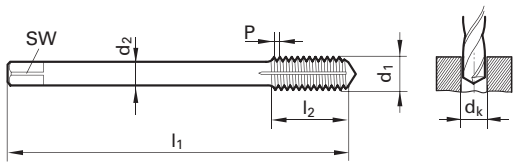
Guhring no.	**333**
Standard	**DIN 2174**
Standard	**~ DIN 374**
Tool material	**HSS-E-PM**
Surface	**S**
Type	**N**
Form	**C**
Tolerance	**6HX**
Cutting direction	**right-hand**
Discount group	**103**
Techn. data page	**813**



d1 X P	d2	SW	dk	l1	l2	Code no.	Availability
	mm		mm	mm	mm		
M 8 X1	6.000	4.90	7.550	90.00	11.00	8.005	❍
M10 X1	7.000	5.50	9.550	90.00	11.00	10.005	●
M12 X1	9.000	7.00	11.550	100.00	11.00	12.005	❍
M12 X1,5	9.000	7.00	11.300	100.00	16.00	12.007	●
M14 X1,5	11.000	9.00	13.300	100.00	15.00	14.007	❍
M16 X1,5	12.000	9.00	15.300	100.00	15.00	16.007	●
M18 X1,5	14.000	11.00	17.300	110.00	16.00	18.007	❍
M20 X1,5	16.000	12.00	19.300	125.00	16.00	20.007	❍

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

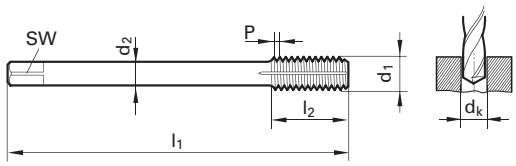
Guhring no.	927	2008	926
Standard	DIN 2174		
Standard	~ DIN 374		
Tool material	HSS-E		
Surface	S	C	S
Type	N	N	N
Form	C	C	C
Tolerance	6HX	6HX	6GX
Cutting direction	right-hand	right-hand	right-hand
Discount group	103	103	103
Techn. data page	812	812	812



d1 X P	d2	SW	dk	l1	l2	Code no.	Availability		
	mm		mm	mm	mm				
M 6 X0,75	4.500	3.40	5.650	80.00	13.00	6.004	●	❍	
M 8 X0,75	6.000	4.90	7.650	80.00	14.00	8.004	●	❍	
M 8 X1	6.000	4.90	7.550	90.00	17.00	8.005	●	❍	●
M10 X1	7.000	5.50	9.550	90.00	17.00	10.005	●		●
M10 X1,25	7.000	5.50	9.400	100.00	20.00	10.006	●	❍	
M12 X1	9.000	7.00	11.550	100.00	20.00	12.005	●	●	●
M12 X1,25	9.000	7.00	11.400	100.00	20.00	12.006	●		
M12 X1,5	9.000	7.00	11.300	100.00	20.00	12.007	●	❍	●
M14 X1	11.000	9.00	13.550	100.00	20.00	14.005	●		
M14 X1,5	11.000	9.00	13.300	100.00	20.00	14.007	●		●
M16 X1	12.000	9.00	15.550	100.00	22.00	16.005	●		❍
M16 X1,5	12.000	9.00	15.300	100.00	22.00	16.007	●	●	●
M18 X1	14.000	11.00	17.550	110.00	25.00	18.005	●		
M18 X1,5	14.000	11.00	17.300	110.00	25.00	18.007	●	●	●
M20 X1	16.000	12.00	19.550	125.00	25.00	20.005	●		
M20 X1,5	16.000	12.00	19.300	125.00	25.00	20.007	●	❍	●
M22 X1,5	18.000	14.50	21.300	125.00	25.00	22.007	●		●
M24 X1,5	18.000	14.50	23.300	140.00	28.00	24.007	●		

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

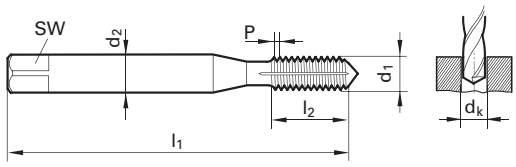
Guhring no.	1583	1582
Standard	DIN 2184-1	
Standard	~ DIN 376	~ DIN 371
Tool material	HSS-E	
Surface	S	S
Type	N	N
Form	C	C
Tolerance	2BX	2BX
Cutting direction	right-hand	right-hand
Discount group	103	103
Techn. data page	812	812



d1 - P	d2	SW	dk	l1	l2	Code no.	Availability
	mm		mm	mm	mm		
NR. 4 -40	3.500	2.70	2.550	56.00	11.00	2.845	●
NR. 5 -40	3.500	2.70	2.900	56.00	11.00	3.175	●
NR. 6 -32	4.000	3.00	3.150	56.00	12.00	3.505	●
NR. 8 -32	4.500	3.40	3.800	63.00	13.00	4.166	●
NR.10 -24	6.000	4.90	4.350	70.00	14.00	4.826	●
NR.12 -24	6.000	4.90	5.000	80.00	16.00	5.486	○
1/4 -20	7.000	5.50	5.750	80.00	16.00	6.350	●
5/16-18	8.000	6.20	7.300	90.00	18.00	7.938	●
3/8 -16	10.000	8.00	8.800	100.00	20.00	9.525	●
1/2 -13	9.000	7.00	11.800	110.00	25.00	12.700	●
9/16-12	11.000	9.00	13.300	110.00	30.00	14.288	●
5/8 -11	12.000	9.00	14.800	110.00	30.00	15.875	●
3/4 -10	14.000	11.00	17.900	125.00	33.00	19.050	●

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

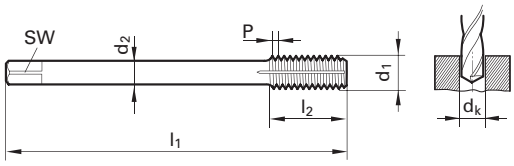
Guhring no.	1584	1585
Standard	DIN 2184-1	
Standard	~ DIN 371	~ DIN 374
Tool material	HSS-E	
Surface	S	S
Type	N	N
Form	C	C
Tolerance	2BX	2BX
Cutting direction	right-hand	right-hand
Discount group	103	103
Techn. data page	812	812



d1 - P	d2	SW	dk	l1	l2	Code no.	Availability	
	mm		mm	mm	mm			
NR. 4 -48	3.500	2.70	2.600	56.00	10.00	2.845	●	
NR. 5 -44	3.500	2.70	2.900	56.00	10.00	3.175	●	
NR. 6 -40	4.000	3.00	3.200	56.00	11.00	3.505	●	
NR. 8 -36	4.500	3.40	3.850	63.00	12.00	4.166	●	
NR.10 -32	6.000	4.90	4.450	70.00	14.00	4.826	●	
NR.12 -28	6.000	4.90	5.100	80.00	16.00	5.486	●	
1/4 -28	7.000	5.50	5.950	80.00	16.00	6.350	●	
5/16-24	8.000	6.20	7.450	90.00	18.00	7.938	●	
3/8 -24	10.000	8.00	9.050	90.00	18.00	9.525	●	
7/16-20	8.000	6.20	10.550	100.00	22.00	11.113		●
1/2 -20	9.000	7.00	12.100	100.00	20.00	12.700		○
9/16-18	11.000	9.00	13.650	100.00	22.00	14.288		●
5/8 -18	12.000	9.00	15.250	100.00	22.00	15.875		●
3/4 -16	14.000	11.00	18.350	110.00	25.00	19.050		●

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

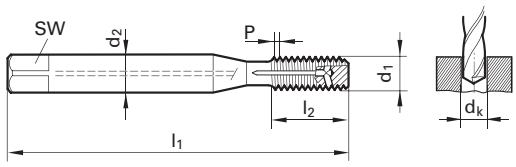
Guhring no.	**1586**
Standard	**DIN 2184-1**
Standard	**DIN 2189**
Tool material	**HSS-E**
Surface	S
Type	**N**
Form	**C**
Tolerance	
Cutting direction	**right-hand**
Discount group	**103**
Techn. data page	**812**



d1	P	d2	SW	dk	l1	l2	Code no.	Availability
	G/inch	mm		mm	mm	mm		
G 1/16	28.00	6.000	4.90	7.300	90.00	18.00	7.723	●
G 1/8	28.00	7.000	5.50	9.300	90.00	18.00	9.728	●
G 1/4	19.00	11.000	9.00	12.500	100.00	20.00	13.157	●
G 3/8	19.00	12.000	9.00	16.000	100.00	22.00	16.662	●
G 1/2	14.00	16.000	12.00	20.000	125.00	25.00	20.955	●
G 3/4	14.00	20.000	16.00	25.500	140.00	28.00	26.441	●

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

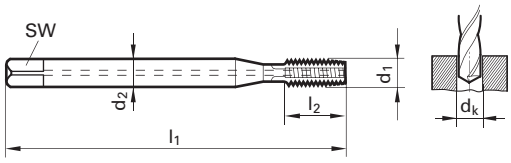
Guhring no.	1927	1972
Standard	DIN 2174	
Standard	~ DIN 371	
Tool material	Solid carbide	
Surface	A	A
Type	N	N
Form	E	C
Tolerance	6HX	6HX
Cutting direction	right-hand	right-hand
Discount group	103	103
Techn. data page	813	813



d1	P	d2	SW	dk	l1	l2	Availability	
	mm	mm		mm	mm	mm		
M 3	0.50	3.500	2.70	2.800	56.00	6.00	○	●
M 4	0.70	4.500	3.40	3.700	63.00	7.50	●	●
M 5	0.80	6.000	4.90	4.650	70.00	8.50	●	●
M 6	1.00	6.000	4.90	5.550	80.00	11.00	●	●
M 8	1.25	8.000	6.20	7.400	90.00	14.00	●	●
M10	1.50	10.000	8.00	9.300	100.00	16.00	●	●

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

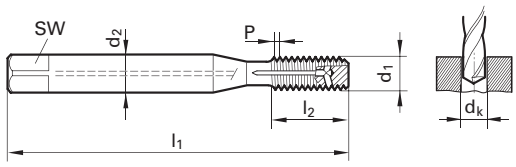
Guhring no.	4146	2442	2446	2515	2443
Standard	DIN 2174				
Standard	~ DIN 371				
Tool material	HSS-E				
Surface	Cb	S	C	Cb	S
Type	N	N	N	N	N
Form	C	C	C	C	C
Tolerance	6GX	6HX	6HX	6HX	6GX
Cutting direction	right-hand	right-hand	right-hand	right-hand	right-hand
Discount group	103	103	103	103	103
Techn. data page	813	812	812	813	812
	NEW				



d1	P	d2	SW	dk	l1	l2	Availability				
	mm	mm		mm	mm	mm					
M 5	0.80	6.000	4.90	4.650	70.00	8.50	●	●	●	●	❍
M 6	1.00	6.000	4.90	5.550	80.00	11.00	●	●	●	●	●
M 8	1.25	8.000	6.20	7.400	90.00	14.00	●	●	●	●	●
M10	1.50	10.000	8.00	9.300	100.00	16.00	●	●	●	●	●
M12	1.75	9.000	7.00	11.200	110.00	18.50	●			●	
M16	2.00	12.000	9.00	15.100	110.00	20.00	●			●	
M20	2.50	16.000	12.00	18.900	140.00	25.00	●			●	

C TiCN Cb Carbo D Cristall F FIRE/nanoFIRE P AlCrN S TiN S+ TiN+ M MolyGlide Y Signum

Guhring no.	2447	323
Standard	DIN 2174	
Standard	~ DIN 371	
Tool material	HSS-E	HSS-E-PM
Surface	C	S+
Type	N	N
Form	C	C
Tolerance	6GX	6HX
Cutting direction	right-hand	right-hand
Discount group	103	103
Techn. data page	812	813



d1	P	d2	SW	dk	l1	l2	Availability	
	mm	mm		mm	mm	mm		
M 5	0.80	6.000	4.90	4.650	70.00	8.50	○	●
M 6	1.00	6.000	4.90	5.550	80.00	11.00	●	●
M 8	1.25	8.000	6.20	7.400	90.00	14.00	○	●
M10	1.50	10.000	8.00	9.300	100.00	16.00	●	●
M12	1.75	9.000	7.00	11.200	110.00	18.50		
M14	2.00	11.000	9.00	13.100	110.00	20.00		
M16	2.00	12.000	9.00	15.100	110.00	20.00		
M18	2.50	14.000	11.00	16.900	125.00	25.00		
M20	2.50	16.000	12.00	18.900	140.00	25.00		

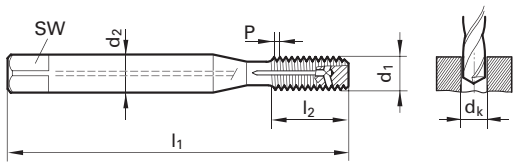
○ bright ● steam tempered ◒ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

1931	2444	2448	2445	342
DIN 2174				
~ DIN 376				
Solid carbide	HSS-E			HSS-E-PM
A	S	C	S	S+
N	N	N	N	N
C	C	C	C	C
6HX	6HX	6HX	6GX	6HX
right-hand	right-hand	right-hand	right-hand	right-hand
103	103	103	103	103
813	812	812	812	813

Availability				
●	●	●	●	●
●	●	○	○	●
●	●	●	○	●
○				
○				

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

Guhring no.	1725	1270	1717	1726
Standard	DIN 2174			
Standard	~ DIN 371			
Tool material	HSS-E-PM			
Surface	S	C	A	S
Type	N	N	N	N
Form	E	C	C	E
Tolerance	6HX	6HX	6HX	6GX
Cutting direction	right-hand	right-hand	right-hand	right-hand
Discount group	103	103	103	103
Techn. data page	813	813	813	813



d1	P	d2	SW	dk	l1	l2	1725	1270	1717	1726
	mm	mm		mm	mm	mm	Availability			
M 3	0.50	3.500	2.70	2.800	56.00	10.00	●			❍
M 4	0.70	4.500	3.40	3.700	63.00	12.00	●			❍
M 5	0.80	6.000	4.90	4.650	70.00	14.00	●	●	●	❍
M 6	1.00	6.000	4.90	5.550	80.00	16.00	●	●	●	
M 8	1.25	8.000	6.20	7.400	90.00	17.00	●	●	●	●
M10	1.50	10.000	8.00	9.300	100.00	20.00	●	●	●	●
M12	1.75	9.000	7.00	11.200	110.00	24.00				
M14	2.00	11.000	9.00	13.100	110.00	26.00				
M16	2.00	12.000	9.00	15.100	110.00	26.00				
M18	2.50	14.000	11.00	16.900	125.00	30.00				
M20	2.50	16.000	12.00	18.900	140.00	32.00				

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

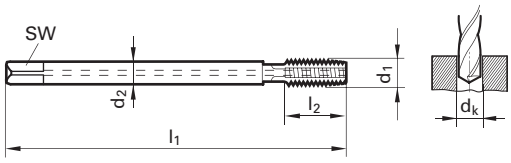
1713	1718	1727	1271	1719	1728	1714	1720
DIN 2174							
~ DIN 371				~ DIN 376			
HSS-E-PM							
C	A	S	C	A	S	C	A
N	N	N	N	N	N	N	N
C	C	E	C	C	E	C	C
6GX	6GX	6HX	6HX	6HX	6GX	6GX	6GX
right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand	right-hand
103	103	103	103	103	103	103	103
813	813	813	813	813	813	813	813

Availability							
●	○						
○	●						
●	●						
		●	●	●	●	●	●
		○	○	○	○	●	○
		○	●	●	○	●	●
			●				
		○	●	●	○	●	○

C TiCN Cb Carbo D Cristall F FIRE/nanoFIRE P AlCrN S TiN S+ TiN+ M MolyGlide Y Signum

Guhring no.	4143
Standard	
Standard	Guhring std.
Tool material	HSS-E-PM
Surface	S
Type	N
Form	C
Tolerance	6HX
Cutting direction	right-hand
Discount group	103
Techn. data page	813

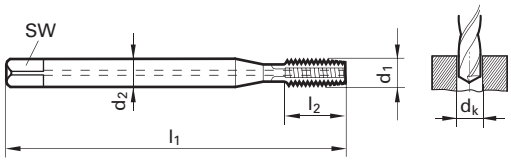
NEW



d1	P	d2	SW	dk	l1	l2	Availability
	mm	mm		mm	mm	mm	
M 3	0.50	3.500	2.70	2.800	112.00	6.00	●
M 4	0.70	2.800	2.10	3.700	112.00	7.50	●
M 5	0.80	3.500	2.70	4.650	125.00	8.50	●
M 6	1.00	4.500	3.40	5.550	125.00	11.00	●
M 8	1.25	6.000	4.90	7.400	140.00	14.00	●
M10	1.50	7.000	5.50	9.300	160.00	16.00	●
M12	1.75	9.000	7.00	11.200	180.00	18.50	●
M16	2.00	12.000	9.00	15.100	220.00	20.00	●
M20	2.50	16.000	12.00	18.900	280.00	25.00	●

bright · steam tempered · nitrided lands · nitrided · golden brown · TiAlN · TiAlN nanoA · TiAlN SuperA

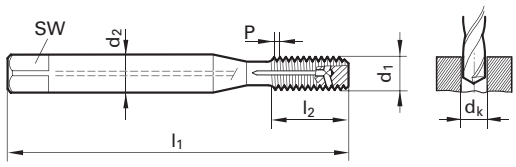
Guhring no.	4147	4151
Standard	DIN 2174	
Standard	~ DIN 371	
Tool material	HSS-E	
Surface	Cb	Cb
Type	N	N
Form	C	C
Tolerance	6HX	6GX
Cutting direction	right-hand	right-hand
Discount group	103	103
Techn. data page	813	813
	NEW	NEW



d1 X P	d2	SW	dk	l1	l2	Code no.	Availability	
	mm		mm	mm	mm			
M 8 X1	8.000	6.20	7.550	90.00	11.00	8.005	●	●
M10 X1	10.000	8.00	9.550	90.00	11.00	10.005	●	●
M10 X1,25	10.000	8.00	9.400	100.00	14.00	10.006	●	●
M12 X1	9.000	7.00	11.550	100.00	11.00	12.005	●	●
M12 X1,50	9.000	7.00	11.300	100.00	16.00	12.007	●	●
M14 X1,50	11.000	9.00	13.300	100.00	15.00	14.007	●	●
M16 X1,50	12.000	9.00	15.300	100.00	15.00	16.007	●	●

C TiCN Cb Carbo D Cristall F FIRE/nanoFIRE P AlCrN S TiN S+ TiN+ M MolyGlide Y Signum

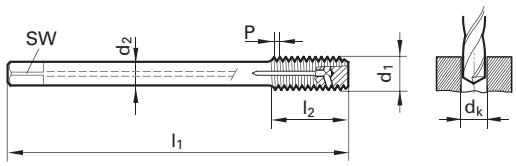
Guhring no.	1729
Standard	DIN 2174
Standard	~ DIN 371
Tool material	HSS-E-PM
Surface	S
Type	N
Form	E
Tolerance	6HX
Cutting direction	right-hand
Discount group	103
Techn. data page	813



d1 X P	d2	SW	dk	l1	l2	Code no.	Availability
	mm		mm	mm	mm		
M 8 X1	8.000	6.20	7.550	90.00	17.00	8.005	●
M10 X1,25	10.000	8.00	9.400	100.00	20.00	10.006	●

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

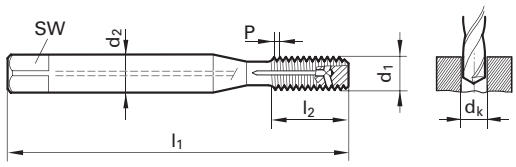
Guhring no.	1581
Standard	DIN 2174
Standard	~ DIN 371 / ~ DIN 376
Tool material	Solid carbide
Surface	A
Type	N
Form	C
Tolerance	6HX
Cutting direction	right-hand
Discount group	103
Techn. data page	813

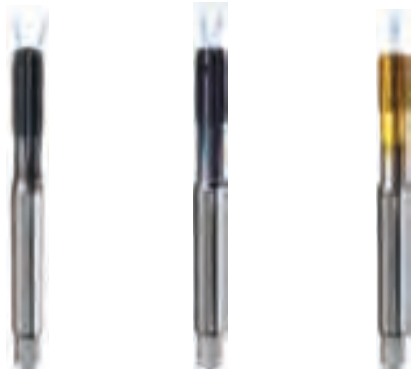


d1 X P	d2	SW	dk	l1	l2	Code no.	Availability
	mm		mm	mm	mm		
M10 X1	10.000	8.00	9.550	90.00	11.00	10.005	●
M12 X1	9.000	7.00	11.550	100.00	15.00	12.005	●
M12 X1,5	9.000	7.00	11.300	100.00	15.00	12.007	●
M14 X1	11.000	9.00	13.550	100.00	15.00	14.005	❍
M14 X1,25	11.000	9.00	13.400	100.00	15.00	14.006	❍
M14 X1,50	11.000	9.00	13.300	100.00	15.00	14.007	●
M16 X1,50	12.000	9.00	15.300	100.00	15.00	16.007	●
M18 X1,5	14.000	11.00	17.300	110.00	15.00	18.007	❍
M20 X1,5	16.000	12.00	19.300	125.00	15.00	20.007	●
M24 X1,5	18.000	14.50	23.300	140.00	15.00	24.007	❍

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

Guhring no.	1272	1721	1730
Standard	DIN 2174		
Standard	~ DIN 371		
Tool material	HSS-E-PM		
Surface	C	A	S
Type	N	N	N
Form	C	C	E
Tolerance	6HX	6HX	6GX
Cutting direction	right-hand	right-hand	right-hand
Discount group	103	103	103
Techn. data page	813	813	813





d1 X P	d2	SW	dk	l1	l2	Code no.	Availability		
	mm		mm	mm	mm				
M 8 X1	8.000	6.20	7.550	90.00	17.00	8.005	●	●	●
M 9 X1	9.000	7.00	8.550	90.00	17.00	9.005	●		
M10 X1	10.000	8.00	9.550	90.00	17.00	10.005	●	❍	❍
M10 X1,25	10.000	8.00	9.400	100.00	20.00	10.006	●	●	●
M12 X1	9.000	7.00	11.550	100.00	20.00	12.005			
M12 X1,25	9.000	7.00	11.400	100.00	20.00	12.006			
M12 X1,5	9.000	7.00	11.300	100.00	20.00	12.007			
M14 X1	11.000	9.00	13.550	100.00	20.00	14.005			
M14 X1,25	11.000	9.00	13.400	100.00	20.00	14.006			
M14 X1,5	11.000	9.00	13.300	100.00	20.00	14.007			
M16 X1	12.000	9.00	15.550	100.00	22.00	16.005			
M16 X1,5	12.000	9.00	15.300	100.00	22.00	16.007			
M18 X1,5	14.000	11.00	17.300	110.00	25.00	18.007			
M20 X1	16.000	12.00	19.550	125.00	25.00	20.005			
M20 X1,5	16.000	12.00	19.300	125.00	25.00	20.007			
M22 X1,5	18.000	14.50	21.300	125.00	25.00	22.007			
M24 X1,5	18.000	14.50	23.300	140.00	28.00	24.007			
M24 X2	18.000	14.50	23.100	140.00	28.00	24.008			

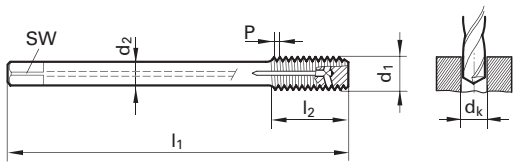
○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

1715	1731	1273	1723	1732	1716
DIN 2174					
~ DIN 371			~ DIN 374		
HSS-E-PM					
C	S	C	A	S	C
N	N	N	N	N	N
C	E	C	C	E	C
6GX	6HX	6HX	6HX	6GX	6GX
right-hand	right-hand	right-hand	right-hand	right-hand	right-hand
103	103	103	103	103	103
813	813	813	813	813	813

Availability					
●					
○					
●					
	○	●		●	○
	●	●	●	●	●
	●	●	●	○	●
		○			
		●			
	●	●	●	●	○
		○			
	○	●	●	●	○
	●	●	●	●	○
		○			
			●	○	○
		●			
	○	●	○	○	○
		○			

C TiCN Cb Carbo D Cristall F FIRE/nanoFIRE P AlCrN S TiN S+ TiN+ M MolyGlide Y Signum

Guhring no.	338
Standard	DIN 2174
Standard	~ DIN 374
Tool material	HSS-E-PM
Surface	S+
Type	N
Form	C
Tolerance	6HX
Cutting direction	right-hand
Discount group	103
Techn. data page	813

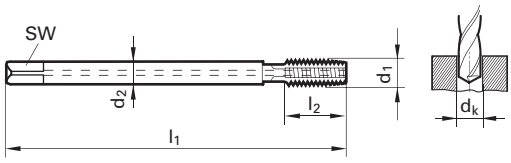


d1 X P	d2	SW	dk	l1	l2	Code no.	Availability
	mm		mm	mm	mm		
M 8 X1	6.000	4.90	7.550	90.00	11.00	8.005	●
M10 X1	7.000	5.50	9.550	90.00	11.00	10.005	●
M12 X1	9.000	7.00	11.550	100.00	11.00	12.005	◐
M12 X1,50	9.000	7.00	11.300	100.00	16.00	12.007	●
M14 X1,50	11.000	9.00	13.300	100.00	15.00	14.007	●
M16 X1,50	12.000	9.00	15.300	100.00	15.00	16.007	●

○ bright ◐ steam tempered ◒ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

Guhring no.	4145
Standard	
Standard	Guhring std.
Tool material	HSS-E-PM
Surface	S
Type	N
Form	C
Tolerance	6HX
Cutting direction	right-hand
Discount group	103
Techn. data page	813

NEW

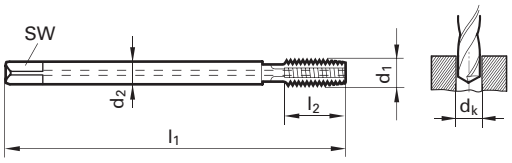


d1 X P	d2	SW	dk	l1	l2	Code no.	Availability
	mm		mm	mm	mm		
M 8 X1	6.000	4.90	7.550	140.00	14.00	8.005	●
M10 X1	7.000	5.50	9.550	160.00	16.00	10.005	●
M10 X1,25	7.000	5.50	9.400	160.00	16.00	10.006	●
M12 X1	9.000	7.00	11.550	180.00	18.50	12.005	●
M12 X1,50	9.000	7.00	11.300	180.00	18.50	12.007	●
M14 X1,50	11.000	9.00	13.300	220.00	20.00	14.007	●
M16 X1,50	12.000	9.00	15.300	220.00	20.00	16.007	●

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

Guhring no.	4152
Standard	
Standard	DIN 2189
Tool material	HSS-E
Surface	Cb
Type	N
Form	C
Tolerance	
Cutting direction	right-hand
Discount group	103
Techn. data page	813

NEW



d1	P	d2	SW	dk	l1	l2	Code no.	Availability
	G/inch	mm		mm	mm	mm		
G 1/16	28.00	6.000	4.90	7.300	90.00	11.00	7.723	●
G 1/8	28.00	7.000	5.50	9.300	90.00	11.00	9.728	●
G 1/4	19.00	11.000	9.00	12.500	100.00	14.00	13.157	●
G 3/8	19.00	12.000	9.00	16.000	100.00	14.00	16.662	●
G 1/2	14.00	16.000	12.00	20.000	125.00	18.00	20.955	●
G 3/4	14.00	20.000	16.00	25.500	140.00	20.00	26.441	●
G1	11.00	25.000	20.00	32.000	160.00	24.00	33.249	●

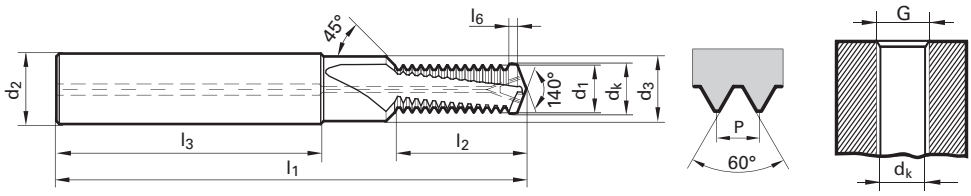
bright · steam tempered · nitrided lands · nitrided · golden brown · A TiAlN · a TiAlN nanoA · A TiAlN SuperA

GUHRING

SPECIAL TAPS

Do you require a tap in a special dimension and with a special thread type or tolerance? In addition to our standard catalogue range we provide special solutions tailored to your specific requirements on request!

Guhring no.	3774
Standard	Guhring std.
Tool material	Solid carbide
Carbide grade	K
Surface	○
Type	DTMC SP
Thread length	1,5xD
Cooling	
Shank design	HA
Cutting direction	right-hand
Discount group	108
Techn. data page	816



G	P	d1	d2	d3	dk	l1	l2	l3	l6	Z	Code no.	Availability
	mm	mm	mm	mm	mm	mm	mm	mm	mm			
M 3	0.50	2.400	6.000	3.400	2.500	48.00	5.50	36.00	0.50	2	3.000	●
M 4	0.70	3.200	6.000	4.500	3.300	48.00	6.90	36.00	0.70	2	4.000	●
M 5	0.80	4.000	6.000	5.500	4.200	54.00	8.80	36.00	0.80	2	5.000	❍
M 6	1.00	4.750	8.000	6.600	5.000	62.00	10.90	36.00	1.00	2	6.000	●
M 8	1.25	6.350	10.000	9.000	6.800	74.00	13.70	40.00	1.25	2	8.000	❍
M10	1.50	7.950	12.000	11.000	8.500	80.00	18.00	45.00	1.50	2	10.000	●
M12	1.75	9.950	14.000	13.500	10.200	90.00	20.90	45.00	1.50	2	12.000	❍
M14	2.00	11.200	16.000	15.500	12.000	102.00	23.70	48.00	1.50	2	14.000	
M16	2.00	13.200	18.000	17.500	14.000	102.00	26.00	48.00	1.50	2	16.000	❍

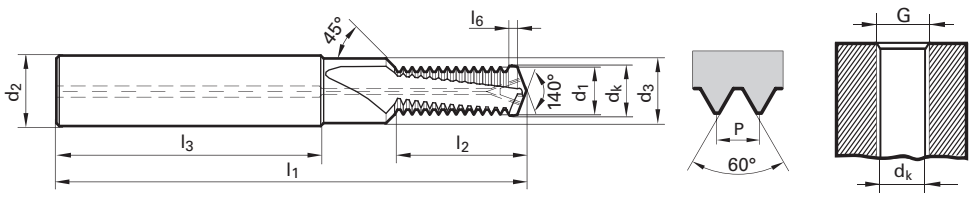
○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

3776	3775	3777
	Guhring std.	
	Solid carbide	
K/P	K	K/P
C	○	C
DTMC SP	DTMC SP	DTMC SP
1,5xD	1,5xD	1,5xD
	axial >=M4	axial >=M4
HA	HA	HA
right-hand	right-hand	right-hand
108	108	108
816	816	816

Availability		
○		
○	●	●
●	○	●
●	●	●
○	●	●
●	●	●
●	○	●
○	○	○
○	○	○

C TiCN Cb Carbo D Cristall F FIRE/nanoFIRE P AlCrN S TiN S+ TiN+ M MolyGlide Y Signum

Guhring no.	3778
Standard	Guhring std.
Tool material	Solid carbide
Carbide grade	K
Surface	○
Type	DTMC SP
Thread length	2xD
Cooling	
Shank design	HA
Cutting direction	right-hand
Discount group	108
Techn. data page	816



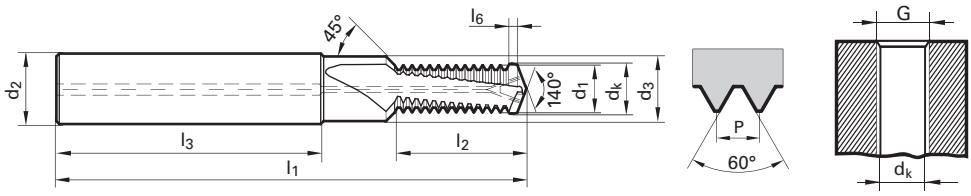
G	P	d1	d2	d3	dk	l1	l2	l3	l6	Z	Code no.	Availability
	mm	mm	mm	mm	mm	mm	mm	mm	mm			
M 3	0.50	2.400	6.000	3.400	2.500	48.00	7.00	36.00	0.50	2	3.000	❍
M 4	0.70	3.200	6.000	4.500	3.300	48.00	9.00	36.00	0.70	2	4.000	●
M 5	0.80	4.000	6.000	5.500	4.200	54.00	11.20	36.00	0.80	2	5.000	❍
M 6	1.00	4.750	8.000	6.600	5.000	62.00	13.90	36.00	1.00	2	6.000	●
M 8	1.25	6.350	10.000	9.000	6.800	74.00	18.70	40.00	1.25	2	8.000	●
M10	1.50	7.950	12.000	11.000	8.500	80.00	22.50	45.00	1.50	2	10.000	●
M12	1.75	9.950	14.000	13.500	10.200	90.00	26.10	45.00	1.50	2	12.000	●
M14	2.00	11.200	16.000	15.500	12.000	102.00	31.70	48.00	1.50	2	14.000	
M16	2.00	13.200	18.000	17.500	14.000	102.00	36.00	48.00	1.50	2	16.000	❍

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

3780	3779	3781
	Guhring std.	
	Solid carbide	
K/P	K	K/P
C	○	C
DTMC SP	DTMC SP	DTMC SP
2xD	2xD	2xD
	axial >=M4	axial >=M4
HA	HA	HA
right-hand	right-hand	right-hand
108	108	108
816	816	816
Availability		
●		
○	●	●
○	●	●
○	●	●
●	●	●
○	○	●
●	○	●
○	○	○
○	○	●

C TiCN Cb Carbo D Cristall F FIRE/nanoFIRE P AlCrN S TiN S+ TiN+ M MolyGlide Y Signum

Guhring no.	3782
Standard	Guhring std.
Tool material	Solid carbide
Carbide grade	K
Surface	○
Type	DTMC SP
Thread length	2,5xD
Cooling	
Shank design	HA
Cutting direction	right-hand
Discount group	108
Techn. data page	816



G	P	d1	d2	d3	dk	l1	l2	l3	l6	Z	Code no.	Availability
	mm	mm	mm	mm	mm	mm	mm	mm	mm			
M 3	0.50	2.400	6.000	3.400	2.500	48.00	8.50	36.00	0.50	2	3.000	
M 4	0.70	3.200	6.000	4.500	3.300	48.00	11.10	36.00	0.70	2	4.000	●
M 5	0.80	4.000	6.000	5.500	4.200	54.00	13.60	36.00	0.80	2	5.000	◐
M 6	1.00	4.750	8.000	6.600	5.000	62.00	16.90	36.00	1.00	2	6.000	●
M 8	1.25	6.350	10.000	9.000	6.800	74.00	22.50	40.00	1.25	2	8.000	
M10	1.50	7.950	12.000	11.000	8.500	80.00	27.00	45.00	1.50	2	10.000	●
M12	1.75	9.950	14.000	13.500	10.200	90.00	31.40	45.00	1.50	2	12.000	●
M14	2.00	11.200	16.000	15.500	12.000	102.00	39.70	48.00	1.50	2	14.000	
M16	2.00	13.200	18.000	17.500	14.000	102.00	46.00	48.00	1.50	2	16.000	◐

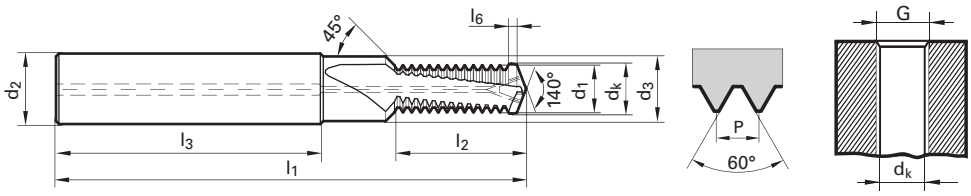
○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

3784	3783	3785
	Guhring std.	
	Solid carbide	
K/P	K	K/P
C		C
DTMC SP	DTMC SP	DTMC SP
2,5xD	2,5xD	2,5xD
	axial >=M4	axial >=M4
HA	HA	HA
right-hand	right-hand	right-hand
108	108	108
816	816	816

Availability		
○		
●	●	○
○	●	●
●	●	○
○	○	●
○	●	●
○	○	●
○		○
○	○	○

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

Guhring no.	3788
Standard	Guhring std.
Tool material	Solid carbide
Carbide grade	K/P
Surface	C
Type	DTMC SP
Thread length	1,5xD
Cooling	
Shank design	HA
Cutting direction	right-hand
Discount group	108
Techn. data page	816



G	d1	d2	d3	dk	l1	l2	l3	l6	Z	Code no.	Availability
	mm	mm	mm	mm	mm	mm	mm	mm	mm		
M 4 X0,5	3.200	6.000	4.500	3.500	48.00	6.60	36.00	0.50	2	4.003	○
M 5 X0,5	4.000	6.000	5.500	4.500	54.00	8.30	36.00	0.50	2	5.003	○
M 6 X0,75	4.750	8.000	6.600	5.200	62.00	9.90	36.00	0.75	2	6.004	●
M 8 X0,75	6.350	10.000	9.000	7.200	74.00	14.10	40.00	0.75	2	8.004	○
M 8 X1	6.350	10.000	9.000	7.000	74.00	14.30	40.00	1.00	2	8.005	○
M10 X1	7.950	12.000	11.000	9.000	80.00	16.60	45.00	1.00	2	10.005	○
M10 X1,25	7.950	12.000	11.000	8.800	80.00	16.60	45.00	1.25	2	10.006	○
M12 X1	9.950	14.000	13.500	11.000	90.00	20.00	45.00	1.00	2	12.005	○
M12 X1,5	9.950	14.000	13.500	10.500	90.00	21.40	45.00	1.50	2	12.007	○
M14 X1,5	11.200	16.000	15.500	12.500	102.00	23.30	48.00	1.50	2	14.007	○
M16 X1,5	13.200	18.000	17.500	14.500	102.00	26.60	48.00	1.50	2	16.007	○

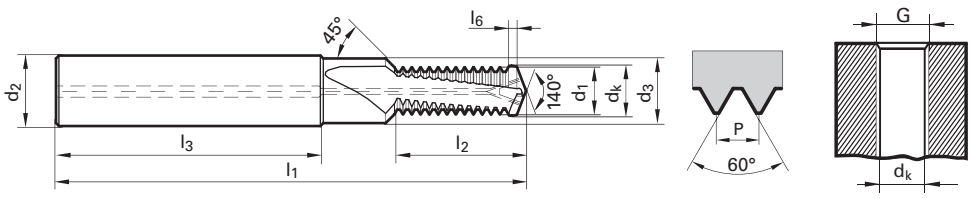
○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

3787	3789
Guhring std.	
Solid carbide	
K	K/P
○	C
DTMC SP	DTMC SP
1,5xD	1,5xD
axial	axial
HA	HA
right-hand	right-hand
108	108
816	816

Availability	
●	○
●	○
●	○
●	○
●	○
●	○
●	●
●	●
●	○

C TiCN Cb Carbo D Cristall F FIRE/nanoFIRE P AlCrN S TiN S+ TiN+ M MolyGlide Y Signum

Guhring no.	3790
Standard	Guhring std.
Tool material	Solid carbide
Carbide grade	K
Surface	◯
Type	DTMC SP
Thread length	2xD
Cooling	
Shank design	HA
Cutting direction	right-hand
Discount group	108
Techn. data page	816



G	d1	d2	d3	dk	l1	l2	l3	l6	Z	Code no.	Availability
	mm	mm	mm	mm	mm	mm	mm	mm	mm		
M 4 X0,5	3.200	6.000	4.500	3.500	48.00	8.60	36.00	0.50	2	4.003	❍
M 5 X0,5	4.000	6.000	5.500	4.500	54.00	10.80	36.00	0.50	2	5.003	❍
M 6 X0,75	4.750	8.000	6.600	5.200	62.00	12.90	36.00	0.75	2	6.004	❍
M 8 X0,75	6.350	10.000	9.000	7.200	74.00	17.10	40.00	0.75	2	8.004	❍
M 8 X1	6.350	10.000	9.000	7.000	74.00	17.30	40.00	1.00	2	8.005	❍
M10 X1	7.950	12.000	11.000	9.000	80.00	21.60	45.00	1.00	2	10.005	❍
M10 X1,25	7.950	12.000	11.000	8.800	80.00	21.60	45.00	1.25	2	10.006	❍
M12 X1	9.950	14.000	13.500	11.000	90.00	26.00	45.00	1.00	2	12.005	❍
M12 X1,5	9.950	14.000	13.500	10.500	90.00	27.40	45.00	1.50	2	12.007	❍
M14 X1,5	11.200	16.000	15.500	12.500	102.00	30.80	48.00	1.50	2	14.007	❍
M16 X1,5	13.200	18.000	17.500	14.500	102.00	34.10	48.00	1.50	2	16.007	❍

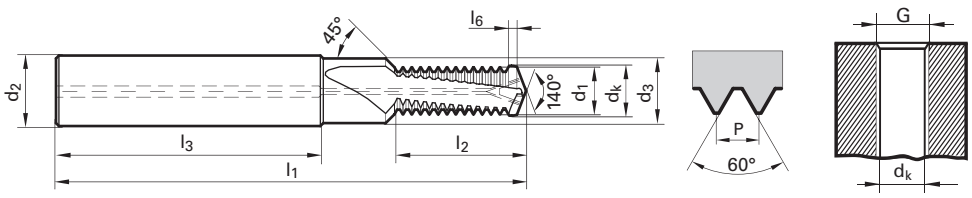
◯ bright ◯ steam tempered ◓ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

3792	3791	3793
	Guhring std.	
	Solid carbide	
K/P	K	K/P
C	○	C
DTMC SP	DTMC SP	DTMC SP
2xD	2xD	2xD
	axial	axial
HA	HA	HA
right-hand	right-hand	right-hand
108	108	108
816	816	816

Availability		
❍		
❍		
❍	❍	❍
	❍	❍
	❍	●
	❍	❍
	❍	❍
	❍	❍
	❍	●
	❍	❍
	❍	❍

C TiCN Cb Carbo D Cristall F FIRE/nanoFIRE P AlCrN S TiN S+ TiN+ M MolyGlide Y Signum

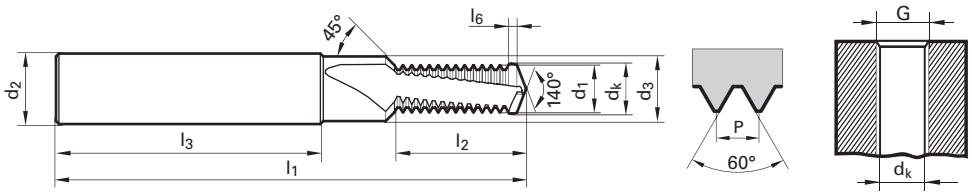
Guhring no.	4138	4139
Standard	Guhring std.	
Tool material	Solid carbide	
Carbide grade	K	K/P
Surface	○	C
Type	DTMC SP	DTMC SP
Thread length	2xD	2xD
Cooling		axial
Shank design	HA	HA
Cutting direction	right-hand	right-hand
Discount group	108	108
Techn. data page	816	816
	NEW	NEW



G	d1	d2	d3	dk	l1	l2	l3	l6	Z	Code no.	Availability	
	mm	mm	mm	mm	mm	mm	mm	mm	mm			
1/4 -20	5.000	8.000	6.600	5.100	62.00	14.90	36.00	1.30	2	6.350	●	●
5/16-18	6.250	10.000	9.000	6.600	74.00	18.10	40.00	1.50	2	7.938	●	●
3/8 -16	7.500	12.000	11.000	8.000	80.00	22.10	45.00	1.50	2	9.525	●	●
7/16-14	8.800	12.000	11.000	9.400	80.00	25.00	45.00	1.50	2	11.113	●	●
1/2 -13	10.200	14.000	13.500	10.800	90.00	26.90	45.00	1.50	2	12.700	●	●
9/16-12	11.600	16.000	15.500	12.200	102.00	31.20	48.00	1.50	2	14.288	●	●
5/8 -11	13.000	18.000	17.500	13.500	102.00	36.30	48.00	1.50	2	15.875	●	●

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

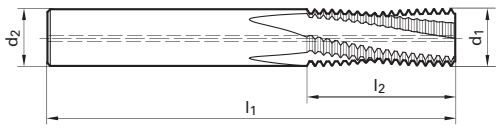
Guhring no.	4140	4141
Standard	Guhring std.	
Tool material	Solid carbide	
Carbide grade	K	K/P
Surface	○	C
Type	DTMC SP	DTMC SP
Thread length	2xD	2xD
Cooling		axial
Shank design	HA	HA
Cutting direction	right-hand	right-hand
Discount group	108	108
Techn. data page	816	816
	NEW	NEW

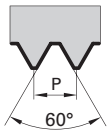


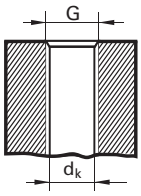
G	d1	d2	d3	dk	l1	l2	l3	l6	Z	Code no.	Availability	
	mm	mm	mm	mm	mm	mm	mm	mm	mm			
1/4 -28	5.000	8.000	6.600	5.500	62.00	12.80	36.00	1.00	2	6.350	●	●
5/16-24	6.250	10.000	9.000	6.900	74.00	18.20	40.00	1.10	2	7.938	●	●
3/8 -24	7.950	12.000	11.000	8.500	80.00	20.60	45.00	1.10	2	9.525	●	●
7/16-20	9.500	12.000	11.000	9.900	80.00	24.70	45.00	1.30	2	11.113	●	●
1/2 -20	10.200	14.000	13.500	11.500	90.00	27.50	45.00	1.30	2	12.700	●	●
9/16-18	11.600	16.000	15.500	12.900	102.00	30.60	48.00	1.50	2	14.288	●	●
5/8 -18	13.000	18.000	17.500	14.500	102.00	33.70	48.00	1.50	2	15.875	●	●

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

Guhring no.	3734	3737	3743
Standard	Guhring std.		
Tool material	Solid carbide		
Carbide grade	K	K/P	K/P
Surface	○	C	A
Type	TM SP	TM SP	TM SP
Thread length	2xD	2xD	2xD
Cooling	axial	axial	axial
Shank design	cil. h6	cil. h6	cil. h6
Cutting direction	right-hand	right-hand	right-hand
Discount group	108	108	108
Techn. data page	816	817	818



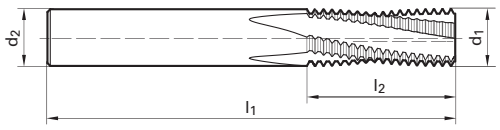


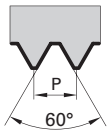


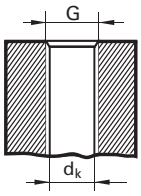
G	P	d1	d2	dk	l1	l2	Z	Code no.	Availability		
	mm	mm	mm	mm	mm	mm					
M 6	1.00	4.800	6.000	5.000	54.00	13.50	3	6.000	●	●	❍
M 8	1.25	6.400	8.000	6.800	62.00	18.10	3	8.000	●	●	❍
M 8 X1	1.00	6.400	8.000	7.000	62.00	17.50	3	8.005	●	●	
M10	1.50	7.950	10.000	8.500	74.00	21.80	3	10.000	●	●	❍
M10 X1	1.00	7.950	10.000	9.000	74.00	21.50	3	10.005	●	●	
M10 X1,25	1.25	7.950	10.000	8.800	74.00	21.90	3	10.006	●	●	
M12	1.75	9.950	10.000	10.200	74.00	25.40	4	12.000	●	●	❍
M14	2.00	11.200	12.000	12.000	90.00	31.00	4	14.000	●	●	❍
M14 X1,50	1.50	11.200	12.000	12.500	90.00	30.80	4	14.007	●	●	
M16	2.00	12.800	14.000	14.000	90.00	35.00	4	16.000	●	●	❍
M16 X1,50	1.50	12.800	14.000	14.500	90.00	33.80	4	16.007	●	●	
M20	2.50	14.950	16.000	17.500	102.00	41.30	4	20.000	●	●	❍
M20 X1,50	1.50	14.950	16.000	18.500	102.00	42.80	4	20.007	●	●	

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

Guhring no.	4132	4133
Standard	Guhring std.	
Tool material	Solid carbide	
Carbide grade	K	K/P
Surface	○	C
Type	TM SP	TM SP
Thread length	2xD	2xD
Cooling		
Shank design	cil. h6	cil. h6
Cutting direction	right-hand	right-hand
Discount group	108	108
Techn. data page	816	817
	NEW	NEW



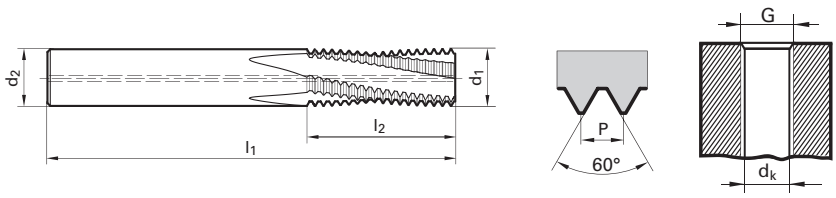




G	P	d1	d2	dk	l1	l2	Z	Code no.	Availability	
	mm	mm	mm	mm	mm	mm				
M 6	1.00	4.800	6.000	5.000	54.00	13.50	3	6.000	●	●
M 8	1.25	6.400	8.000	6.800	62.00	18.10	3	8.000	●	●
M10	1.50	7.950	10.000	8.500	74.00	21.80	3	10.000	●	●
M12	1.75	9.950	10.000	10.200	74.00	25.40	4	12.000	●	●
M14	2.00	11.200	12.000	12.000	90.00	31.00	4	14.000	●	●
M16	2.00	12.800	14.000	14.000	90.00	35.00	4	16.000	●	●
M20	2.50	14.950	16.000	17.500	102.00	41.30	4	20.000	●	●

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

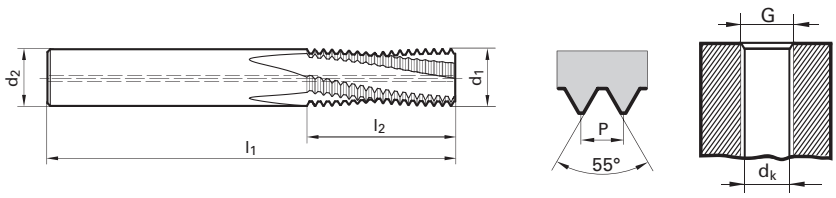
Guhring no.	3735	3740	3744
Standard	Guhring std.		
Tool material	Solid carbide		
Carbide grade	K	K/P	K/P
Surface	○	C	A
Type	TM SP	TM SP	TM SP
Thread length	2,5xD	2,5xD	2,5xD
Cooling	axial	axial	axial
Shank design	cil. h6	cil. h6	cil. h6
Cutting direction	right-hand	right-hand	right-hand
Discount group	108	108	108
Techn. data page	816	817	818



G	P	d1	d2	dk	l1	l2	Z	Code no.	Availability		
	mm	mm	mm	mm	mm	mm					
M 6	1.00	4.800	6.000	5.000	54.00	16.50	3	6.000	●	●	❍
M 8	1.25	6.400	8.000	6.800	62.00	21.90	3	8.000	●	●	❍
M10	1.50	7.950	10.000	8.500	74.00	26.30	3	10.000	●	●	❍
M12	1.75	9.950	10.000	10.200	74.00	32.40	4	12.000	●	●	❍
M14	2.00	11.200	12.000	12.000	90.00	37.00	4	14.000	❍	❍	❍
M16	2.00	12.800	14.000	14.000	90.00	43.00	4	16.000	●	●	❍
M20	2.50	14.950	16.000	17.500	102.00	48.80	4	20.000	●	●	❍

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

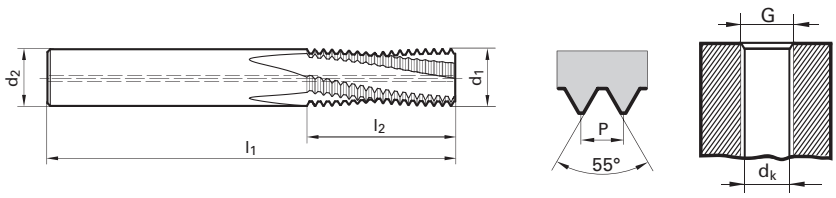
Guhring no.	3745	3748	3751
Standard	Guhring std.		
Tool material	Solid carbide		
Carbide grade	K	K/P	K/P
Surface	○	C	A
Type	TM SP	TM SP	TM SP
Thread length	2xD	2xD	2xD
Cooling	axial	axial	axial
Shank design	cil. h6	cil. h6	cil. h6
Cutting direction	right-hand	right-hand	right-hand
Discount group	108	108	108
Techn. data page	816	817	818



G	P	d1	d2	dk	l1	l2	Z	Code no.	Availability		
	G/inch	mm	mm	mm	mm	mm					
G 1/8	28.00	7.950	8.000	8.800	64.00	21.30	3	9.728	●	●	○
G 1/4	19.00	10.500	12.000	11.800	90.00	28.70	4	13.157	●	●	○
G 3/8	19.00	13.600	14.000	15.250	90.00	35.40	4	16.662	○	●	○

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

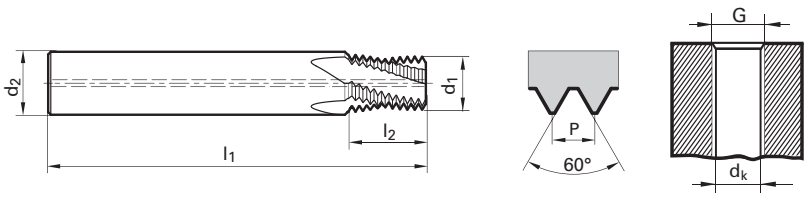
Guhring no.	3746	3750	3752
Standard	Guhring std.		
Tool material	Solid carbide		
Carbide grade	K	K/P	K/P
Surface	○	C	A
Type	TM SP	TM SP	TM SP
Thread length	2,5xD	2,5xD	2,5xD
Cooling	axial	axial	axial
Shank design	cil. h6	cil. h6	cil. h6
Cutting direction	right-hand	right-hand	right-hand
Discount group	108	108	108
Techn. data page	816	817	818



G	P	d1	d2	dk	l1	l2	Z	Code no.	Availability		
	G/inch	mm	mm	mm	mm	mm					
G 1/8	28.00	7.950	8.000	8.800	64.00	24.90	3	9.728	❍	❍	❍
G 1/4	19.00	10.500	12.000	11.800	90.00	35.40	4	13.157	●	●	❍
G 3/8	19.00	13.600	14.000	15.250	90.00	43.50	4	16.662	❍	●	❍

○ bright ◐ steam tempered ◒ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

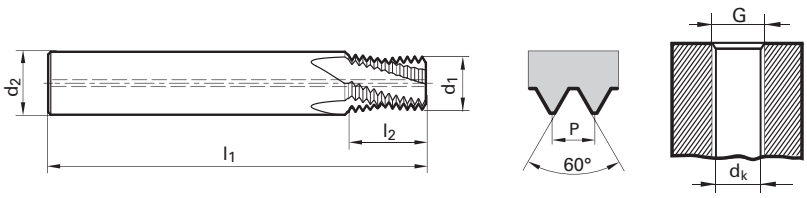
Guhring no.	3753	3754	3755
Standard	Guhring std.		
Tool material	Solid carbide		
Carbide grade	K	K/P	K/P
Surface	○	C	A
Type	TM SP	TM SP	TM SP
Thread length			
Cooling	axial	axial	axial
Shank design	cil. h6	cil. h6	cil. h6
Cutting direction	right-hand	right-hand	right-hand
Discount group	108	108	108
Techn. data page	816	817	818



G	P	d1	d2	dk	l1	l2	Z	Code no.	Availability		
	G/inch	mm	mm	mm	mm	mm					
1/16	27.00	5.900	8.000	6.150	54.00	9.90	3	8.190	●	●	○
1/8	27.00	7.300	8.000	8.400	64.00	9.90	3	10.620	○	●	○
1/4	18.00	9.950	12.000	11.100	72.00	19.00	4	14.140	●	●	○
3/8	18.00	12.500	14.000	14.300	80.00	14.80	4	17.570	○	●	○

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

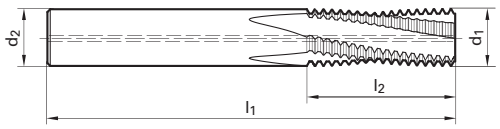
Guhring no.	3756	3757	3758
Standard	Guhring std.		
Tool material	Solid carbide		
Carbide grade	K	K/P	K/P
Surface	○	C	A
Type	TM SP	TM SP	TM SP
Thread length			
Cooling	axial	axial	axial
Shank design	cil. h6	cil. h6	cil. h6
Cutting direction	right-hand	right-hand	right-hand
Discount group	108	108	108
Techn. data page	816	817	818

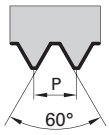


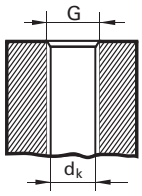
G	P	d1	d2	dk	l1	l2	Z	Code no.	Availability		
	G/inch	mm	mm	mm	mm	mm					
1/16	27.00	5.900	8.000	6.150	54.00	9.90	3	8.190	◐	●	◐
1/8	27.00	7.300	8.000	8.400	64.00	9.90	3	10.620	◐	◐	◐
1/4	18.00	9.950	12.000	11.100	72.00	19.00	4	14.140	◐	●	◐
3/8	18.00	12.500	14.000	14.300	80.00	14.80	4	17.570	◐	●	◐

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

Guhring no.	4134	4135
Standard	Guhring std.	
Tool material	Solid carbide	
Carbide grade	K	K/P
Surface	○	C
Type	TM SP	TM SP
Thread length	2xD	2xD
Cooling	axial	axial
Shank design	cil. h6	cil. h6
Cutting direction	right-hand	right-hand
Discount group	108	108
Techn. data page	816	817
	NEW	NEW



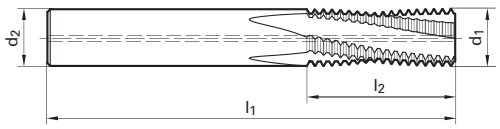


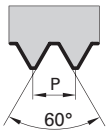


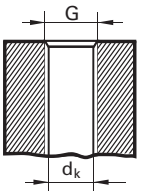
G	d1	d2	dk	l1	l2	Z	Code no.	Availability	
	mm	mm	mm	mm	mm				
NR.10 -24	3.400	6.000	3.900	54.00	11.10	3	4.826	●	●
NR.12 -24	4.100	6.000	4.500	54.00	12.20	3	5.486	●	●
1/4 -20	4.700	6.000	5.100	54.00	14.60	3	6.350	●	●
5/16-18	6.100	8.000	6.600	64.00	17.60	3	7.938	●	●
3/8 -16	7.600	8.000	8.000	64.00	21.40	3	9.525	●	●
7/16-14	9.000	10.000	9.400	74.00	24.50	3	11.113	●	●
1/2 -13	9.950	10.000	10.800	74.00	28.30	4	12.700	●	●
9/16-12	11.400	12.000	12.200	90.00	30.70	4	14.288	●	●
5/8 -11	12.700	14.000	13.500	90.00	35.80	4	15.875	●	●

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

Guhring no.	4136	4137
Standard	Guhring std.	
Tool material	Solid carbide	
Carbide grade	K/P	K/P
Surface	○	C
Type	TM SP	TM SP
Thread length	2xD	2xD
Cooling	axial	axial
Shank design	cil. h6	cil. h6
Cutting direction	right-hand	right-hand
Discount group	108	108
Techn. data page	816	817
	NEW	NEW







G	d1	d2	dk	l1	l2	Z	Code no.	Availability	
	mm	mm	mm	mm	mm				
NR.10 -32	3.800	6.000	4.100	54.00	11.50	3	4.826	●	●
NR.12 -28	4.300	6.000	4.600	54.00	12.20	3	5.486	●	●
1/4 -28	5.100	6.000	5.500	54.00	14.10	3	6.350	●	●
5/16-24	6.300	8.000	6.900	64.00	17.50	3	7.938	●	●
3/8 -24	7.800	8.000	8.500	64.00	20.60	3	9.525	●	●
7/16-20	9.400	10.000	9.900	74.00	24.80	3	11.113	●	●
1/2 -20	9.950	10.000	11.500	74.00	27.30	4	12.700	●	●
9/16-18	11.400	12.000	12.900	90.00	30.30	4	14.288	●	●
5/8 -18	12.700	14.000	14.500	90.00	33.20	4	15.875	●	●

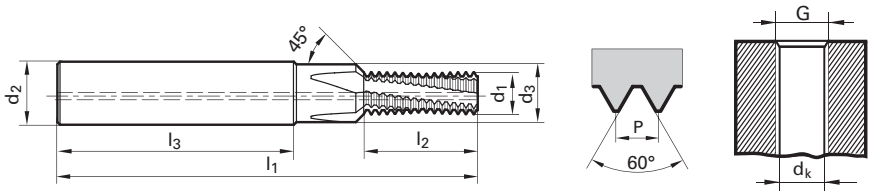
○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

GUHRING

SPECIAL THREAD MILLING CUTTERS

In addition to our standard catalogue range, we also provide your specific solution for an efficient production, for example, with special dimensions and thread types as well as additional options such as de-burring, countersinking, drilling or facing steps.

Guhring no.	3510
Standard	Guhring std.
Tool material	Solid carbide
Carbide grade	K
Surface	○
Type	TMC SP
Thread length	1,5xD
Cooling	axial >=M4
Shank design	HA
Cutting direction	right-hand
Discount group	108
Techn. data page	816



G	P	d1	d2	d3	dk	l1	l2	l3	Z	Code no.	Availability
	mm	mm	mm	mm	mm	mm	mm	mm	mm		
M 3	0.50	2.300	6.000	3.400	2.500	48.00	5.30	36.00	3	3.000	●
M 4	0.70	3.000	6.000	4.500	3.300	48.00	7.40	36.00	3	4.000	●
M 5	0.80	4.000	6.000	5.500	4.200	54.00	9.20	36.00	3	5.000	●
M 6	1.00	4.800	8.000	6.600	5.000	62.00	10.50	36.00	3	6.000	●
M 8	1.25	6.400	10.000	9.000	6.800	74.00	13.10	40.00	3	8.000	❍
M10	1.50	7.950	12.000	11.000	8.500	80.00	17.30	45.00	4	10.000	●
M12	1.75	9.950	14.000	13.500	10.200	90.00	20.10	45.00	4	12.000	❍
M14	2.00	11.200	16.000	15.500	12.000	102.00	25.00	48.00	4	14.000	❍
M16	2.00	12.800	18.000	17.500	14.000	102.00	27.00	48.00	4	16.000	❍
M20	2.50	14.500	20.000	21.500	17.500	125.00	33.80	50.00	4	20.000	●

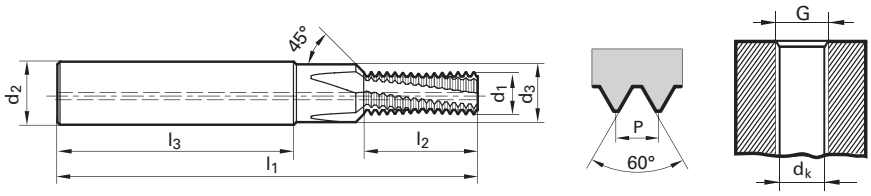
○ bright ◯ steam tempered ◒ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

3525	3543
Guhring std.	
Solid carbide	
K/P	K/P
C	A
TMC SP	TMC SP
1,5xD	1,5xD
axial >=M4	axial >=M4
HA	HA
right-hand	right-hand
108	108
817	818

Availability	
●	○
●	○
●	○
●	○
●	○
●	○
●	○
●	○
●	○
●	○

C TiCN Cb Carbo D Cristall F FIRE/nanoFIRE P AlCrN S TiN S+ TiN+ M MolyGlide Y Signum

Guhring no.	3511
Standard	Guhring std.
Tool material	Solid carbide
Carbide grade	K
Surface	◯
Type	TMC SP
Thread length	2xD
Cooling	axial >=M4
Shank design	HA
Cutting direction	right-hand
Discount group	108
Techn. data page	816



G	P	d1	d2	d3	dk	l1	l2	l3	Z	Code no.	Availability
	mm	mm	mm	mm	mm	mm	mm	mm	mm		
M 3	0.50	2.300	6.000	3.400	2.500	48.00	6.80	36.00	3	3.000	●
M 4	0.70	3.000	6.000	4.500	3.300	48.00	8.80	36.00	3	4.000	●
M 5	0.80	4.000	6.000	5.500	4.200	54.00	10.80	36.00	3	5.000	●
M 6	1.00	4.800	8.000	6.600	5.000	62.00	13.50	36.00	3	6.000	●
M 8	1.25	6.400	10.000	9.000	6.800	74.00	18.10	40.00	3	8.000	●
M10	1.50	7.950	12.000	11.000	8.500	80.00	21.80	45.00	4	10.000	●
M12	1.75	9.950	14.000	13.500	10.200	90.00	25.40	45.00	4	12.000	●
M14	2.00	11.200	16.000	15.500	12.000	102.00	31.00	48.00	4	14.000	●
M16	2.00	12.800	18.000	17.500	14.000	102.00	35.00	48.00	4	16.000	●
M20	2.50	14.500	20.000	21.500	17.500	125.00	41.30	50.00	4	20.000	❍

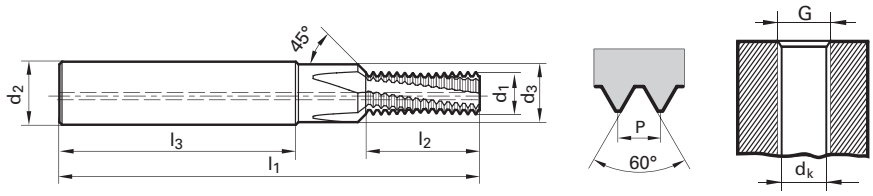
◯ bright ◯ steam tempered ◓ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

3526	3544
Guhring std.	
Solid carbide	
K/P	K/P
C	A
TMC SP	TMC SP
2xD	2xD
axial >=M4	axial >=M4
HA	HA
right-hand	right-hand
108	108
817	818

Availability	
●	○
●	○
●	○
●	○
●	○
●	○
●	○
●	○
●	○
●	○

C TiCN Cb Carbo D Cristall F FIRE/nanoFIRE P AlCrN S TiN S+ TiN+ M MolyGlide Y Signum

Guhring no.	3759
Standard	Guhring std.
Tool material	Solid carbide
Carbide grade	K
Surface	◯
Type	TMC SP
Thread length	2,5xD
Cooling	axial >=M4
Shank design	HA
Cutting direction	right-hand
Discount group	108
Techn. data page	816



G	P	d1	d2	d3	dk	l1	l2	l3	Z	Code no.	Availability
	mm	mm	mm	mm	mm	mm	mm	mm	mm		
M 3	0.50	2.300	6.000	3.400	2.500	48.00	7.80	36.00	3	3.000	❍
M 4	0.70	3.000	6.000	4.500	3.300	48.00	10.90	35.60	3	4.000	●
M 5	0.80	4.000	6.000	5.500	4.200	54.00	13.20	36.00	3	5.000	●
M 6	1.00	4.800	8.000	6.600	5.000	62.00	16.50	36.00	3	6.000	●
M 8	1.25	6.400	10.000	9.000	6.800	74.00	21.90	40.00	3	8.000	●
M10	1.50	7.950	12.000	11.000	8.500	80.00	26.30	45.00	4	10.000	●
M12	1.75	9.950	14.000	13.500	10.200	90.00	32.40	45.00	4	12.000	●
M14	2.00	11.200	16.000	15.500	12.000	102.00	37.00	48.00	4	14.000	❍
M16	2.00	12.800	18.000	17.500	14.000	102.00	43.00	48.00	4	16.000	●
M20	2.50	14.500	20.000	21.500	17.500	125.00	48.80	50.00	4	20.000	

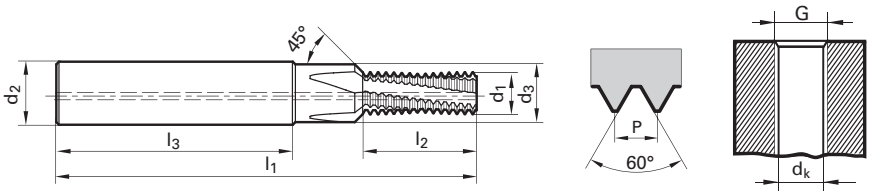
◯ bright ◯ steam tempered ◓ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

3760	3761
Guhring std.	
Solid carbide	
K/P	K/P
C	A
TMC SP	TMC SP
2,5xD	2,5xD
axial >=M4	axial >=M4
HA	HA
right-hand	right-hand
108	108
817	818

Availability	
●	○
●	○
●	○
●	○
●	○
●	○
●	○
○	○
○	○
●	○

C TiCN Cb Carbo D Cristall F FIRE/nanoFIRE P AlCrN S TiN S+ TiN+ M MolyGlide Y Signum

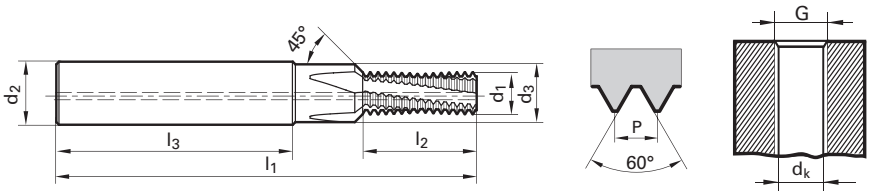
Guhring no.	3512	3527	3545
Standard	Guhring std.		
Tool material	Solid carbide		
Carbide grade	K	K/P	
Surface	○	C	A
Type	TMC SP	TMC SP	TMC SP
Thread length	1,5xD	1,5xD	1,5xD
Cooling	axial	axial	axial
Shank design	HA	HA	HA
Cutting direction	right-hand	right-hand	right-hand
Discount group	108	108	108
Techn. data page	816	817	818



G	d1	d2	d3	dk	l1	l2	l3	Z	Code no.	Availability		
	mm	mm	mm	mm	mm	mm	mm					
M 4 X0,5	3.000	6.000	4.500	3.500	48.00	7.30	36.00	3	4.003	❍	❍	❍
M 5 X0,5	4.000	6.000	5.500	4.500	54.00	8.80	36.00	3	5.003	●	❍	❍
M 6 X0,5	4.800	8.000	6.600	5.500	62.00	9.80	36.00	3	6.003	●	❍	❍
M 6 X0,75	4.800	8.000	6.600	5.200	62.00	10.10	36.00	3	6.004	●	●	❍
M 8 X0,75	6.400	10.000	9.000	7.200	74.00	13.10	40.00	3	8.004	●	●	❍
M 8 X1	6.400	10.000	9.000	7.000	74.00	13.50	40.00	3	8.005	❍	●	❍
M10 X1	7.950	12.000	11.000	9.000	80.00	16.50	45.00	4	10.005	●	●	❍
M10 X1,25	7.950	12.000	11.000	8.800	80.00	16.90	45.00	4	10.006	❍	❍	❍
M12 X1	9.950	14.000	13.500	11.000	90.00	19.50	45.00	4	12.005	●	●	❍
M12 X1,5	9.950	14.000	13.500	10.500	90.00	20.30	45.00	4	12.007	●	●	❍
M14 X1,5	11.200	16.000	15.500	12.500	102.00	23.30	48.00	4	14.007	●	●	❍
M16 X1,5	12.800	18.000	17.500	14.500	102.00	26.30	48.00	4	16.007	●	●	❍

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

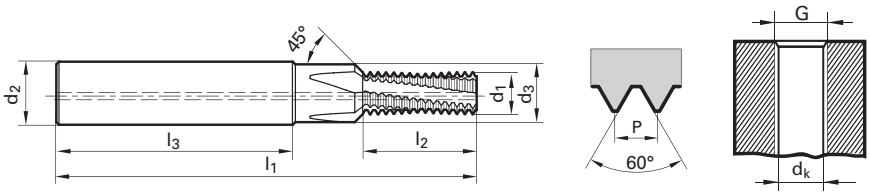
Guhring no.	3513	3528	3546
Standard	Guhring std.		
Tool material	Solid carbide		
Carbide grade	K	K/P	
Surface	○	C	A
Type	TMC SP	TMC SP	TMC SP
Thread length	2xD	2xD	2xD
Cooling	axial	axial	axial
Shank design	HA	HA	HA
Cutting direction	right-hand	right-hand	right-hand
Discount group	108	108	108
Techn. data page	816	817	818



G	d1	d2	d3	dk	l1	l2	l3	Z	Code no.			
	mm	mm	mm	mm	mm	mm	mm			Availability		
M 4 X0,5	3.000	6.000	4.500	3.500	48.00	8.80	36.00	3	4.003	○	○	○
M 5 X0,5	4.000	6.000	5.500	4.500	54.00	10.80	36.00	3	5.003	●	○	○
M 6 X0,5	4.800	8.000	6.600	5.500	62.00	12.80	36.00	3	6.003	●	○	○
M 6 X0,75	4.800	8.000	6.600	5.200	62.00	13.10	36.00	3	6.004	○	○	○
M 8 X0,75	6.400	10.000	9.000	7.200	74.00	16.90	40.00	3	8.004	○	●	○
M 8 X1	6.400	10.000	9.000	7.000	74.00	17.50	40.00	3	8.005	○	●	○
M10 X1	7.950	12.000	11.000	9.000	80.00	21.50	45.00	4	10.005	○	●	○
M10 X1,25	7.950	12.000	11.000	8.800	80.00	21.90	45.00	4	10.006	●	○	○
M12 X1	9.950	14.000	13.500	11.000	90.00	25.50	45.00	4	12.005	●	●	○
M12 X1,5	9.950	14.000	13.500	10.500	90.00	26.30	45.00	4	12.007	●	●	○
M14 X1,5	11.200	16.000	15.500	12.500	102.00	30.80	48.00	4	14.007	●	○	○
M16 X1,5	12.800	18.000	17.500	14.500	102.00	33.80	48.00	4	16.007	●	●	○

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

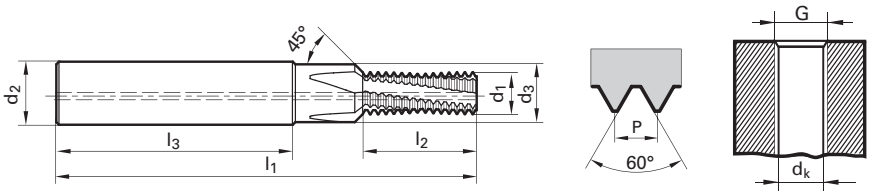
Guhring no.	3762	3763	3764
Standard	Guhring std.		
Tool material	Solid carbide		
Carbide grade	K	K/P	
Surface	○	C	A
Type	TMC SP	TMC SP	TMC SP
Thread length	2,5xD	2,5xD	2,5xD
Cooling	axial	axial	axial
Shank design	HA	HA	HA
Cutting direction	right-hand	right-hand	right-hand
Discount group	108	108	108
Techn. data page	816	817	818



G	d1	d2	d3	dk	l1	l2	l3	Z	Code no.	Availability		
	mm	mm	mm	mm	mm	mm	mm					
M 4 X0,5	3.000	6.000	4.500	3.500	48.00	10.30	36.00	3	4.003	❍	●	❍
M 5 X0,5	4.000	6.000	5.500	4.500	54.00	12.80	36.00	3	5.003	❍	❍	❍
M 6 X0,5	4.800	8.000	6.600	5.500	62.00	15.30	36.00	3	6.003	❍	●	❍
M 6 X0,75	4.800	8.000	6.600	5.200	62.00	15.40	36.00	3	6.004	❍	❍	❍
M 8 X0,75	6.400	10.000	9.000	7.200	74.00	20.60	40.00	3	8.004	❍	●	❍
M 8 X1	6.400	10.000	9.000	7.000	74.00	20.50	40.00	3	8.005	❍	●	❍
M10 X1	7.950	12.000	11.000	9.000	80.00	25.50	45.00	4	10.005	●	❍	❍
M10 X1,25	7.950	12.000	11.000	8.800	80.00	25.60	45.00	4	10.006	●	●	❍
M12 X1	9.950	14.000	13.500	11.000	90.00	30.50	45.00	4	12.005	●	❍	❍
M12 X1,5	9.950	14.000	13.500	10.500	90.00	30.80	45.00	4	12.007	❍	❍	❍
M14 X1,5	11.200	16.000	15.500	12.500	102.00	38.30	48.00	4	14.007	❍	●	❍
M16 X1,5	12.800	18.000	17.500	14.500	102.00	41.30	48.00	4	16.007	❍	●	❍

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

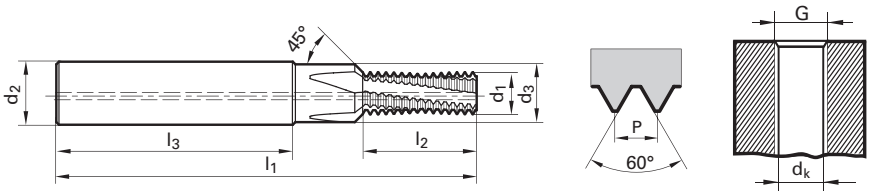
Guhring no.	3516	3534
Standard	Guhring std.	
Tool material	Solid carbide	
Carbide grade	K	K/P
Surface	○	C
Type	TMC SP	TMC SP
Thread length	1,5xD	1,5xD
Cooling	axial	axial
Shank design	HA	HA
Cutting direction	right-hand	right-hand
Discount group	108	108
Techn. data page	816	817



G	d1	d2	d3	dk	l1	l2	l3	Z	Code no.	Availability	
	mm	mm	mm	mm	mm	mm	mm				
1/4 -20	4.800	8.000	6.600	5.100	62.00	12.10	36.00	3	6.350	❍	❍
5/16-18	5.950	10.000	9.000	6.600	74.00	14.80	40.00	3	7.938	●	❍
3/8 -16	7.100	12.000	11.000	8.000	80.00	16.70	45.00	4	9.525	●	❍
7/16-14	7.950	12.000	11.000	9.400	80.00	19.00	45.00	4	11.113	❍	❍
1/2 -13	9.950	14.000	13.500	10.800	90.00	22.50	45.00	4	12.700	❍	❍

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

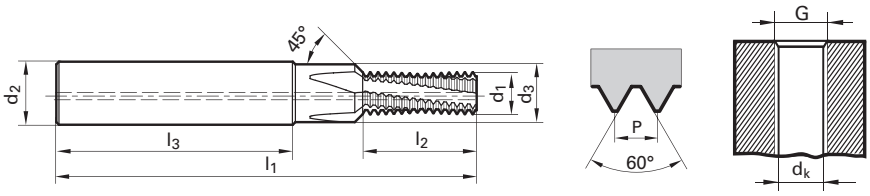
Guhring no.	3517	3535	3550
Standard	Guhring std.		
Tool material	Solid carbide		
Carbide grade	K	K/P	
Surface	○	C	A
Type	TMC SP	TMC SP	TMC SP
Thread length	2xD	2xD	2xD
Cooling	axial	axial	axial
Shank design	HA	HA	HA
Cutting direction	right-hand	right-hand	right-hand
Discount group	108	108	108
Techn. data page	816	817	818



G	d1	d2	d3	dk	l1	l2	l3	Z	Code no.	Availability		
	mm	mm	mm	mm	mm	mm	mm					
1/4 -20	4.800	8.000	6.600	5.100	62.00	14.60	36.00	3	6.350	❍	●	❍
5/16-18	5.950	10.000	9.000	6.600	74.00	17.60	40.00	3	7.938	❍	❍	❍
3/8 -16	7.100	12.000	11.000	8.000	80.00	21.40	45.00	4	9.525	●	●	❍
7/16-14	7.950	12.000	11.000	9.400	80.00	24.50	45.00	4	11.113	❍	❍	❍
1/2 -13	9.950	14.000	13.500	10.800	90.00	28.30	45.00	4	12.700	❍	●	❍

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

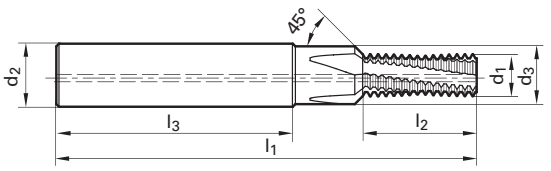
Guhring no.	3518	3536	3551
Standard	Guhring std.		
Tool material	Solid carbide		
Carbide grade	K	K/P	
Surface	○	C	A
Type	TMC SP	TMC SP	TMC SP
Thread length	1,5xD	1,5xD	1,5xD
Cooling	axial	axial	axial
Shank design	HA	HA	HA
Cutting direction	right-hand	right-hand	right-hand
Discount group	108	108	108
Techn. data page	816	817	818

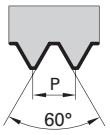


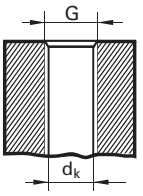
G	d1	d2	d3	dk	l1	l2	l3	Z	Code no.	Availability		
	mm	mm	mm	mm	mm	mm	mm					
1/4 -28	4.800	8.000	6.600	5.500	62.00	11.30	36.00	3	6.350	❍	❍	❍
5/16-24	5.950	10.000	9.000	6.900	74.00	13.20	40.00	3	7.938	●	❍	❍
3/8 -24	7.950	12.000	11.000	8.500	80.00	16.40	45.00	4	9.525	❍	❍	❍
7/16-20	7.950	12.000	11.000	9.900	80.00	18.40	45.00	4	11.113	●	●	❍
1/2 -20	9.950	14.000	13.500	11.500	90.00	21.00	45.00	4	12.700	❍	❍	❍

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

Guhring no.	3519	3537	3552
Standard	Guhring std.		
Tool material	Solid carbide		
Carbide grade	K	K/P	
Surface	○	C	A
Type	TMC SP	TMC SP	TMC SP
Thread length	2xD	2xD	2xD
Cooling	axial	axial	axial
Shank design	HA	HA	HA
Cutting direction	right-hand	right-hand	right-hand
Discount group	108	108	108
Techn. data page	816	817	818







G	d1	d2	d3	dk	l1	l2	l3	Z	Code no.	Availability		
	mm	mm	mm	mm	mm	mm	mm					
1/4 -28	4.800	8.000	6.600	5.500	62.00	14.10	36.00	3	6.350	●	●	○
5/16-24	5.950	10.000	9.000	6.900	74.00	17.50	40.00	3	7.938	●	●	○
3/8 -24	7.950	12.000	11.000	8.500	80.00	20.60	45.00	4	9.525	○	●	○
7/16-20	7.950	12.000	11.000	9.900	80.00	24.80	45.00	4	11.113	○	●	○
1/2 -20	9.950	14.000	13.500	11.500	90.00	27.30	45.00	4	12.700	○	●	○

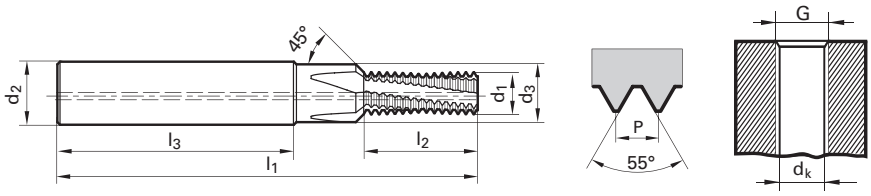
○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

GUHRING

SPECIAL TAPS

Do you require a tap in a special dimension and with a special thread type or tolerance? In addition to our standard catalogue range we provide special solutions tailored to your specific requirements on request!

Guhring no.	3514
Standard	Guhring std.
Tool material	Solid carbide
Carbide grade	K
Surface	○
Type	TMC SP
Thread length	1,5xD
Cooling	axial
Shank design	HA
Cutting direction	right-hand
Discount group	108
Techn. data page	816



G	P	d1	d2	d3	dk	l1	l2	l3	Z	Code no.	Availability
	G/inch	mm	mm	mm	mm	mm	mm	mm	mm		
G 1/8	28.00	7.950	12.000	11.000	8.800	80.00	15.90	45.00	4	9.728	●
G 1/4	19.00	9.950	14.000	13.900	11.800	90.00	22.10	45.00	4	13.157	●
G 3/8	19.00	13.600	18.000	17.500	15.250	102.00	27.40	48.00	4	16.662	◑

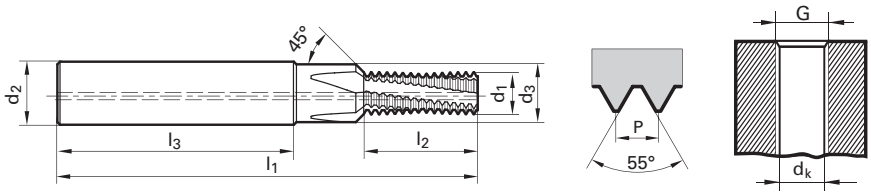
○ bright ◯ steam tempered ◒ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

3529	3547
Guhring std.	
Solid carbide	
K/P	K/P
C	A
TMC SP	TMC SP
1,5xD	1,5xD
axial	axial
HA	HA
right-hand	right-hand
108	108
817	818

Availability	
●	○
○	○
	○

C TiCN Cb Carbo D Cristall F FIRE/nanoFIRE P AlCrN S TiN S+ TiN+ M MolyGlide Y Signum

Guhring no.	3515
Standard	Guhring std.
Tool material	Solid carbide
Carbide grade	K
Surface	◯
Type	TMC SP
Thread length	2xD
Cooling	axial
Shank design	HA
Cutting direction	right-hand
Discount group	108
Techn. data page	816



G	P	d1	d2	d3	dk	l1	l2	l3	Z	Code no.	Availability
	G/inch	mm	mm	mm	mm	mm	mm	mm	mm		
G 1/8	28.00	7.950	12.000	11.000	8.800	80.00	21.30	45.00	4	9.728	❍
G 1/4	19.00	9.950	14.000	13.900	11.800	90.00	28.70	45.00	4	13.157	●
G 3/8	19.00	13.600	18.000	17.500	15.250	102.00	35.40	48.00	4	16.662	❍

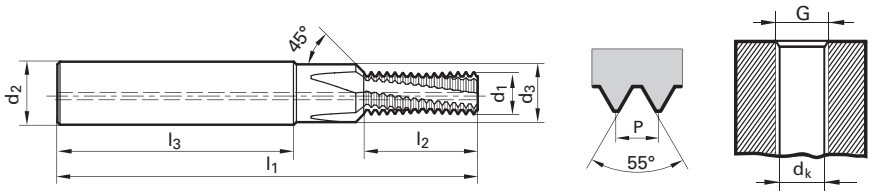
◯ bright ◯ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

3533	3548
Guhring std.	
Solid carbide	
K/P	K/P
C	A
TMC SP	TMC SP
2xD	2xD
axial	axial
HA	HA
right-hand	right-hand
108	108
817	818

Availability	
●	○
●	○
○	○

C TiCN Cb Carbo D Cristall F FIRE/nanoFIRE P AlCrN S TiN S+ TiN+ M MolyGlide Y Signum

Guhring no.	3765
Standard	Guhring std.
Tool material	Solid carbide
Carbide grade	K
Surface	○
Type	TMC SP
Thread length	2,5xD
Cooling	axial
Shank design	HA
Cutting direction	right-hand
Discount group	108
Techn. data page	816



G	P	d1	d2	d3	dk	l1	l2	l3	Z	Code no.	Availability
	G/inch	mm	mm	mm	mm	mm	mm	mm	mm		
G 1/8	28.00	7.950	12.000	11.000	8.800	80.00	24.90	45.00	4	9.728	◐
G 1/4	19.00	9.950	14.000	13.900	11.800	90.00	35.40	45.00	4	13.157	●

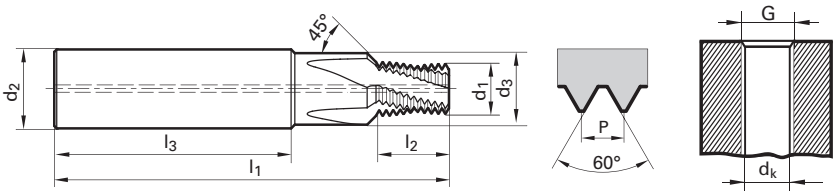
○ bright ◯ steam tempered ◒ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

GUHRING

OEM

Our OEM division was specifically created to provide direct support for the machine tool industry and has received ongoing development in recent years. Benefit from our know-how of process and tool planning, tool design, process optimisation and after-sales-service.

Guhring no.	3520
Standard	Guhring std.
Tool material	Solid carbide
Carbide grade	K
Surface	◯
Type	TMC SP
Thread length	
Cooling	axial
Shank design	HA
Cutting direction	right-hand
Discount group	108
Techn. data page	816



G	P	d1	d2	d3	dk	l1	l2	l3	Z	Code no.	Availability
	G/inch	mm	mm	mm	mm	mm	mm	mm	mm		
1/8	27.00	7.300	12.000	11.000	8.400	70.00	9.90	45.00	4	10.620	❍
1/4	18.00	9.950	16.000	14.500	11.100	80.00	14.80	48.00	4	14.140	❍
3/8	18.00	12.500	18.000	17.500	14.300	80.00	14.80	48.00	4	17.570	❍

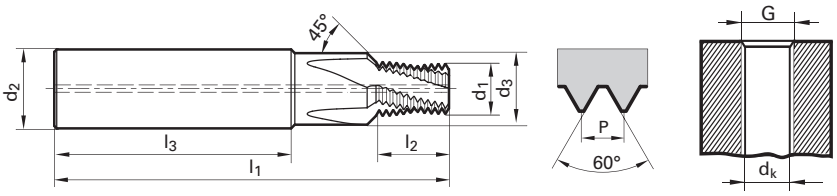
◯ bright ◯ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

3538	3553
Guhring std.	
Solid carbide	
K/P	K/P
C	A
TMC SP	TMC SP
axial	axial
HA	HA
right-hand	right-hand
108	108
817	818

Availability	
❍	❍
●	❍
❍	❍

C TiCN Cb Carbo D Cristall F FIRE/nanoFIRE P AlCrN S TiN S+ TiN+ M MolyGlide Y Signum

Guhring no.	3521
Standard	Guhring std.
Tool material	Solid carbide
Carbide grade	K
Surface	◯
Type	TMC SP
Thread length	
Cooling	axial
Shank design	HA
Cutting direction	right-hand
Discount group	108
Techn. data page	816



G	P	d1	d2	d3	dk	l1	l2	l3	Z	Code no.	Availability
	G/inch	mm	mm	mm	mm	mm	mm	mm	mm		
1/8	27.00	7.300	12.000	11.000	8.400	70.00	9.90	45.00	4	10.620	❍
1/4	18.00	9.950	16.000	14.500	11.100	80.00	14.80	48.00	4	14.140	❍
3/8	18.00	12.500	18.000	17.500	14.300	80.00	14.80	48.00	4	17.570	❍

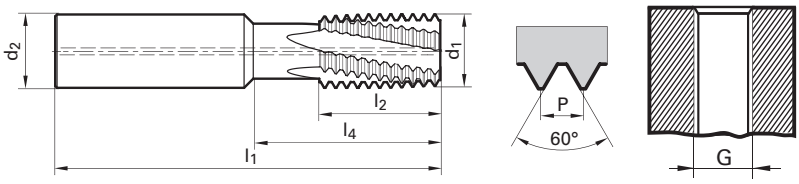
◯ bright ◯ steam tempered ◓ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

3539	3554
Guhring std.	
Solid carbide	
K/P	K/P
C	A
TMC SP	TMC SP
axial	axial
HA	HA
right-hand	right-hand
108	108
817	818

Availability	
●	○
○	○
○	○

C TiCN Cb Carbo D Cristall F FIRE/nanoFIRE P AlCrN S TiN S+ TiN+ M MolyGlide Y Signum

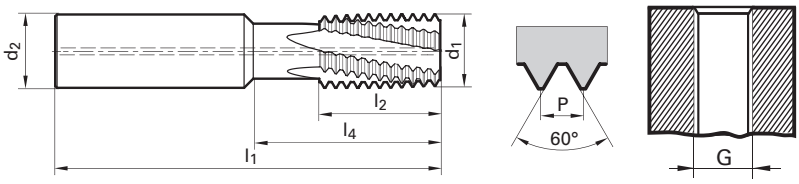
Guhring no.	3523	3541	3556
Standard	Guhring std.		
Tool material	Solid carbide		
Carbide grade	K	K/P	K/P
Surface	○	C	A
Type	TMU SP	TMU SP	TMU SP
Thread length			
Cooling	axial	axial	axial
Shank design	cil. h6	cil. h6	cil. h6
Cutting direction	right-hand	right-hand	right-hand
Discount group	108	108	108
Techn. data page	816	817	818



G	P	d1	d2	l1	l2	l4	Z	Code no.	Availability		
	mm	mm	mm	mm	mm	mm					
M 1	1.00	9.950	10.000	70.00	16.00	25.00	4	10.100	●	●	○
M 1,25	1.25	9.950	10.000	70.00	16.00	25.00	4	10.125	○	●	○
M 1,5	1.50	9.950	10.000	70.00	16.00	25.00	4	10.150	●	●	○
M 1	1.00	11.950	12.000	80.00	20.00	31.00	4	12.100	●	●	○
M 1,25	1.25	11.950	12.000	80.00	20.00	31.00	4	12.125	○	●	○
M 1,5	1.50	11.950	12.000	80.00	20.00	31.00	4	12.150	●	●	○
M 1	1.00	15.950	16.000	90.00	25.00	40.00	5	16.100	●	●	
M 1,5	1.50	15.950	16.000	90.00	25.00	40.00	5	16.150	●	●	○
M 2	2.00	15.950	16.000	90.00	25.00	40.00	5	16.200	●	●	○
M 3	3.00	17.950	18.000	102.00	33.00	50.00	5	18.300	●	●	
M 1	1.00	19.950	20.000	105.00	33.00	50.00	5	20.100	●	○	○
M 1,5	1.50	19.950	20.000	105.00	33.00	50.00	5	20.150	●	●	○
M 2	2.00	19.950	20.000	105.00	33.00	50.00	5	20.200	●	●	○
M 2,5	2.50	19.950	20.000	105.00	33.00	50.00	5	20.250	○	●	○
M 3	3.00	19.950	20.000	105.00	33.00	50.00	5	20.300	●	●	○
M 3,5	3.50	19.950	20.000	105.00	33.00	50.00	5	20.350	○	●	○

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

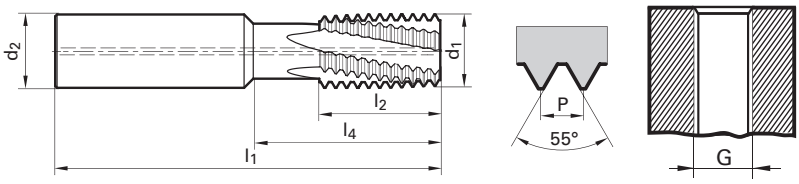
Guhring no.	3595	3596	3597
Standard	Guhring std.		
Tool material	Solid carbide		
Carbide grade	K	K/P	K/P
Surface	○	C	A
Type	TMU UN	TMU UN	TMU UN
Thread length			
Cooling	axial	axial	axial
Shank design	cil. h6	cil. h6	cil. h6
Cutting direction	right-hand	right-hand	right-hand
Discount group	108	108	108
Techn. data page	816	817	818



G	P	d1	d2	l1	l2	l4	Z	Code no.	Availability		
	G/inch	mm	mm	mm	mm	mm					
UN 24	24.00	9.950	10.000	70.00	16.00	25.00	4	10.240	●	●	○
UN 16	16.00	11.950	12.000	80.00	20.00	31.00	4	12.160	●	●	○
UN 18	18.00	11.950	12.000	80.00	20.00	31.00	4	12.180	●	●	○
UN 20	20.00	11.950	12.000	80.00	20.00	31.00	4	12.200	●	●	○
UN 24	24.00	11.950	12.000	80.00	20.00	31.00	4	12.240	●	●	○
UN 14	14.00	15.950	16.000	90.00	25.00	40.00	5	16.140	●	●	○
UN 16	16.00	15.950	16.000	90.00	25.00	40.00	5	16.160	●	●	○
UN 18	18.00	15.950	16.000	90.00	25.00	40.00	5	16.180	●	●	○
UN 20	20.00	15.950	16.000	90.00	25.00	40.00	5	16.200	●	●	○
UN 20	8.00	19.950	20.000	105.00	33.00	50.00	5	20.080	●	●	○
UN 12	12.00	19.950	20.000	105.00	33.00	50.00	5	20.120	●	●	○
UN 14	14.00	19.950	20.000	105.00	33.00	50.00	5	20.140	●	●	○
UN 16	16.00	19.950	20.000	105.00	33.00	50.00	5	20.160	●	●	○

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

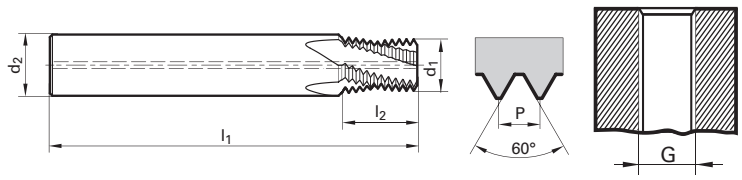
Guhring no.	3524	3542	3557
Standard	Guhring std.		
Tool material	Solid carbide		
Carbide grade	K	K/P	K/P
Surface	○	C	A
Type	TMU SP	TMU SP	TMU SP
Thread length			
Cooling	axial	axial	axial
Shank design	cil. h6	cil. h6	cil. h6
Cutting direction	right-hand	right-hand	right-hand
Discount group	108	108	108
Techn. data page	816	817	818



G	P	d1	d2	l1	l2	l4	Z	Code no.	Availability		
	G/inch	mm	mm	mm	mm	mm					
G 19	19.00	9.950	10.000	70.00	16.00	25.00	4	10.190	●	●	❍
G 14	14.00	15.950	16.000	90.00	25.00	40.00	5	16.140	●	●	❍
G 11	11.00	19.950	20.000	105.00	33.00	50.00	5	20.110	●	●	❍

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

Guhring no.	3768	3769	3770
Standard	Guhring std.		
Tool material	Solid carbide		
Carbide grade	K	K/P	K/P
Surface	○	C	A
Type	TMU SP	TMU SP	TMU SP
Thread length			
Cooling	axial	axial	axial
Shank design	cil. h6	cil. h6	cil. h6
Cutting direction	right-hand	right-hand	right-hand
Discount group	108	108	108
Techn. data page	816	817	818



G	P	d1	d2	l1	l2	Z	Code no.	Availability		
	G/inch	mm	mm	mm	mm					
NPT 14	14.00	14.500	16.000	90.00	19.05	5	21.900	●	●	❍
NPT 11,5	11.50	18.500	20.000	90.00	23.19	5	34.180	❍	●	❍

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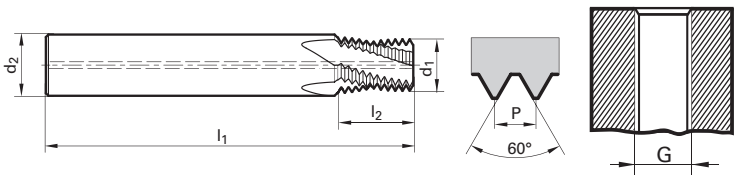
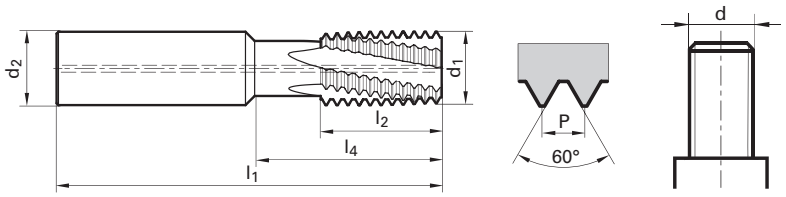
Guhring no.	3772	3773
Standard	Guhring std.	
Tool material	Solid carbide	
Carbide grade	K/P	K/P
Surface	C	A
Type	TMU SP	TMU SP
Thread length		
Cooling	axial	axial
Shank design	cil. h6	cil. h6
Cutting direction	right-hand	right-hand
Discount group	108	108
Techn. data page	817	818



G	P	d1	d2	l1	l2	Z	Code no.	Availability	
	G/inch	mm	mm	mm	mm				
NPTF 14	14.00	14.500	16.000	90.00	19.05	5	21.900	●	○
NPTF 11,5	11.50	18.500	20.000	90.00	23.19	5	34.180	○	○

○ bright ◐ steam tempered ◒ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

Guhring no.	4162	4163
Standard	Guhring std.	
Tool material	Solid carbide	
Carbide grade	K	K/P
Surface	○	C
Type	TMU SP	TMU SP
Thread length		
Cooling	axial	axial
Shank design	cil. h6	cil. h6
Cutting direction	right-hand	right-hand
Discount group	108	108
Techn. data page	816	817
	NEW	NEW



P	d	d1	d2	l1	l2	l4	Z	Code no.	Availability	
mm	mm	mm	mm	mm	mm	mm				
0.50	10.000	9.950	10.000	70.00	16.00	25.00	4	10.050	●	●
0.75	10.000	9.950	10.000	70.00	16.00	25.00	4	10.075	●	●
1.00	12.000	11.950	12.000	80.00	20.00	31.00	4	12.100	●	●
1.25	12.000	11.950	12.000	80.00	20.00	31.00	4	12.125	●	●
1.50	12.000	11.950	12.000	80.00	20.00	31.00	4	12.150	●	●
1.50	16.000	15.950	16.000	90.00	25.00	40.00	5	16.150	●	●
2.00	16.000	15.950	16.000	90.00	25.00	40.00	5	16.200	●	●
2.50	16.000	15.950	16.000	90.00	25.00	40.00	5	16.250	●	●
3.00	20.000	19.950	20.000	105.00	33.00	50.00	5	20.300	●	●

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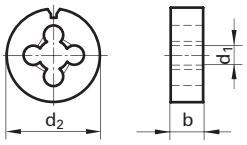
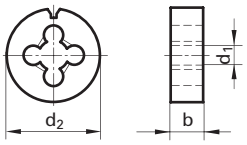
Guhring no.	**125**
Standard	**Guhring std.**
Tool material	**HSS**
Surface	○
	lapped
Spiral entry	**>M 2.6**
Chamfer lead	**1,75xP**
Cutting direction	**right-hand**
Tolerance	**6g**
Discount group	**103**
Techn. data page	**820**



d1	P	d2	b	workpce Ø	Code no.	Availability
	mm	mm	mm	mm		
M 1	0.25	16.000	2.00	0.970	1.000	◐
M 1,1	0.25	16.000	2.00	1.070	1.100	◐
M 1,2	0.25	16.000	2.00	1.170	1.200	◐
M 1,6	0.35	16.000	2.60	1.540	1.600	◐
M 2	0.40	16.000	3.50	1.940	2.000	●
M 2,2	0.45	16.000	3.50	2.130	2.200	◐
M 3	0.50	16.000	3.50	2.920	3.000	●
M 4	0.70	20.000	5.00	3.910	4.020	◐
M 5	0.80	20.000	7.00	4.900	5.000	●
M 6	1.00	20.000	7.00	5.880	6.000	●
M10	1.50	30.000	11.00	9.850	10.000	●

○ bright ◐ steam tempered ◒ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

Guhring no.	**121**
Standard	**Guhring std.**
Tool material	**HSS**
Surface	◯
Spiral entry	**>M 2.6**
Chamfer lead	**1,75xP**
Cutting direction	**right-hand**
Tolerance	**6g**
Discount group	**103**
Techn. data page	**820**



d1	P	d2	b	workpce Ø	Code no.	Availability
	mm	mm	mm	mm		
M 2,2	0.45	16.000	5.00	2.130	2.200	❍
M 3	0.50	16.000	5.00	2.920	3.010	●
M 4	0.70	20.000	5.00	3.910	4.020	●
M 5	0.80	16.000	5.00	4.900	5.010	●
M 5	0.80	20.000	7.00	4.900	5.000	●
M 6	1.00	16.000	5.00	5.880	6.010	●
M 6	1.00	20.000	7.00	5.880	6.000	●
M 8	1.25	25.000	9.00	7.870	8.000	●
M10	1.50	30.000	11.00	9.850	10.000	●
M12	1.75	38.000	14.00	11.830	12.000	❍

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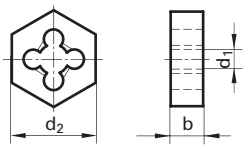
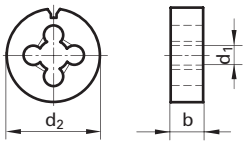
Guhring no.	**139**
Standard	**DIN 382**
Tool material	**HSS**
Surface	○
Spiral entry	**without point grind**
Chamfer lead	**1,75xP**
Cutting direction	**right-hand**
Tolerance	**6g**
Discount group	**103**
Techn. data page	**820**



d1	P	d2	b	workpce Ø	Code no.	Availability
	mm	mm	mm	mm		
M 5	0.80	18.000	7.00	4.900	5.000	●
M 6	1.00	18.000	7.00	5.880	6.000	●
M 7	1.00	21.000	9.00	6.880	7.000	●
M 8	1.25	21.000	9.00	7.870	8.000	●
M10	1.50	27.000	11.00	9.850	10.000	●
M12	1.75	36.000	14.00	11.830	12.000	●
M16	2.00	41.000	18.00	15.820	16.000	●
M20	2.50	41.000	18.00	19.790	20.000	●
M24	3.00	50.000	22.00	23.770	24.000	●
M45	4.50	85.000	36.00	44.770	45.000	❍
M52	5.00	85.000	36.00	51.660	52.000	❍

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

Guhring no.	**130**
Standard	**DIN EN 22568**
Tool material	**HSS-E**
Surface	●
	lapped
Spiral entry	**>M 2.6**
Chamfer lead	**1,75xP**
Cutting direction	**right-hand**
Tolerance	**6g**
Discount group	**103**
Techn. data page	**820**



d1	P	d2	b	workpce Ø	Code no.	Availability
	mm	mm	mm	mm		
M 2	0.40	16.000	3.50	1.940	2.000	●
M 2,2	0.45	16.000	3.50	2.130	2.200	❍
M 2,5	0.45	16.000	5.00	2.430	2.500	●
M 3	0.50	16.000	5.00	2.920	3.010	●
M 3	0.50	20.000	5.00	2.920	3.020	●
M 4	0.70	16.000	5.00	3.910	4.010	●
M 4	0.70	20.000	5.00	3.910	4.020	●
M 5	0.80	20.000	7.00	4.900	5.000	●
M 6	1.00	20.000	7.00	5.880	6.000	●
M 8	1.25	25.000	9.00	7.870	8.000	●
M10	1.50	30.000	11.00	9.850	10.000	●
M12	1.75	38.000	14.00	11.830	12.000	●
M14	2.00	38.000	14.00	13.820	14.000	●
M16	2.00	45.000	18.00	15.820	16.000	●
M20	2.50	45.000	18.00	19.790	20.000	●
M22	2.50	55.000	22.00	21.790	22.000	❍

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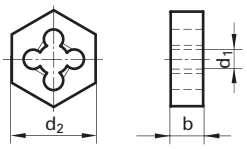
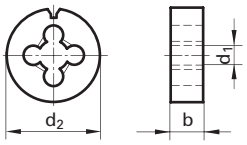
Guhring no.	**140**
Standard	**DIN 382**
Tool material	**HSS**
Surface	○
Spiral entry	**>M 2.6**
Chamfer lead	**1,75xP**
Cutting direction	**right-hand**
Tolerance	**6g**
Discount group	**103**
Techn. data page	**820**



d1	P	d2	b	workpce Ø	Code no.	Availability
	mm	mm	mm	mm		
M 3	0.50	18.000	5.00	2.920	3.000	●
M 4	0.70	18.000	5.00	3.910	4.000	●
M 5	0.80	18.000	7.00	4.900	5.000	❍
M 6	1.00	18.000	7.00	5.880	6.000	❍
M 8	1.25	21.000	9.00	7.870	8.000	●
M10	1.50	27.000	11.00	9.850	10.000	❍
M12	1.75	36.000	14.00	11.830	12.000	❍
M14	2.00	36.000	14.00	13.820	14.000	●
M16	2.00	41.000	18.00	15.820	16.000	❍

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

Guhring no.	151	153	155	156
Standard	DIN EN 22568			
Tool material	HSS			
Surface	○	○	○	○
		lapped	lapped	
Spiral entry	without	>M 2.6	>M 2.6	>M 2.6
Chamfer lead	1,75xP	1,75xP	1,25xP	1,75xP
Cutting direction	right-hand	right-hand	right-hand	left-hand
Tolerance	6g	6g	6g	6g
Discount group	103	103	103	103
Techn. data page	820	820	820	820



d1	P	d2	b	workpce Ø	Code no.	Availability			
	mm	mm	mm	mm					
M 1	0.25	16.000	5.00	0.970	1.000	●			
M 1,2	0.25	16.000	5.00	1.170	1.200	●			
M 1,4	0.30	16.000	5.00	1.360	1.400	○			
M 1,6	0.35	16.000	5.00	1.540	1.600	●			
M 1,7	0.35	16.000	5.00	1.660	1.700	○			
M 2	0.40	16.000	5.00	1.940	2.000	●			
M 2,3	0.40	16.000	5.00	2.250	2.300	○			
M 2,5	0.45	16.000	5.00	2.430	2.500	●			
M 2,6	0.45	16.000	5.00	2.540	2.600	●			
M 3	0.50	20.000	5.00	2.920	3.020	●			●
M 3,5	0.60	20.000	5.00	3.410	3.500	●			
M 4	0.70	20.000	5.00	3.910	4.020	●	●	●	●
M 4,5	0.75	20.000	7.00	4.410	4.500		○	○	
M 5	0.80	20.000	7.00	4.900	5.000	●	●	○	●
M 5,5	0.90	20.000	7.00	5.390	5.500		○		
M 6	1.00	20.000	7.00	5.880	6.000	●	●	○	●
M 7	1.00	25.000	9.00	6.880	7.000	●			
M 8	1.25	25.000	9.00	7.870	8.000	●	●	●	●
M 9	1.25	25.000	9.00	8.870	9.000		○		
M10	1.50	30.000	11.00	9.850	10.000	●	●	●	●
M11	1.50	30.000	11.00	10.850	11.000	○	○		
M12	1.75	38.000	14.00	11.830	12.000	●	●	○	●
M14	2.00	38.000	14.00	13.820	14.000	●			●
M16	2.00	45.000	18.00	15.820	16.000	●		○	●
M18	2.50	45.000	18.00	17.790	18.000	●		○	
M20	2.50	45.000	18.00	19.790	20.000	●		○	●
M22	2.50	55.000	22.00	21.790	22.000			○	
M24	3.00	55.000	22.00	23.770	24.000	●		○	
M27	3.00	65.000	25.00	26.770	27.000			○	
M30	3.50	65.000	25.00	29.730	30.000	●			
M33	3.50	65.000	25.00	32.730	33.000				○

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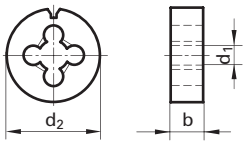
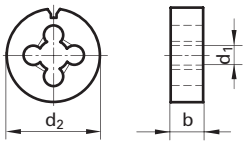
Guhring no.	**152**
Standard	**DIN EN 22568**
Tool material	**HSS**
Surface	○
Spiral entry	**>M 2.6**
Chamfer lead	**1,75xP**
Cutting direction	**right-hand**
Tolerance	**6g**
Discount group	**103**
Techn. data page	**820**



d1	P	d2	b	workpce Ø	Code no.	Availability
	mm	mm	mm	mm		
M 3	0.50	20.000	5.00	2.920	3.020	●
M 3,5	0.60	20.000	5.00	3.410	3.500	●
M 4	0.70	20.000	5.00	3.910	4.020	●
M 4,5	0.75	20.000	7.00	4.410	4.500	◐
M 5	0.80	20.000	7.00	4.900	5.000	●
M 6	1.00	20.000	7.00	5.880	6.000	●
M 7	1.00	25.000	9.00	6.880	7.000	●
M 8	1.25	25.000	9.00	7.870	8.000	●
M 9	1.25	25.000	9.00	8.870	9.000	●
M10	1.50	30.000	11.00	9.850	10.000	●
M12	1.75	38.000	14.00	11.830	12.000	●
M14	2.00	38.000	14.00	13.820	14.000	●
M16	2.00	45.000	18.00	15.820	16.000	●
M18	2.50	45.000	18.00	17.790	18.000	●
M20	2.50	45.000	18.00	19.790	20.000	●
M22	2.50	55.000	22.00	21.790	22.000	●
M24	3.00	55.000	22.00	23.770	24.000	●
M27	3.00	65.000	25.00	26.770	27.000	●
M30	3.50	65.000	25.00	29.730	30.000	●

○ bright ◐ steam tempered ◒ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

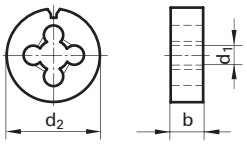
Guhring no.	161	162	163
Standard	DIN EN 22568		
Tool material	HSS		
Surface	◯	◯	◯
			lapped
Spiral entry	without point grind	>M 2.6	>M 2.6
Chamfer lead	1,75xP	1,75xP	1,75xP
Cutting direction	right-hand	right-hand	right-hand
Tolerance	6g	6g	6g
Discount group	103	103	103
Techn. data page	820	820	820



d1 X P	d2	b	workpce Ø	Code no.	Availability		
	mm	mm	mm				
M 2,6X0,25	16.000	5.00	2.540	2.601	❍		
M 3 X0,35	20.000	5.00	2.940	3.002		●	
M 4 X0,5	20.000	5.00	3.920	4.003	❍	●	
M 4,5X0,5	20.000	5.00	4.420	4.503			●
M 5 X0,5	20.000	5.00	4.920	5.003	❍	●	
M 6 X0,5	20.000	5.00	5.920	6.003		●	
M 6 X0,75	20.000	7.00	5.910	6.004		●	
M 7 X0,5	25.000	9.00	6.920	7.003		●	
M 7 X0,75	25.000	9.00	6.910	7.004		●	
M 8 X0,5	25.000	9.00	7.920	8.003		●	
M 8 X0,75	25.000	9.00	7.910	8.004	●	●	
M 8 X1	25.000	9.00	7.880	8.005	●	●	
M 9 X0,75	25.000	9.00	8.910	9.004		●	
M 9 X1	25.000	9.00	8.880	9.005		●	
M10 X0,75	30.000	11.00	9.910	10.004		●	
M10 X1	30.000	11.00	9.880	10.005	●	●	❍
M10 X1,25	30.000	11.00	9.870	10.006	●	●	
M11 X0,5	30.000	11.00	10.920	11.003			●
M11 X1	30.000	11.00	10.880	11.005		●	
M12 X0,75	38.000	10.00	11.910	12.004		●	
M12 X1	38.000	10.00	11.880	12.005	●	●	
M12 X1,25	38.000	10.00	11.870	12.006	●	●	
M12 X1,5	38.000	10.00	11.850	12.007	●	●	
M13 X1	38.000	10.00	12.880	13.005		●	
M14 X1	38.000	10.00	13.880	14.005	❍	●	
M14 X1,25	38.000	10.00	13.870	14.006		●	
M14 X1,5	38.000	10.00	13.850	14.007	●	●	
M15 X1	38.000	10.00	14.880	15.005		●	
M15 X1,5	38.000	10.00	14.850	15.007			●
M16 X1	45.000	14.00	15.880	16.005	❍	●	
M16 X1,5	45.000	14.00	15.850	16.007	●	●	
M17 X1	45.000	14.00	16.880	17.005		●	❍
M18 X1	45.000	14.00	17.880	18.005		●	
M18 X1,5	45.000	14.00	17.850	18.007		●	
M20 X0,75	45.000	14.00	19.910	20.004			❍
M20 X1	45.000	14.00	19.880	20.005	●	●	

C TiCN · Cb Carbo · D Cristall · F FIRE/nanoFIRE · P AlCrN · S TiN · S+ TiN+ · M MolyGlide · Y Signum

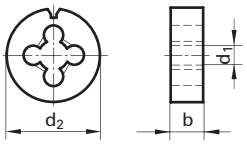
Guhring no.	161	162	163
Standard	DIN EN 22568		
Tool material	HSS		
Surface	○	○	○
			lapped
Spiral entry	without point grind	>M 2.6	>M 2.6
Chamfer lead	1,75xP	1,75xP	1,75xP
Cutting direction	right-hand	right-hand	right-hand
Tolerance	6g	6g	6g
Discount group	103	103	103
Techn. data page	820	820	820



d1 X P	d2	b	workpce Ø	Code no.	Availability		
	mm	mm	mm				
M20 X1,5	45.000	14.00	19.850	20.007	●	●	
M20 X2	45.000	14.00	19.820	20.008		●	❍
M22 X1	55.000	16.00	21.880	22.005		●	
M22 X1,5	55.000	16.00	21.850	22.007	❍	●	
M24 X1,5	55.000	16.00	23.850	24.007		●	
M24 X2	55.000	16.00	23.820	24.008		●	❍
M25 X1,5	55.000	16.00	24.850	25.007		●	
M26 X1	55.000	16.00	25.880	26.005			❍
M26 X1,5	55.000	16.00	25.850	26.007		●	
M27 X1,5	65.000	18.00	26.850	27.007		●	❍
M27 X2	65.000	18.00	26.820	27.008		●	
M28 X1,5	65.000	18.00	27.850	28.007		●	
M30 X1,5	65.000	18.00	29.850	30.007		●	
M30 X2	65.000	18.00	29.820	30.008		●	

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

Guhring no.	181	182
Standard	DIN EN 22568	
Tool material	HSS	
Surface	○	○
Spiral entry	without point grind	with
Chamfer lead	1,75xP	1,75xP
Cutting direction	right-hand	right-hand
Tolerance	2a	2a
Discount group	103	103
Techn. data page	820	820



d1 - P	d2	b	workpce Ø	Code no.	Availability	
	mm	mm	mm			
NR. 4 -40	16.000	5.00	2.760	2.845	❍	
NR. 8 -32	20.000	7.00	4.070	4.166	❍	●
NR.10 -24	20.000	7.00	4.710	4.826		●
1/4 -20	20.000	7.00	6.220	6.350	❍	●
5/16-18	25.000	9.00	7.800	7.938		●
3/8 -16	30.000	11.00	9.370	9.525		●
7/16-14	30.000	11.00	10.950	11.113	❍	●
1/2 -13	38.000	14.00	12.520	12.700		●
5/8 -11	45.000	18.00	15.680	15.875		●
3/4 -10	45.000	18.00	18.840	19.050		●

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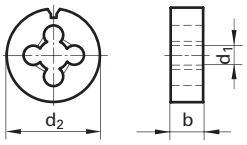
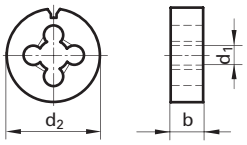
Guhring no.	**185**
Standard	**DIN EN 22568**
Tool material	**HSS**
Surface	○
Spiral entry	**with**
Chamfer lead	**1,75xP**
Cutting direction	**right-hand**
Tolerance	**2a**
Discount group	**103**
Techn. data page	**820**



d1 - P	d2	b	workpce Ø	Code no.	Availability
	mm	mm	mm		
NR.10 -32	20.000	7.00	4.730	4.826	●
1/4 -28	20.000	7.00	6.240	6.350	●
5/16-24	25.000	9.00	7.820	7.938	●
3/8 -24	30.000	11.00	9.410	9.525	●
7/16-20	30.000	11.00	10.980	11.113	●
1/2 -20	38.000	10.00	12.560	12.700	●
9/16-18	38.000	10.00	14.140	14.288	●
5/8 -18	45.000	14.00	15.730	15.875	●
3/4 -16	45.000	14.00	18.890	19.050	●
7/8 -14	55.000	16.00	22.050	22.225	●

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown A TiAlN a TiAlN nanoA A TiAlN SuperA

Guhring no.	**172**
Standard	**DIN EN 22568**
Tool material	**HSS**
Surface	○
Spiral entry	**with**
Chamfer lead	**1,75xP**
Cutting direction	**right-hand**
Tolerance	
Discount group	**103**
Techn. data page	**820**



d1	P	d2	b	workpce Ø	Code no.	Availability
	G/inch	mm	mm	mm		
W 1/8	40.00	20.000	5.00	3.090	3.175	❍
W 1/4	20.00	20.000	7.00	6.180	6.350	●
W 3/8	16.00	30.000	11.00	9.350	9.525	●
W 1/2	12.00	38.000	14.00	12.470	12.700	●
W 5/8	11.00	45.000	18.00	15.660	15.876	●
W1	8.00	55.000	22.00	25.110	25.401	❍
W1 3/8	6.00	65.000	25.00	34.570	34.926	❍
W1 5/8	5.00	75.000	30.00	40.920	41.277	❍

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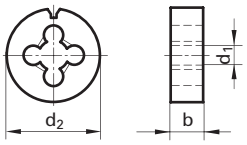
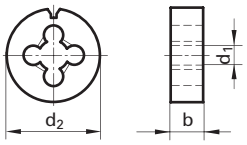
Guhring no.	175	176
Standard	DIN EN 24231	
Tool material	HSS	
Surface	○	○
Spiral entry	without point grind	with
Chamfer lead	1,75xP	1,75xP
Cutting direction	right-hand	right-hand
Tolerance		
Discount group	103	103
Techn. data page	820	820



d1	P	d2	b	workpce Ø	Code no.	Availability	
	G/inch	mm	mm	mm			
G 1/8	28.00	30.000	11.00	9.620	9.728	●	●
G 1/4	19.00	38.000	10.00	13.030	13.157	●	●
G 3/8	19.00	45.000	14.00	16.540	16.662	●	●
G 1/2	14.00	45.000	14.00	20.810	20.955	●	●
G 5/8	14.00	55.000	16.00	22.770	22.911		●
G 3/4	14.00	55.000	16.00	26.300	26.441	●	●
G 7/8	14.00	65.000	18.00	30.060	30.201		❍
G1	11.00	65.000	18.00	33.070	33.249	❍	●
G1 1/4	11.00	75.000	20.00	41.730	41.910		●
G1 1/2	11.00	90.000	22.00	47.620	47.803		●

○ bright ◐ steam tempered ◓ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

Guhring no.	**198**
Standard	**DIN EN 24230**
Tool material	**HSS**
Surface	◯
Spiral entry	**with**
Chamfer lead	**1,75xP**
Cutting direction	**right-hand**
Tolerance	
Discount group	**103**
Techn. data page	**820**



d1	P	d2	b	workpce Ø	Code no.	Availability
	G/inch	mm	mm	mm		
R 1/8	28.00	30.000	11.00	9.480	9.728	❍
R 1/4	19.00	38.000	14.00	12.780	13.157	❍
R 1/2	14.00	45.000	18.00	20.440	20.955	❍
R1 1/4	11.00	75.000	26.00	41.120	41.910	❍
R2	11.00	105.000	28.00	58.820	59.614	❍

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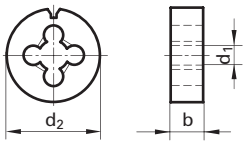
Guhring no.	190	191
Standard	DIN EN 22568	
Tool material	HSS	
Surface	○	○
Spiral entry	without point grind	with
Chamfer lead	1,75xP	1,75xP
Cutting direction	right-hand	right-hand
Tolerance		
Discount group	103	103
Techn. data page	820	820



d1	P	d2	b	workpce Ø	Code no.	Availability	
	G/inch	mm	mm	mm			
1/8	27.00	30.000	11.00	9.930	10.620	●	●
1/4	18.00	38.000	14.00	13.180	14.140		●
3/8	18.00	45.000	14.00	16.600	17.570		●
1/2	14.00	45.000	18.00	20.630	21.900	◐	●
3/4	14.00	55.000	22.00	25.950	27.230	●	●
1	11.50	65.000	25.00	32.510	34.180	●	

○ bright ◯ steam tempered ◐ nitrided lands ● nitrided ● golden brown Ⓐ TiAlN ⓐ TiAlN nanoA Ⓐ TiAlN SuperA

The QS principle encourages requests for inspection records or certificates of conformity to be supplied with ordered tools. We will gladly do this. But as the setting-up of inspection records is particularly time consuming and costly - special marking on a specified number of tools, the provision of measuring records, the entry of measured data in special forms - and we do not wish to incorporate these costs in our overhead costs, we have chosen to charge the prices below in relation to the quantity ordered. Surely you will appreciate this.

inspected number of items / inspection criteria	1	up to 3	up to 5	up to 10	up to 15	up to 20	up to 30	up to 50	up to 100
	net prices for the inspected number of items per inspection criteria								
Total length	●	●	●	●	●	●	●	●	●
Thread length	●	●	●	●	●	●	●	●	●
Flute length	●	●	●	●	●	●	●	●	●
Shank diameter	●	●	●	●	●	●	●	●	●
Thread diameter	●	●	●	●	●	●	●	●	●
Effective diameter	●	●	●	●	●	●	●	●	●
Thread core diameter	●	●	●	●	●	●	●	●	●
Chamfer length	●	●	●	●	●	●	●	●	●
Chamfer angle	●	●	●	●	●	●	●	●	●
Chamfer diameter	●	●	●	●	●	●	●	●	●
Rake angle	●	●	●	●	●	●	●	●	●
Lead angle	●	●	●	●	●	●	●	●	●
Chamfer concentricity	●	●	●	●	●	●	●	●	●
Thread concentricity	●	●	●	●	●	●	●	●	●
Shank concentricity	●	●	●	●	●	●	●	●	●
Included angle of thread	●	●	●	●	●	●	●	●	●
Optical	●	●	●	●	●	●	●	●	●
Marking of the test tools									

	net prices for the inspected number of items for all inspection criteria								
	●	●	●	●	●	●	●	●	●
	plus cost of inspection report								
total price	●	●	●	●	●	●	●	●	●

C TiCN Cb Carbo D Cristall F FIRE/nanoFIRE P AlCrN S TiN S+ TiN+ M MolyGlide Y Signum