

# Machine taps

Tool illustration					Tool material	Guhring no.
Standard	Type	Form	Tolerance	Surface	Diameter range	

## Machine taps for UNJF-threads

	HSS-E-PM	<b>1060</b>				
~ DIN 371	Ti/Ni	B	3BX	<b>C</b>	NR. 6 -40	- 5/8 -18
	HSS-E-PM	<b>1064</b>				
~ DIN 371	Ti R15	C	3BX	<b>C</b>	NR. 6 -40	- 5/8 -18
	HSS-E-PM	<b>1068</b>				
~DIN 371 / ~DIN 374	Ni R10	C	3BX	<b>A</b>	NR. 6 -40	- 5/8 -18

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## Oil feed taps for ISO metric threads

	HSS-E	<b>318</b>				
DIN 371	GG	C	6HX	<b>A</b>	M 5	- M10
	HSS-E	<b>1890</b>				
DIN 371	GG	C	6HX	<b>C</b>	M 5	- M10
	HSS-E	<b>2517</b>				
DIN 371	N	B	ISO 2 / 6H	<b>A</b> + <b>M</b>	M 5	- M10
	HSS-E-PM	<b>302</b>				
DIN 371	H	C	6HX	<b>C</b>	M 5	- M10
	HSS-E-PM	<b>1091</b>				
DIN 371	H	E	6HX	<b>C</b>	M 5	- M10
	HSS-E	<b>1891</b>				
DIN 371	N R15	C	ISO 2 / 6H	<b>C</b>	M 5	- M10
	HSS-E	<b>1892</b>				
DIN 371	VA R40	C	ISO 2 / 6H	<b>C</b>	M 5	- M10
	HSS-E	<b>1893</b>				
DIN 371	N R40	C	ISO 2 / 6H	<b>C</b>	M 5	- M10
	HSS-E	<b>1894</b>				
DIN 371	H R40	C	ISO 2 / 6H	<b>C</b>	M 5	- M10
	HSS-E	<b>2436</b>				
DIN 371	N R15	C	ISO 2 / 6H	<b>S</b>	M 5	- M10
	HSS-E	<b>2438</b>				
DIN 371	N R40	C	ISO 2 / 6H	<b>S</b>	M 5	- M10
	HSS-E	<b>2514</b>				
DIN 371	N R40	C	ISO 2 / 6H	<b>A</b> + <b>M</b>	M 5	- M10
	HSS-E-PM	<b>1152</b>				
DIN 371	N R50	C	ISO 2 / 6H	<b>C</b>	M 5	- M10
	HSS-E-PM	<b>1188</b>				
DIN 371	H R15	C	6HX	<b>C</b>	M 6	- M10

○ bright  
**A** AlTiN

● steam tempered  
**C** TiCN

◐ nitrided lands  
**F** FIRE

● nitrided  
**P** AlCrN














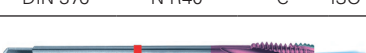
● golden brown  
**S** TiN

**A** TiAlN  
**M** MolyGlide

# Machine taps










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## Oil feed taps for ISO metric threads





	Solid carbide	<b>969</b>	< M5 ☒	DIN 371	H	C	ISO 2 / 6H	○	M 3 - M10
	Solid carbide	<b>1008</b>	< M5 ☒	DIN 371	H	E	ISO 2 / 6H	○	M 3 - M10
	Solid carbide	<b>971</b>	< M5 ☒	DIN 371	N R15	C	ISO 2 / 6H	○	M 3 - M10
	Solid carbide	<b>1858</b>		DIN 371	H	C	ISO 2 / 6H	○	M 5 - M10
	Solid carbide	<b>2311</b>		DIN 371	H	C	ISO 2 / 6H	Ⓐ	M 5 - M10
	Solid carbide	<b>2506</b>		DIN 371	H	C	ISO 2 / 6H	Ⓐ	M 5 - M10
	Solid carbide	<b>2510</b>		DIN 371	N R15	C	ISO 2 / 6H	Ⓐ	M 5 - M10
	Solid carbide	<b>2516</b>		DIN 371	N R15	C	ISO 2 / 6H	Ⓜ	M 5 - M10
	HSS-E	<b>1898</b>		DIN 376	N R15	C	ISO 2 / 6H	○	M12 - M20
	HSS-E	<b>1899</b>		DIN 376	VA R40	C	ISO 2 / 6H	○	M12 - M20
	HSS-E	<b>1901</b>		DIN 376	H R40	C	ISO 2 / 6H	○	M12 - M20
	HSS-E	<b>2437</b>		DIN 376	N R15	C	ISO 2 / 6H	Ⓢ	M12 - M20
	HSS-E	<b>2439</b>		DIN 376	N R40	C	ISO 2 / 6H	Ⓢ	M12 - M20
	HSS-E-PM	<b>1194</b>		DIN 376	H R15	C	6HX	Ⓒ	M12 - M24

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## Oil feed taps for ISO metric threads

	HSS-E-PM	<b>1293</b>		DIN 376	N R50	C	ISO 2 / 6H	Ⓒ	M12 - M20
	HSS-E	<b>319</b>		DIN 376	GG	C	6HX	Ⓐ	M12 - M20
	HSS-E	<b>1897</b>		DIN 376	GG	C	6HX	●	M12 - M20
	HSS-E	<b>2899</b>		DIN 376	NAZ	E	ISO 2 / 6H	Ⓐ+Ⓜ	M 5 - M10
	HSS-E-PM	<b>297</b>		DIN 376	H	C	6HX	Ⓒ	M10 - M12
	HSS-E-PM	<b>1139</b>		DIN 371	VA R50	C	6HX	Ⓒ	M 5 - M10
	HSS-E-PM	<b>1142</b>		DIN 376	VA R50	C	6HX	Ⓒ	M12 - M20
	Solid carbide	<b>1859</b>		DIN 376	H	C	ISO 2 / 6H	○	M12 - M20
	Solid carbide	<b>1883</b>		DIN 376	H	C	ISO 2 / 6H	○	M12 - M20

## Oil feed taps for ISO metric fine threads

	HSS-E-PM	<b>1144</b>		DIN 374	VA R50	C	6HX	Ⓒ	M 8 X1 - M20 X1,50
	HSS-E	<b>1905</b>		DIN 374	N R15	C	ISO 2 / 6H	○	M 5 X0,50 - M20 X1,50
	HSS-E	<b>1906</b>		DIN 374	VA R40	C	ISO 2 / 6H	○	M 5 X0,50 - M20 X1,50
	HSS-E	<b>1907</b>		DIN 374	H R40	C	ISO 2 / 6H	○	M 6 X0,75 - M20 X1,50

○ bright	● steam tempered	● nitrided lands	● nitrided	● golden brown	Ⓐ TiAlN
Ⓐ AlTiN	Ⓒ TiCN	Ⓕ FIRE	⒫ AlCrN	Ⓢ TiN	Ⓜ MolyGlide

# Machine taps

Tool illustration						Tool material	Gühring no.
Standard	Type	Form	Tolerance	Surface	Diameter range		

## Oil feed taps for ISO metric fine threads

	HSS-E-PM	1200			
DIN 374	H R15	C	6HX	Ⓢ	M 9 X1 - M24 X1,50
	HSS-E-PM	1294			
DIN 374	N R50	C	ISO 2 / 6H	Ⓢ	M 8 X1 - M20 X1,50
	HSS-E-PM	1090			
DIN 374	H	C	6HX	Ⓢ	M 8 X1 - M12 X1,50
	HSS-E-PM	1007			
DIN 374	H	E	6HX	Ⓢ	M 8 X1 - M16 X1,50
	HSS-E	347			
DIN 374	GG	C	6HX	Ⓐ	M 8 X1 - M24 X1,50
	HSS-E	1904			
DIN 374	GG	C	6HX	●	M 8 X1 - M20 X1,50
	Solid carbide	972			
< M5 ☒				○	M 4 X0,50 - M10 X1
DIN 371	H	C	ISO 2 / 6H	○	
	Solid carbide	1009			
< M5 ☒				○	M 10 X1 - M16 X1,5
DIN 371	H	E	ISO 2 / 6H	○	
	Solid carbide	975			
< M5 ☒				○	M 4 X0,50 - M10 X1
DIN 371	N L15	D	ISO 2 / 6H	○	
	Solid carbide	977			
< M5 ☒				○	M 4 X0,50 - M10 X1
DIN 371	N R15	C	ISO 2 / 6H	○	
	Solid carbide	1861			
DIN 371	H	C	ISO 2 / 6H	○	M 5 X0,50 - M10 X1
	Solid carbide	974			
DIN 374	H	C	ISO 2 / 6H	○	M12 X1,50 - M18 X1,50
	Solid carbide	976			
DIN 374	N L15	D	ISO 2 / 6H	○	M12 X1,50 - M18 X1,50
	Solid carbide	978			
DIN 374	N R15	C	ISO 2 / 6H	○	M12 X1,50 - M20 X1,50

○ bright	● steam tempered	● nitrided lands	● nitrided	● golden brown	Ⓐ TiAlN
Ⓐ AlTiN	Ⓢ TiCN	Ⓕ FIRE	Ⓟ AlCrN	Ⓢ TiN	Ⓜ MolyGlide

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## Oil feed taps for ISO metric fine threads

	Solid carbide	1860			
DIN 374	H	C	ISO 2 / 6H	○	M12 X1,50 - M20 X1,50

## Oil feed taps for UNC threads

	HSS-E	1085			
~ DIN 371	GG	C		Ⓐ	NR.10 - 24 - 3/8 - 16
	HSS-E	1086			
~ DIN 376	GG	C		Ⓐ	7/16-14 - 7/8 - 9

## Oil feed taps for UNF threads

	HSS-E	1082			
~ DIN 374	GG	C		Ⓐ	NR.10 - 32 - 7/8 - 14

## Machine nut taps for ISO metric threads

	HSS-E	851			
DIN 357	N		ISO 2 / 6H	○	M 3 - M30

## Machine combination drill taps for ISO metric threads

	HSS-E	1839			
Gühring std.	N	D	ISO 2 / 6H	○	M 3 - M12