

Machine tap

Design: With oil grooves.
M3–M10 DIN 371 with reinforced shank.
M12–M16 DIN 376 with overflow shank.

M

HSS-E

DIN
371

DIN
376

N



Application: For regular metric threads according to DIN 13.

1780 Tolerance zone 6HX: Addition "X" indicates a special tolerance range for thread formers, as the deformed material tends to spring back.
TiN

6HX



1783 Tolerance range 6GX with **oversize 0.02–0.04 mm**. For use with workpieces that tend to spring back when cutting, are galvanised or easily shrink when hardening.
TiN

6GX



1784 Tolerance zone 6HX: Addition "X" indicates a special tolerance range for thread formers, as the deformed material tends to spring back.
TiCN

6HX



Use	STEEL			INOX			CAST		SPEC. ALLOY	NON-FERROUS METALS				HARDENED STEEL			Order No.
	< 700 N/mm²	< 1000 N/mm²	< 1400 N/mm²	Ferrite/ martens.	Austenitic	Duplex	GG/ GTS	GGG	Titanium > 850 N/mm²	Alu < 8% Si	Alu > 8% Si	Copper/ copper- alloy	Graphite GFK/CFK/ Duropl.	< 55 HRC	< 60 HRC	> 60 HRC	
V _c [m/min]	10	8	6	12	10	8	–	23	6	45	35	–	–	–	–	–	1780
	10	8	6	12	10	8	–	23	6	45	35	–	–	–	–	–	1783
	15	15	12	6	8	–	–	–	6	17	–	–	–	–	–	–	1784

Thread	Gradient mm	Total length mm	Shank-Ø mm	Square shank mm	Core hole Ø mm	format	format	GUHRING	Order No.
						1780 TiN	1783 TiN	1784 TiCN	
M3	0.5	56	3.5	2.7	2.8	22.20	33.50	49.20	...0001
M4	0.7	63	4.5	3.4	3.7	22.20	34.70	42.90	...0003
M5	0.8	70	6	4.9	4.65	23.50	36.00	44.30	...0005
M6	1	80	6	4.9	5.55	23.50	35.90	51.40	...0007
M8	1.25	90	8	6.2	7.4	27.60	43.60	57.70	...0009
M10	1.5	100	10	8	9.25	35.60	55.70	78.80	...0011
M12	1.75	110	9	7	11.2	42.70	66.30	96.40	...0013
M16	2	110	12	9	15	70.10 (W170)	– (W170)	156.00 (W165)	...0015