



Modular tap

Most economically possible threads

The perfect combination of toughness & wear resistance





Maximum economic efficiency & flexibility:

These are the two hallmarks of modular taps by Gühring, which combine the advantages of the two cutting materials – HSS and carbide.

While the HSS tool shank can be used several times, only the tool head needs to be changed at the end of the tool life.

This thread head is made of carbide and offers a high level of wear protection thanks to the fire coating. As a result, you not only halve your cycle times, but also multiply your tool lives – and manufacture for the lowest cost per component.

- x **Tool life** increased 16-fold
- x **Machining time** reduced by 40 %

-  X easy-to-install insert system reduces costs
-  X at the end of the tool life, only the thread head needs to be replaced
-  X multiple use of the HSS tool shank
-  X use of a carbide tool even under unstable conditions



replaceable carbide thread head
for up to 16 times the tool life

Fire coating
for high wear resistance

公制粗牙 M12–M30
公制細牙 MF12x1.5–MF30x1.5

HSS shank
reduces costs as it can be used multiple times

Application example

Component: Differential housing, GG20

Tool: #6120, M20

Customer target: Increased tool life and reduced machining time

Difficulty: Sub-optimal conditions

Cutting data:	Gühring	Competition
	v_c 25 m/min	v_c 15 m/min

Tool life:	36,000 threads	2,220 threads
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Machining time:	38 sec	63 sec
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Interchangeable heads

Article no. **6120**



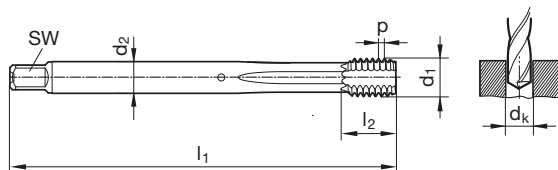
鎢鋼頭：軸向出水 盲孔專用 Fire Coating
鑄鐵/鑄鋁合金專用



cutting data see page 145

P	M	K	N	S	H
		•	•		

incl. screw • same interface values can be combined with each other • axial coolant exit



Standard **DIN 376/DIN 374**
Article no. **6120**

d1	P mm	dk mm	l2 mm	Size Interface	Z	Standard	Order no.
M12 x 1,75	1.750	10.20	12.00	1	4	~DIN 376	6120 12.000
M12 x 1,5	1.500	10.50	12.00	1	4	~DIN 374	6120 12.007
M14 x 2	2.000	12.00	14.00	2	4	~DIN 376	6120 14.000
M14 x 1,5	1.500	12.50	14.00	2	4	~DIN 374	6120 14.007
M16 x 2	2.000	14.00	14.00	3	5	~DIN 376	6120 16.000
M16 x 1,5	1.500	14.50	14.00	3	5	~DIN 374	6120 16.007
M18 x 2,5	2.500	15.50	18.00	4	5	~DIN 376	6120 18.000
M18 x 1,5	1.500	16.50	18.00	4	5	~DIN 374	6120 18.007
M20 x 2,5	2.500	17.50	18.00	5	5	~DIN 376	6120 20.000
M20 x 1,5	1.500	18.50	18.00	5	5	~DIN 374	6120 20.007
M22 x 2,5	2.500	19.50	18.00	6	5	~DIN 376	6120 22.000
M22 x 1,5	1.500	20.50	18.00	6	5	~DIN 374	6120 22.007
M24 x 3	3.000	21.00	21.00	7	5	~DIN 376	6120 24.000
M24 x 1,5	1.500	22.50	21.00	7	5	~DIN 374	6120 24.007
M30 x 3,5	3.500	26.50	26.00	8	5	~DIN 376	6120 30.000
M30 x 1,5	1.500	28.50	26.00	8	5	~DIN 374	6120 30.007

Taps

Interchangeable heads

Article no. **6139**



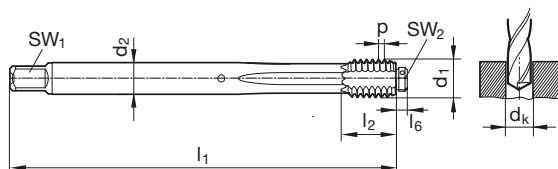
鎢鋼頭：徑向出水 通盲孔用 Fire Coating
鑄鐵/鑄鋁合金專用



cutting data see page 145

P	M	K	N	S	H
		•	•		

incl. screw • same interface values can be combined with each other • radial coolant exit



Standard **DIN 376/DIN 374**
Article no. **6139**

d1	P mm	dk mm	l2 mm	Size Interface	Z	Standard	Order no.
M12 x 1,75	1.750	10.20	12.00	1	4	~DIN 376	6139 12.000
M12 x 1,5	1.500	10.50	12.00	1	4	~DIN 374	6139 12.007
M14 x 2	2.000	12.00	14.00	2	4	~DIN 376	6139 14.000
M14 x 1,5	1.500	12.50	14.00	2	4	~DIN 374	6139 14.007
M16 x 2	2.000	14.00	14.00	3	5	~DIN 376	6139 16.000
M16 x 1,5	1.500	14.50	14.00	3	5	~DIN 374	6139 16.007
M18 x 2,5	2.500	15.50	18.00	4	5	~DIN 376	6139 18.000
M18 x 1,5	1.500	16.50	18.00	4	5	~DIN 374	6139 18.007
M20 x 2,5	2.500	17.50	18.00	5	5	~DIN 376	6139 20.000
M20 x 1,5	1.500	18.50	18.00	5	5	~DIN 374	6139 20.007
M22 x 2,5	2.500	19.50	18.00	6	5	~DIN 376	6139 22.000
M22 x 1,5	1.500	20.50	18.00	6	5	~DIN 374	6139 22.007
M24 x 3	3.000	21.00	21.00	7	5	~DIN 376	6139 24.000
M24 x 1,5	1.500	22.50	21.00	7	5	~DIN 374	6139 24.007
M30 x 3,5	3.500	26.50	26.00	8	5	~DIN 376	6139 30.000
M30 x 1,5	1.500	28.50	26.00	8	5	~DIN 374	6139 30.007

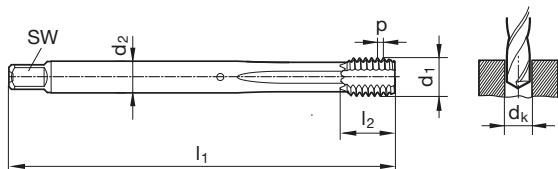


Interchangeable shanks

Article no. 6121



HSS-E刀桿



Standard	DIN 376/DIN 374
Article no.	6121

d2 mm	SW mm	l1 mm	Size Interface		Order no.
9.00	7.00	110.00	1	~DIN 376	6121 12.000
9.00	7.00	100.00	1	~DIN 374	6121 12.007
11.00	9.00	110.00	2	~DIN 376	6121 14.000
11.00	9.00	100.00	2	~DIN 374	6121 14.007
12.00	9.00	110.00	3	~DIN 376	6121 16.000
12.00	9.00	100.00	3	~DIN 374	6121 16.007
14.00	11.00	125.00	4	~DIN 376	6121 18.000
14.00	11.00	110.00	4	~DIN 374	6121 18.007
16.00	12.00	140.00	5	~DIN 376	6121 20.000
16.00	12.00	125.00	5	~DIN 374	6121 20.007
18.00	14.50	140.00	6	~DIN 376	6121 22.000
18.00	14.50	125.00	6	~DIN 374	6121 22.007
18.00	14.50	160.00	7	~DIN 376	6121 24.000
18.00	14.50	140.00	7	~DIN 374	6121 24.007
22.00	18.00	180.00	8	~DIN 376	6121 30.000
22.00	18.00	150.00	8	~DIN 374	6121 30.007

Taps



Sockets

Article no. **4868**



Article no. **4868**

for	l1 mm	Order no.
SW 5,5	22	4868 5.500
SW 7	22	4868 7.000
SW 8	22	4868 8.000
SW 10	22	4868 10.000
SW 13	22	4868 13.000

Retaining screw

Article no. **4889**



Taps

Article no. **4889**

for	l1 mm	Order no.
IP 9	23	4889 3.000
IP15	22	4889 4.000
IP15	28	4889 4.010
IP20	32	4889 5.000
IP30	37	4889 6.000
IP40	44	4889 8.000

Retaining screw

Article no. **4869**



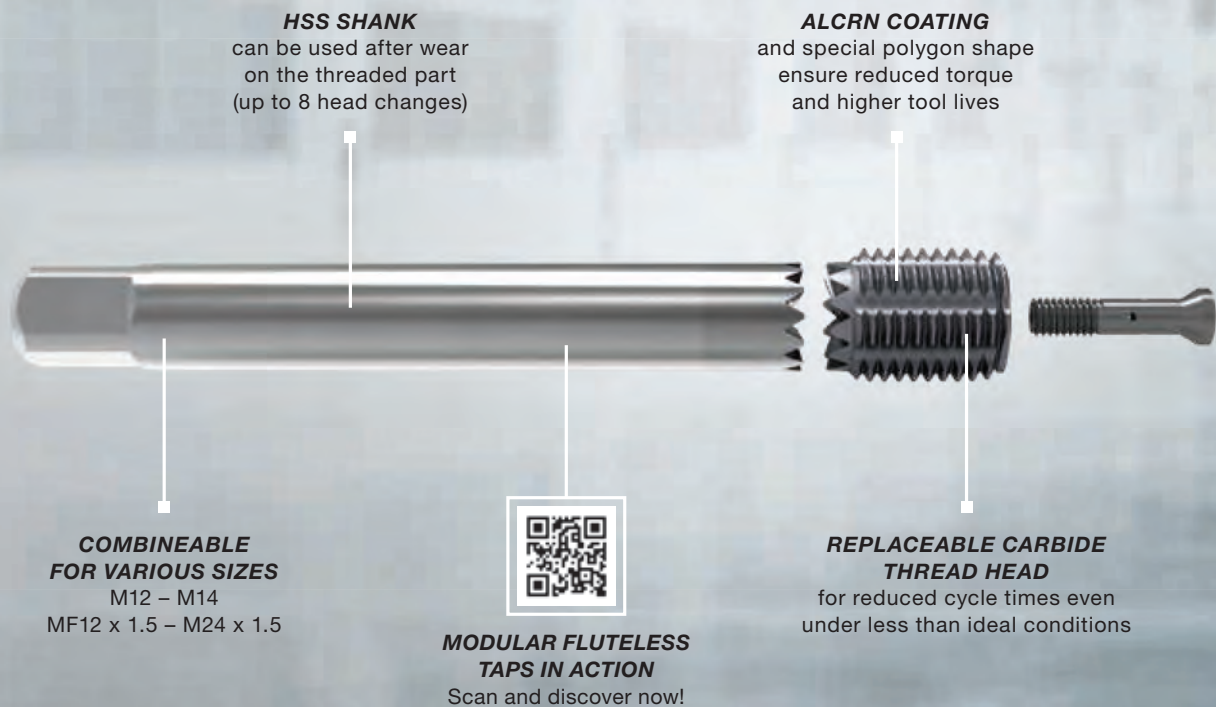
Article no. **4869**

for	l1 mm	Order no.
SW 5,5	29	4869 3.000
SW 7	30	4869 4.000
SW 7	36	4869 4.010
SW 8	40	4869 5.000
SW 10	46	4869 6.000
SW 13	54	4869 8.000

Modular fluteless taps

Modular system for maximum flexibility and economy

economical machining | high flexibility | also suitable for suboptimal conditions



High-performance thanks to innovative material combination

These fluteless taps combine wear resistance with toughness. The concept consists of a steel shank (HSS-E) and an exchangeable thread head made of carbide with an AlCrN coating. Both components are connected via a screw. Compared to a threading tool made of HSS-E, the carbide thread head both reduces cycle time and increases tool life – even under less than ideal conditions. And because the steel shank makes the tool cheaper than monolithic solid carbide tools, the customer benefits from a double cost advantage.



Interchangeable heads

Article no. **4871**

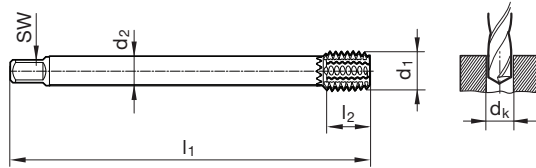


鎢鋼頭：軸向出水 通盲孔用 ALCrN Coating 無屑
鋼料/鑄鐵/鑄鋁合金適用

Cutting data page 148



incl. screw • same interface values can be combined with each other



Standard **~DIN 374/~DIN 376**

Article no. **4871**

d1	P	dk	l2	Size	Z	Standard	Order no.
mm	mm	mm	mm	Interface		Article no.	
M12 x 1,75	1.750	11.20	12.00	1	7	~DIN 376	4871 12.000
M12 x 1,5	1.500	11.30	12.00	1	7	~DIN 374	4871 12.007
M14 x 2	2.000	13.10	14.00	2	7	~DIN 376	4871 14.000
M14 x 1,5	1.500	13.30	14.00	2	7	~DIN 374	4871 14.007
M16 x 2	2.000	15.10	14.00	3	8	~DIN 376	4871 16.000
M16 x 1,5	1.500	15.30	14.00	3	8	~DIN 374	4871 16.007
M18 x 2,5	2.500	16.90	18.00	4	8	~DIN 376	4871 18.000
M18 x 1,5	1.500	17.30	18.00	4	8	~DIN 374	4871 18.007
M20 x 2,5	2.500	18.90	18.00	5	8	~DIN 376	4871 20.000
M20 x 1,5	1.500	19.30	18.00	5	8	~DIN 374	4871 20.007
M22 x 2,5	2.500	20.90	18.00	6	8	~DIN 376	4871 22.000
M22 x 1,5	1.500	21.30	18.00	6	8	~DIN 374	4871 22.007
M24 x 3	3.000	22.70	21.00	6	8	~DIN 376	4871 24.000
M24 x 1,5	1.500	23.30	21.00	6	8	~DIN 374	4871 24.007

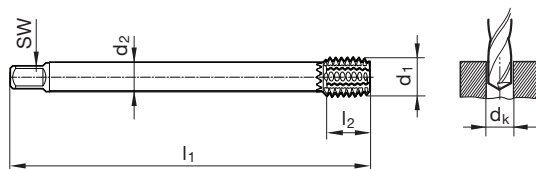
Fluteless taps

Interchangeable shanks

Article no. **4873**



HSS-E刀桿



Standard **~DIN 374/~DIN 376**

Article no. **4873**

d2	SW	l1	Size	Standard	Order no.
mm	mm	mm	Interface	Article no.	
9.00	7.00	110.00	1	~DIN 376	4873 12.000
9.00	7.00	100.00	1	~DIN 374	4873 12.007
11.00	9.00	110.00	2	~DIN 376	4873 14.000
11.00	9.00	100.00	2	~DIN 374	4873 14.007
12.00	9.00	110.00	3	~DIN 376	4873 16.000
12.00	9.00	100.00	3	~DIN 374	4873 16.007
14.00	11.00	125.00	4	~DIN 376	4873 18.000
14.00	11.00	110.00	4	~DIN 374	4873 18.007
16.00	12.00	140.00	5	~DIN 376	4873 20.000
16.00	12.00	125.00	5	~DIN 374	4873 20.007
18.00	14.50	140.00	6	~DIN 376	4873 22.000
18.00	14.50	125.00	6	~DIN 374	4873 22.007
18.00	14.50	160.00	6	~DIN 376	4873 24.000
18.00	14.50	140.00	6	~DIN 374	4873 24.007

NEW



Modular
Fastener