

Taps for general steels ≤ 800 N/mm²

Suitable for conventional machining with quick change tapping chucks



Taps Compass

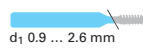


Through hole

Material examples	
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-treatable steels	
1.0402	C 22
1.1151	C22E (Ck 22)
1.0503	C 45
1.1191	C45E (Ck 45)

Shank designs

DIN 371



d₁ 0.9 ... 2.6 mm



d₁ > 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 production of threads for electrical fittings to DIN 60 423. See prices and dimensions.

Type clarification

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

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	N/B	
Surface finish			○	○	○	○	○	○	●	●	●	○	
Cooling			☒	☒	☒	☒	☒	☒	☒	☒	☒	☒	
Rec. parameters			for machining sheet metal					preferred tools					LH spiral
for un-coated tools v _c ≤ 15 m/min													
for coated tools v _c ≤ 30 m/min													
Tools with colouring													
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 p. 38					
			838 M1,4 - M10 p. 39	839 M1 - M10 p. 40	802 M2 - M8 p. 41	806 M1 - M10 p. 44	801 M2 - M10 p. 41	803 M1,4 - M10 p. 41	945 M1 - M10 p. 41	912 M1,4 - M10 p. 41	1246 M3 - M10 p. 41	789 M3 - M10 p. 42	
	ISO 2 6H	869 M2 - M10 p. 51	796 M2 - M10 p. 52	797 M2 - M8 p. 53	795 M3 - M10 p. 54		837 M1,4 - M10 p. 53						
		846 M3 - M20 p. 55	847 M3 - M10 p. 56		818 M1,6 - M52 p. 60	813 M2 - M27 p. 57	815 M1,6 - M36 p. 57	948 M2 - M52 p. 57	915 M1,6 - M52 p. 57	1249 M12 - M16 p. 57	790 M12 - M20 p. 57		
ISO 3 6G		870 M10 - M20 p. 67						845 M2 - 48 p. 68					
MF	ISO 2 6H	DIN 374						830 M3x0,35 - M45x1,5 p. 72	827 M3x0,35 - M45x1,5 p. 70	2888 M3x0,35 - M36x1,5 p. 70	832 M3x0,35 - M36x1,5 p. 70		
			ISO 3 6G						829 * M6x0,75 - M63x1,5 p. 78	316 * M6x0,75 - M20x1,5 p. 77			
UNC	2B	~ DIN 371						1977 No.2-56 - 3/8"-16 p. 80	873 No.1-64 - 3/8"-16 p. 79	2889 No.2-56 - 3/8"-16 p. 79			
			~ DIN 376	1982 7/16"-14 - 1"-8 p. 82	878 7/16"-14 - 1 1/2"-6 p. 81	2890 7/16"-14 - 1 1/2"-6 p. 81							
UNF	2B	~ DIN 374						1987 No.3-56 - 1"-12 p. 84	908 No.1-72 - 1 1/2"-12 p. 83	2891 No.3-56 - 1 1/4"-12 p. 83			
BSW	-	~ DIN 371						934 W1/8" - W3/8" p. 86	933 W1/8" - W3/8" p. 85	2892 W1/8" - W3/8" p. 85			
			~ DIN 376	941 W3/8" - W1" p. 88	940 W1/2" - W1" p. 87	2893 W7/16" - W1" p. 87							
G BSP	-	DIN 5156						963 G1/16" - G2" p. 90	962 G1/16" - G2" p. 89	2894 G1/8" - G1/2" p. 89			

○ bright ● steam tempered ● nitrided ● A TiAlN ● C TiCN ● S TiN ● P AlCrN ● M MolyGlide

Dimensions to DIN 2184, part 1, long version



Blind hole

≤3xD		≤1.5xD						≤3xD							
HSS-E		HSS-E						HSS-E							
N/B	NL15/D	N/C	NR15/C	NR15/C	NR15/C	NR15/C	NR40/C	NR40/C	NR40/C	NR40/C	NL40/C	NR40/C	NR40/C	NR40/C	
		preferred tools				preferred tools				LH spiral					
Guhring no. Ø-range Prices on page		Guhring no. Ø-range Prices on page						Guhring no. Ø-range Prices on page							
2509 M5 - M10 p. 43	808 M3 - M10 p. 42	806 M1 - M10 p. 44	809 M2 - M10 p. 45	946 M2 - M10 p. 46	913 M2 - M10 p. 46	1891 M5 - M10 p. 47	2436 M5 - M10 p. 48	810 M2 - M10 p. 45	783 M2 - M10 p. 49	914 M2 - M10 p. 49	1252 M3 - M10 p. 49	786 M3 - M10 p. 49	1893 M5 - M10 p. 50	2438 M5 - M10 p. 50	2513 M5 - M10 p. 50
		795 M3 - M10 p. 54	799 M2 - M10 p. 54					844 M3 - M10 p. 54							
	820 M3 - M22 p. 59	818 M1,6 - M52 p. 60	821 M3 - M30 p. 61	949 M3 - M22 p. 62	916 M3 - M27 p. 62	1898 M12 - M20 p. 63	2437 M12 - M20 p. 64	822 M3 - M30 p. 65	784 M3 - M30 p. 65	917 M3 - M30 p. 5	1254 M12 - M16 p. 65	787 M12 - M20 p. 65	1900 M12 - M20 p. 66	2439 M12 - M20 p. 50	
								848 M3 - M27 p. 69							
		830 M3x0,35 - M45x1,5 p. 72	833 M4x0,50 - M30x2 p. 72	2838 M4x0,50 - M30x2 p. 72	1971 M4x0,50 - M30x2 p. 72	1905 M5x0,50 - M20x1,5 p. 74		834 M3x0,35 - M30x2 p. 75	2843 M3x0,35 - M30x2 p. 75	852 M3x0,35 - M24x2 p. 75					
		829 * M6x0,75 - M63x1,5 p. 78													
		1977 No.2-56 - 3/8"-16 p. 80	1978 No.2-56 - 3/8"-16 p. 80	2839 No.2-56 - 3/8"-16 p. 80				876 No.2-56 - 3/8"-16 p. 80	2844 No.2-56 - 3/8"-16 p. 80						
		1982 7/16"-14 - 1"-8 p. 82	1983 7/16"-14 - 1"-8 p. 82	2840 7/16"-14 - 1"-8 p. 82				881 7/16"-14 - 1"-8 p. 82	2845 7/16"-14 - 1"-8 p. 82						
		1987 No.3-56 - 1"-12 p. 84	1988 No.3-56 - 1"-12 p. 84	2841 No.10-32 - 3/4"-16 p. 84				911 No.3-56 - 1"-12 p. 4	2846 No.6-40 - 1"-12 p. 84						
		934 W1/8" - W3/8" p. 86						1974 W1/8" - W3/8" p. 86	2847 W1/8" - W3/8" p. 86						
		941 W3/8" - W1" p. 88						1976 W3/8" - W1" p. 88	2848 W3/8" - W1" p. 88						
		963 G1/16" - G2" p. 90	964 G1/16" - G1" p. 90	2842 G1/8" - G1" p. 90				965 G1/16" - G1 1/2" p. 91	2849 G1/8" - G1" p. 91						

external coolant internal radial coolant internal axial coolant through hole blind hole

Taps Compass

Taps for general steels $\leq 800 \text{ N/mm}^2$



Taps Compass



Through hole

Thread depth

$\leq 1.5 \times D$

Tool material

HSS-E

Type/form

N/C

N/C

N/-

NL15/-

Surface finish



Cooling



Material examples

Material no. to DIN EN 10 027	Abbreviation
Structural steels	
1.0035	S 185 (St 33)
1.0039	S 235 JRH
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Unalloyed heat-treatable 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



d_1 1 ... 2.6 mm



d_1 > 2.6 ... 6.35 mm



d_1 > 6.35 ... 52 mm

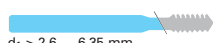
DIN 357 / Guhring std. No. 998



DIN 40 432 / Guhring std. No. 973



Guhring std. No. 888/1839



d_1 > 2.6 ... 6.35 mm



d_1 > 6.35 ... 52 mm

Type clarification

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

Rec. parameters

for un-coated tools
 $v_c \leq 15 \text{ m/min}$

Machine nut taps



Thread type	Tolerance zone	Dim. to DIN 2184-2	Other dim.	Guhring no. \emptyset -range Prices on page			
M	ISO 2 6H	DIN 352	–	995 M2 – M24 p. 93			
	ISO 2 6H	–	DIN 357			851 M3 – M30 p. 94	865 M3.5 – M20 p. 94
	ISO 2 6H	–	Guhring std.				
MF	ISO 2 6H	DIN 2181	–	997 M5x0.50 – M12x1.5 p. 98			
Pg	–	DIN 40 432	–	979 Pg7 – Pg48 p. 99			
NPT	–	–	Guhring std.			973 $\frac{1}{16}$ " – 2" p. 100	

bright

steam tempered

nitrided

TiAlN

TiCN

TiN

AlCrN

MolyGlide

Taps for high tensile steels 800... 1200 N/mm²



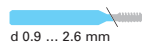
Through holes

Material examples

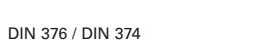
Material no. to DIN EN 10 027	Abbreviation
Alloyed heat-treatable steels	
1.6511 1.7033 1.7225	36 CrNiMo 4 34 Cr 4 42 CrMo 4
Tool steels	
1.2316 1.2067	X 36 CrMo 17 10 S20
High speed tool steels	
1.3343 1.3344 1.3243 1.3247	HS 6-5-2 HS 6-5-3 HS 6-5-2-5 HS 2-19-1-8

Shank designs

DIN 371



d 0.9 ... 2.6 mm

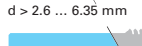


d > 2.6 ... 10 mm

DIN 376 / DIN 374



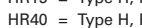
DIN 352



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, RH spiral 15°

HR40 = Type H, RH spiral 40°

*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.

Rec. parameters		
for un-coated tools $v_c \leq 15$ m/min		
for coated tools $v_c \leq 20$ m/min		
 Tools with colouring		

Thread depth	$\leq 1.5 \times D$		$\leq 3 \times D$					
	HSS-E	PM HSS-E	HSS-E					
Tool material	H/C	H/C	H/B	H/B	H/B	H/B	H/B	H AZ/B
Type/form	○	Ⓐ	○	●	●	●	●	○
Surface finish	○	Ⓐ	○	●	●	●	●	○
Cooling	☒	ⓐ	☒	☒	☒	☒	☒	☒
			preferred tools					
Thread type	Tolerance zone	Dim. to DIN 2184-1	Guhring no. Ø-range <i>Prices on page</i>		Guhring no. Ø-range <i>Prices on page</i>			
M	ISO 2 6H	DIN 371	804 M2 - M10 <i>p. 102</i>	733 M2 - M10 <i>p. 102</i>	2941 M2 - M10 <i>p. 102</i>	1914 M2 - M10 <i>p. 102</i>	791 M2 - M10 <i>p. 102</i>	
	ISO 3 6G		2465 M2 - M10 <i>p. 108</i>	2466 M2 - M10 <i>p. 108</i>		2710 M2 - M10 <i>p. 108</i>		
	6HX						302 * M5 - M10 <i>p. 11</i>	
	ISO 2 6H	DIN 376	816 M3 - M24 <i>p. 112</i>	734 M3 - M24 <i>p. 112</i>	2942 M3 - M24 <i>p. 112</i>	1915 M3 - M24 <i>p. 112</i>	849 M12 - M20 <i>p. 112</i>	
	6HX						297 * M10 - M12 <i>p. 118</i>	
MF	ISO 2 6H	DIN 374	828 M3x0.35 - M26x1.5 <i>p. 119</i>	715 M3x0.35 - M24x1.5 <i>p. 119</i>	2943 M3x0.35 - M24x1.5 <i>p. 119</i>			
	ISO 3 6H		2981 M8x1 - M20x1.5 <i>p. 122</i>	2982 M8x1 - M20x1.5 <i>p. 122</i>		2983 M8x1 - M20x1.5 <i>p. 122</i>		
	6HX							
M short version	ISO 2 6H	Dim. to DIN 2184-2 DIN 352	996 M2 - M12 <i>p. 125</i>					

○ bright	● steam tempered	● nitrided	Ⓐ TiAlN	Ⓒ TiCN	● TiN	● AlCrN	● MolyGlide
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Taps for high tensile steels 800... 1200 N/mm²



Through holes



Taps Compass

Material examples

Material no. to DIN EN 10 027	Abbreviation
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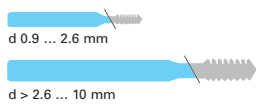
Alloyed heat-treatable steels	
1.6511 1.7033 1.7225	36 CrNiMo 4 34 Cr 4 42 CrMo 4

Tool steels	
1.2316 1.2067	X 36 CrMo 17 10 S20

High speed tool steels	
1.3343 1.3344 1.3243 1.3247	HS 6-5-2 HS 6-5-3 HS 6-5-2-5 HS 2-19-1-8

Shank designs

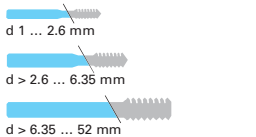
DIN 371



DIN 376 / DIN 374



DIN 352



Type clarification

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

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.

			≤3xD						
			HSS-E						
			HR40/C	HR40/C	HR40/C	HR40/C	HR40/C	HR40/C	HR40/C
			○	●	●	Ⓢ	Ⓒ	○	Ⓐ+Ⓜ
			☒	☒	☒	☒	☒	☒	☒
			preferred tools						
Rec. parameters			for un-coated tools v _c ≤ 15 m/min for coated tools v _c ≤ 20 m/min						
Tools with colouring									
Thread type	Tolerance zone	Dim. to DIN 2184-1	Guhring no. Ø-range Prices on page						
M	ISO 2 6H	DIN 371	811 M2 - M10 p. 106	947 M2 - M10 p. 106	2850 M2 - M10 p. 106	361 M2 - M10 p. 106	1916 M2 - M10 p. 106	1894 M5 - M10 p. 107	2511 M5 - M10 p. 107
			2984 M2 - M10 p. 109	2985 M2 - M10 p. 109	2986 M2 - M10 p. 109				
	ISO 2 6H	DIN 376	823 M3 - M30 p. 115	950 M3 - M30 p. 115	2851 M4 - M30 p. 115	362 M3 - M30 p. 115	1917 M3 - M30 p. 115	1901 M12 - M20 p. 116	
			6HX						
MF	ISO 2 6H	DIN 374	835 M6x0.75 - M24x1.5 p. 120	2940 M6x0.75 - M24x1.5 p. 120	2852 M6x0.75 - M24x1.5 p. 120			1907 M6x0.75 - M20x1.5 p. 121	
	ISO 3 6H		2987 M8x1 - M20x1.5 p. 123		2988 M8x1 - M20x1.5 p. 123	2989 M8x1 - M20x1.5 p. 123			
M short version	ISO 2 6H	Dim. to DIN 2184-2 DIN 352							

○ bright ● steam tempered ● nitrided Ⓐ TiAlN Ⓒ TiCN Ⓢ TiN Ⓟ AlCrN Ⓜ MolyGlide

Taps for hardened steels 45 ... 62 HRC



 Through and blind hole



Material examples

All steel examples are hardened to 45 ... 62 HRC

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

Rec. parameters			≤1.5xD	
for PM HSS-E taps Guhring no. 1201 v _c ≤ 2 - 8 m/min			Solid carbide	
for solid carbide taps Guhring no. 2944 v _c ≤ 2 m/min			45...55 HRC	≤ 62 HRC
				
			Guhring no. Ø-range Prices on page	
Thread type	Tolerance zone	Dim. to		
M	6HX	DIN 371	1201 M6 - M12 p. 126	
	ISO 2 6H	Guhring std.	2944 M3 - M12 p. 127	

Taps Compass


Special tapping size hole diameter for hard machining with Guhring no. 2994

Thread size	Tapping size hole Ø		Core diameter of int. thread			
			min.		max.	
	to DIN 336 mm	with no. 2944 mm	to DIN 336 mm	with no. 2944 mm	to DIN 336 mm	with 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	10.306	10.441	10.641

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 3.0 to 12.0 mm.

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



Cutting rates at 3 x D with Guhring no. 1946

drill Ø in mm	Hardness	HRC 40...48	HRC 48 ... 62
	Cutting speed v _c	40 m/min	30 m/min
	feed	f (mm/rev):	f (mm/rev):
(2.6 on demand)		(0.032)	(0.025)
3.4		0.040	0.032
4.3		0.050	0.040
5.1		0.050	0.040
6.9		0.070	0.055
8.6		0.090	0.070
10.4		0.110	0.090

 external coolant  internal radial coolant  internal axial coolant  through hole  blind hole

Taps for stainless and acid-resistant steels

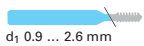


Taps Compass

Material examples	
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
Ferritic stainless steels	
1.4000	X 6 Cr 13
1.4008	GX7CrNiMo12-1
1.4113	X 6 CrMo 17-1

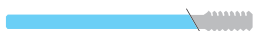
Shank designs

DIN 371



d₁ > 2.6 ... 10 mm

DIN 376 / DIN 374 / DIN 5156



Type clarification

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

			≤3xD					
			HSS-E					PM HSS-E
Thread depth			VA/B	VA/B	VA/B	VA AZ/B	VA/B	VA/B
Tool material			○	●	Ⓢ	○	Ⓐ+Ⓜ	○
Type/form			☒	☒	☒	☒	☒	☒
Surface finish			☒	☒	☒	☒	☒	☒
Cooling			☒	☒	☒	☒	☒	☒
Rec. parameters			preferred tools					
for un-coated tools v _c ≤ 10 m/min								
for coated tools v _c ≤ 15 m/min								
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 p. 128	2869 M3 M10 p. 128	2086 M3 M10 p. 128	1871 M3 M10 p. 128	2508 M5 M10 p. 129	877 M2 M10 p. 128
	6HX							
	ISO 2 6H	DIN 376	1872 M3 M30 p. 133	2870 M3 M30 p. 133	2087 M3 M30 p. 133	792 M12 M16 p. 133	879 M12 M20 p. 133	
MF	ISO 2 6H	DIN 374	1873 M3x0,35 M24x2 p. 137	2871 M3x0,35 M24x1,5 p. 137				887 M8x1 M16x1,5 p. 137
	6HX							
UNC	2B	DIN ~ 371	1980 No.3-48 3/8"-16 p. 141	2872 No.4-40 3/8"-16 p. 141				
	2B	DIN ~ 376	1985 7/16"-14 1"-8 p. 143	2873 1/2"-13 1"-8 p. 143				
UNF	2B	DIN ~ 374	1990 No.3-56 1"-12 p. 145	2874 No.4-48 1"-12 p. 145				
G Rohrgewinde	-	DIN 5156	967 G 1/16 G 7/8 p. 147	2875 G 1/8 G 1 p. 147				938 G 1/8 G 1/4 p. 147

○ bright ● steam tempered ● nitrided Ⓐ TiAlN Ⓒ TiCN Ⓢ TiN Ⓟ AlCrN Ⓜ MolyGlide



Blind holes

≤1.5xD		≤3xD						
HSS-E		HSS-E				PM HSS-E		
VA R15/C	VA R15/C	VA R40/C	VA R40/C	VA R40/C	VA R40/C	VA R40/C	VA R40/C	VA R50/C
			preferred tools 				preferred tools 	only suitable with synchro tapping
Guhring no. Ø-range Prices on page		Guhring no. Ø-range Prices on page						
843 M3 - M10 p. 130	2896 M3 - M10 p. 130	814 M3 - M10 p. 130	2862 M3 - M10 p. 130	1892 M5 - M10 p. 131	2512 M5 - M10 p. 131	909 M3 - M10 p. 130	59 M3 - M10 p. 130	
								761 M3 - M10 p. 132
785 M12 - M24 p. 134	2895 M12 - M24 p. 134	825 M12 - M24 p. 134	2863 M12 - M24 p. 134	1899 M12 - M20 p. 135		910 M12 - M24 p. 134	60 M12 - M20 p. 134	
								763 M12 - M20 p. 136
1874 M4x0,5 - M22x2 p. 138	2897 M4x0,5 - M24x1,5 p. 138	777 M3x0,35 - M30x1,5 p. 138	2864 M3x0,35 - M24x1,5 p. 138	1906 M5x0,5 - M20x1,5 p. 139		936 M8x1 - M20x1,5 p. 138		764 M8x1 - M20x1,5 p. 140
		1981 No.2-56 - 3/8"-16 p. 142	2865 No.2-56 - 3/8"-16 p. 142					
		1986 7/16"-14 - 7/8"-9 p. 144	2866 7/16"-14 - 7/8"-9 p. 144					
1991 No.3-56 - 1"-12 p. 146	2898 No.3-56 - 1"-12 p. 146	2867 No.6-56 - 1"-12 p. 146	2868 No.3-56 - 1"-12 p. 146					
			968 G 1/16 - G1 1/2" p. 148			939 G 1/8 - G1 1/2" p. 148		

Taps Compass

external coolant internal radial coolant internal axial coolant through hole blind hole

Taps for universal application in materials < 1000 N/mm²

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

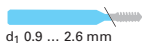


Taps Compass

Material examples	
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 cast iron	
0.7040	EN-GJS-400-15
0.7060	EN-GJS-600-3

Shank designs

DIN 371



d₁ > 2.6 ... 10 mm

DIN 376 / DIN 374 / DIN 5156



Type clarification

- (K) = corrected angle of hel. flute
- NR40 = Type N, RH spiral 40°
- NR50 = Type N, RH spiral 50°

* With solid carbide taps cutting speed v_c can be doubled.

Through holes

			≤3xD						
			HSS-E				PM HSS-E		Solid carbide*
Thread depth									
Tool material									
Type/form	N/B	N/B	N/B	N/B	N/B	N/B	N/B	N/B	
Surface finish	●	● S	● A+M	● A+M	● S	● C	● S	●	
Cooling	☒	☒	☒	☒	☒	☒	☒	☒	
Rec. parameters*			preferred tools						
for un-coated tools v _c ≤ 15 m/min									
for coated tools v _c ≤ 30 m/min									
 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 M3 - M10 p. 149	313 M3 - M10 p. 149	2427 M3 - M10 p. 149	2517 M5 - M10 p. 150	1285 M3 - M10 p. 149	1287 M3 - M10 p. 149	
			2990 M3 - M10 p. 156	2991 M3 - M10 p. 156					
	6HX	~ DIN 371							942 * M5 - M12 p. 155
	ISO 2 6H	DIN 376	2877 M3 - M36 p. 158	315 M3 - M16 p. 158	2428 M3 - M16 p. 158		1286 M12 - M20 p. 158		
MF	6HX	~ DIN 371							943 * M5x0,5 - M12x1,5 p. 162
	ISO 2 6H	DIN 374	2879 M3x0,35 - M52x1,5 p. 163		2878 M3x0,35 - M24x1,5 p. 163		1291 M8x1 - M24x2 p. 163		
	6HX								944 * M14x1 - M16x1,5 p. 165
	ISO 3 6G		2992 M8x1 - M18x1,5 p. 166	2993 M8x1 - M18x1,5 p. 166					
UNC	2B	DIN ~ 371	2881 No.4-40 - 3/8"-16 p. 168		2880 No.4-40 - 3/8"-16 p. 168				
	2B	DIN ~ 376	2883 7/16"-14 - 1"-8 p. 170		2882 7/16"-14 - 1"-8 p. 170				
UNF	2B	DIN ~ 374	2885 No.4-48 - 1"-12 p. 172		2884 No.4-48 - 1"-12 p. 172				
G BSP	-	DIN 5156	2887 G 1/8 - G2" p. 174		2886 G 1/8 - G1" p. 174				

○ bright ● steam tempered ● nitrided ●**A** TiAlN ●**C** TiCN ●**S** TiN ●**P** AlCrN ●**M** MolyGlide



Blind holes

≤3xD

HSS-E							PM HSS-E		
NR40/C	NR40/C	NR40/C	NR40/C	NR40/C	NR40/E	NR40/C(K)	NR40/C	NR40/C	NR50/C
	preferred tools								
Guhring no. Ø-range Prices on page									
889 M2 - M10 p. 151	836 M3 - M10 p. 152	2440 M3 - M10 p. 152	2425 M3 - M10 p. 152	2514 M5 - M10 p. 154	2790 M4 - M10 p. 152	174 M5 - M10 p. 152	1288 M3 - M10 p. 153	1290 M3 - M10 p. 153	767 M3 - M10 p. 153
	2994 M3 - M10 p. 157	2995 M3 - M10 p. 157							
890 M3 - M24 p. 159	826 M3 - M36 p. 160	2441 M3 - M24 p. 160	2426 M3 - M16 p. 160		2791 M4 - M16 p. 160	196 M5 - M30 p. 160	1289 M12 - M20 p. 161		1098 M12 - M20 p. 161
2424 M5x0,5 - M24x2 p. 164	2853 M5x0,5 - M30x2 p. 164				2792 M8x1 - M14x1,5 p. 164	273 M5x0,5 - M24x1,5 p. 164	1292 M8x1 - M24x2 p. 164		1100 M8x1 - M20x1,5 p. 164
2998 M8x1 - M20x1,5 p. 167	2999 M10x1 - M20x1,5 p. 167	1049 M8x1 - M20x1,5 p. 167							
2854 No.2-56 - 3/8"-16 p. 169	2855 No.2-56 - 3/8"-16 p. 169					1837 No.10-24 - 3/8"-16 p. 169			
2856 7/16"-14 - 1"-8 p. 171	2857 7/16"-14 - 7/8"-9 p. 171								
2858 No.3-56 - 1"-12 p. 173	2859 No.3-56 - 1"-12 p. 173					1838 No.10-32 - 1"-12 p. 173			
2860 G 1/16 - G1 1/2" p. 175	2861 G 1/16 - G2" p. 175					937 G 1/8 - G1 1/2" p. 175			

Taps Compass

external coolant
 internal radial coolant
 internal axial coolant
 through hole
 blind hole

Taps for Aluminium and Al-alloys ≤ 10% Si

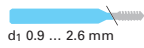


Material examples

Material no. to DIN EN 10 027	Abbreviation
Al and Al-alloys	
3.0250 3.0280 3.3308	Al 99,5H AL 99,8H Al99,9Mg0,5
Al rough alloys	
3.2315 3.1655 3.4335	AlMgSi1 AlCuMgPb AlZn4,5Mg1
Al cast alloys ≤ 10% Si	
3.2134 3.2162 3.2373	GD-AlSi5Cu1Mg GD-AlSi8Cu3 G-AISI9Mg
Al cast alloys > 10% Si	
3.2581 3.2583 3.2581	G-AISI12 G-AISI12Cu G-AISI10Mg

Shank designs

DIN 371



d₁ > 2.6 ... 10 mm

DIN 376 / DIN 374 / DIN 5156



Type clarification

Al = for Aluminium
AIR15 = for Al, RH spiral 15°
AIR45 = for Al, RH spiral 45°
NR15 = Type N, RH spiral 15°
NL15 = Type N, LH spiral 15°

* With solid carbide taps cutting speed v_c can be doubled.

** < M5 without coolant ducts

Through holes

Blind holes

			1.5	≤3xD	≤3xD
Thread depth					
Tool material			HSS-E	HSS-E	HSS-E
Type/form			N/B	AI/B	AIR45/B
Surface finish			○	○	○
Cooling			☒	☒	☒
Rec. parameters*			for machining sheet metal	preferred tools	preferred tools
for un-coated tools v _c ≤ 15 m/min					
for coated tools v _c ≤ 30 m/min					
 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	838 M1.4 - M10 p. 176	805 M2 - M10 p. 177	812 M1.6 - M10 p. 178
			869 M2 - M10 p. 185		
	ISO 2 6H	DIN 376	846 M3 - M20 p. 186	817 M12 - M24 p. 187	824 M3 - M24 p. 188
	ISO 3 6G		870 M10 - M20 p. 191		
MF	ISO 2 6H	DIN 371			
	ISO 2 6H	DIN 374			

Taps for Aluminium and Al-alloys > 10% Si



Through holes

$\leq 3 \times D$		
Solid carbide*		
H/C	NL15/D	NL15/D
	preferred tools	
Guhring no. Ø-range Prices on page	Guhring no. Ø-range Prices on page	
1858 M5 - M10 p. 179	970 M5 - M8 p. 180	2507 M5 - M10 p. 181
1859 M12 - M20 p. 189		
1861 M5x0.5 - M10x1 p. 192	975 ** M4x0.5 - M10x1 p. 193	
1860 M12x1.5 - M16x1.5 p. 196	976 M12x1.5 - M18x1.5 p. 197	



Blind holes

$\leq 3 \times D$			
Solid carbide*			
H/C	H/C	NR15/D	NR15/D
		preferred tools	
Guhring no. Ø-range Prices on page			
969 ** M3 - M10 p. 182	1858 M5 - M10 p. 179	971 ** M3 - M10 p. 183	2516 M5 - M10 p. 184
1883 M12 - M20 p. 190	1859 M12 - M20 p. 189		
972 ** M4x0.5 - M10x1 p. 194	1861 M5x0.5 - M10x1 p. 192	977 ** M4x0.5 - M10x1 p. 195	
974 M12x1.5 - M16x1.5 p. 198	1860 M12x1.5 - M16x1.5 p. 196	978 M12x1.5 - M18x1.5 p. 199	

Taps for cast materials



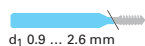
Taps Compass

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 & 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

Shank designs

DIN 371



d₁ 0.9 ... 2.6 mm



d₁ > 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, RH spiral 15°

* With solid carbide taps cutting speed v_c can be doubled.

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

			≤3xD					
			HSS-E					
			GG/C	GG/C	GG/C	GG/C	GGT/C	GGT/C
			●	Ⓢ	Ⓐ	●	Ⓢ	Ⓐ
			☒	☒	a	a	☒	☒
Rec. parameters*			preferred tools				preferred tools	
for un-coated tools v _c ≤ 20 m/min								
for coated tools v _c ≤ 30 m/min								
Tools with colour-ring								
Thread type	Tolerance zone	Dim. to DIN 2184-1	Gühring no. Ø-range Prices on page					
M	ISO 2 6H	DIN 371					1875 M3 - M10 p. 200	
	6HX		807 M3 - M10 p. 204	930 M3 - M10 p. 204	318 M5 - M10 p. 205	1890 M5 - M10 p. 205		1918 M3 - M10 p. 204
	ISO 2 6H	DIN 376					1876 M3 - M30 p. 206	
M	6HX		819 M3 - M30 p. 209	931 M3 - M30 p. 209	319 M12 - M20 p. 210	1897 M12 - M20 p. 210		1919 M3 - M20 p. 209
	ISO 2 6H	DIN 371						
MF	ISO 2 6H	DIN 374						
	6HX		831 M3x0.35 - M30x1.5 p. 215	932 M3x0.35 - M30x1.5 p. 215	347 M8x1 - M24x1.5 p. 216	1904 M8x1 - M20x1.5 p. 216		169 M3x0.35 - M24x1.5 p. 215
UNC	2B	~ DIN 371	1979 No.2-56 - 3/8"-16 p. 217					
	2B	~ DIN 376	1984 7/16"-14 - 1"-8 p. 218					
UNF	2B	~ DIN 374	1989 No.3-56 - 1"-12 p. 219					
BSW	-	~ DIN 371	1973 W 1/8" - W 3/8" p. 220					
	-	~ DIN 376	1975 W 3/8" - W1" p. 221					
G BSP	-	DIN 5156	961 G 1/16 - G2" p. 222					

○ bright ● steam tempered ● nitrided Ⓐ TiAlN Ⓒ TiCN Ⓢ TiN Ⓟ AlCrN Ⓜ MolyGlide

Taps for long-chipping non-ferrous metals (Ms, Cu, Bronze)

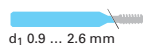


Taps Compass

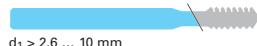
Material examples	
Material no.	Abbreviation
Brass, short-chipping	
2.0380 2.0401 2.0410	CuZn39Pb2 CuZn39Pb3 CuZn43Pb2
Brass, long-chipping	
2.0250 2.0280 2.0332	CuZn20 CuZn33 CuZn37Pb0,5

Shank designs

DIN 371



d_1 0.9 ... 2.6 mm

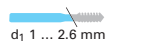


d_1 > 2.6 ... 10 mm

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

* With solid carbide taps cutting speed v_c can be doubled.

** < M5 without coolant ducts

Type clarification







Ms = for brass

NR15 = Typ N, RH spiral 15°

NR40 = Type N, RH spiral 40°




Through holes

Blind holes






			≤3xD			≤3xD		
			HSS-E			HSS-E		
			N/B	N/B	N/B	NR15/C	NR40/C	NR15/C
			○	○	○	○	○	○
			☒	☒	☒	☒	☒	☒ a
Rec. parameters* for un-coated tools $v_c \leq 15$ m/min			for machining sheet metal			preferred tools		
								
Thread type	Tolerance zone	Dim. to DIN 2184-1	Guhring no. Ø-range <i>Prices on page</i>			Guhring no. Ø-range <i>Prices on page</i>		
M	ISO 2 6H	DIN 371	839 M1 - M10 <i>p. 224</i>	838 M1.4 - M10 <i>p. 225</i>	809 M2 - M10 <i>p. 226</i>	889 M2 - M10 <i>p. 227</i>	1891 M5 - M10 <i>p. 228</i>	
			796 M2 - M10 <i>p. 233</i>	869 M2 - M10 <i>p. 234</i>				
	ISO 2 6H	DIN 376	847 M3 - M10 <i>p. 235</i>	846 M3 - M20 <i>p. 236</i>	821 M3 - M30 <i>p. 237</i>	890 M3 - M24 <i>p. 238</i>	1898 M12 - M20 <i>p. 239</i>	
			ISO 3 6G		870 M10 - M20 <i>p. 241</i>			
MF	ISO 2 6H	DIN 371						
	ISO 2 6H	DIN 374						
M short version	ISO 2 6H	Dim. to DIN 2184-2 DIN 352	991 M2 - M24 <i>p. 244</i>					

Taps for short-chipping non-ferrous metals (Ms, Cu, Bronze)

Through holes

$\leq 3 \times D$		
HSS-E		Solid carbide*
H/C	Ms/C	H/C
○	○	○
☒	☒	r
preferred toola		
		
Gühring no. Ø-range Prices on page		
	800 M3 – M10 p. 229	1858 M5 – M10 p. 230
996 M2 – M12 p. 245		

Blind holes

$\leq 3 \times D$				
HSS-E		Solid carbide*		
H/C	Ms/C	NR15/C	H/C	H/C
○	○	○	○	○
☒	☒	a	a	r
preferred toola				
				
Gühring no. Ø-range Prices on page				
	800 M3 – M10 p. 229	971** M3 – M10 p. 231	969** M3 – M10 p. 232	1858 M5 – M10 p. 230
			1883 M12 – M20 p. 240	
			972** M4x0.5 – M10x1 p. 242	
			974 M12x1.5 – M16x1.5 p. 243	
996 M2 – M12 p. 245				

Taps Compass

Taps for plastics



Through holes



Blind holes

Material examples	
Special application hints	Abbreviation
Duroplastics	
-	Bakelit Resopal Pertinax Moltopren
Thermoplastics	
-	Plexiglas Hostalen Novodur Makralon
Glass-/carbon-reinforced plastics	
-	Polypropylen GFK CFK

Shank designs

DIN 371



d₁ > 2.6 ... 10 mm

DIN 376 / DIN 374



Type clarification

HAZ = with interrupted threads

NL15 = Type N, LH spiral 15°

NR15 = Type N, RH spiral 15°

* With solid carbide taps cutting speed v_c can be doubled.

** < M5 without coolant ducts

Rec. parameters* for un-coated tools v _c ≤ 8 m/min			Through holes			Blind holes		
			≤3xD			≤3xD		
preferred tools			HSS-E			Solid carbide*		
			HAZ/C	NL15/C	H/C	HAZ/C	NR15/C	H/C
preferred tools			HSS-E			Solid carbide*		
			HAZ/C	NL15/C	H/C	HAZ/C	NR15/C	H/C
preferred tools			HSS-E			Solid carbide*		
			HAZ/C	NL15/C	H/C	HAZ/C	NR15/C	H/C
preferred tools			HSS-E			Solid carbide*		
			HAZ/C	NL15/C	H/C	HAZ/C	NR15/C	H/C
preferred tools			HSS-E			Solid carbide*		
			HAZ/C	NL15/C	H/C	HAZ/C	NR15/C	H/C
Cooling			☒	☒	☒	☒	☒	☒
Thread depth			☒			☒		
Tool material			☒			☒		
Type/form			☒			☒		
Surface finish			☒			☒		
Cooling			☒			☒		
Thread type			M			MF		
Tolerance zone			ISO 2 6H			ISO 2 6H		
Dim. to DIN 2184-1			DIN 371			DIN 371		
Guhring no.			788			788		
Ø-range			M2			M2		
Prices on page			p. 246			p. 246		
Guhring no.			970			970		
Ø-range			M5			M5		
Prices on page			p. 247			p. 247		
Guhring no.			1858			1858		
Ø-range			M5			M5		
Prices on page			p. 248			p. 248		
Guhring no.			971 **			971 **		
Ø-range			M3			M3		
Prices on page			p. 249			p. 249		
Guhring no.			969 **			969 **		
Ø-range			M3			M3		
Prices on page			p. 250			p. 250		
Guhring no.			1858			1858		
Ø-range			M5			M5		
Prices on page			p. 248			p. 248		
Guhring no.			1859			1859		
Ø-range			M12			M12		
Prices on page			p. 251			p. 251		
Guhring no.			975 **			975 **		
Ø-range			M4x0.5			M4x0.5		
Prices on page			p. 253			p. 253		
Guhring no.			1861			1861		
Ø-range			M5x0.5			M5x0.5		
Prices on page			p. 254			p. 254		
Guhring no.			977 **			977 **		
Ø-range			M4x0.5			M4x0.5		
Prices on page			p. 255			p. 255		
Guhring no.			972 **			972 **		
Ø-range			M4x0.5			M4x0.5		
Prices on page			p. 256			p. 256		
Guhring no.			1861			1861		
Ø-range			M5x0.5			M5x0.5		
Prices on page			p. 254			p. 254		
Guhring no.			976			976		
Ø-range			M12x1.5			M12x1.5		
Prices on page			p. 257			p. 257		
Guhring no.			1860			1860		
Ø-range			M12x1.5			M12x1.5		
Prices on page			p. 258			p. 258		
Guhring no.			978			978		
Ø-range			M12x1.5			M12x1.5		
Prices on page			p. 259			p. 259		
Guhring no.			974			974		
Ø-range			M12x1.5			M12x1.5		
Prices on page			p. 260			p. 260		
Guhring no.			1860			1860		
Ø-range			M12x1.5			M12x1.5		
Prices on page			p. 258			p. 258		

Taps for special alloys (Titanium and Nickel)



Through holes

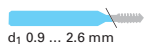


Blind holes

Material examples	
Material no. to DIN EN 10 027	Abbreviation
Titanium	
3.7025 3.7065	Ti Ti
Titanium-alloys	
3.7115 3.7165	TiAl 5Sn2 TiAl 6V4
Special alloys	
2.4610 2.4876 2.4816 2.4668 2.4634	Hastelloy C4 Incoloy 800 Inconel 600 Inconel 718 Nimonic 105 CuNi12Zn24 CuNi18Zn20

Shank designs

DIN 371



Type clarification

TiR30 = for Titanium, RH spiral 30°
NiR15 = for Nickel, RH spiral 15°

			Through holes			Blind holes		
			≤1.5xD			≤1xD		
			PM HSS-E			PM HSS-E		
			Ti/B	Ti/B	Ni/B	TiR30/C	TiR30/C	NiR15/C
			○	●	○	○	●	○
			☒	☒	☒	☒	☒	☒
			preferred tools			preferred tools		
			Titanium-alloys: v _c ≤ 8 m/min			Titanium-alloys: v _c ≤ 4 m/min		
			Nickel-alloys: v _c ≤ 4 m/min					
Thread type	Tolerance zone	Dim. to	Guhring no. Ø-range Prices on page			Guhring no. Ø-range Prices on page		
M	ISO 2 6H	DIN ~ 371	2900 M3 M10 p. 261	2901 M3 M10 p. 261	2916 M3 M10 p. 261	2908 M3 M10 p. 262	2909 M3 M10 p. 262	2920 M3 M10 p. 263
			2902 M3x0.35 M10x1 p. 264	2903 M3x0.35 M10x1 p. 264	2917 M3x0.35 M10x1.25 p. 264	2910 M3x0.35 M10x1 p. 265	2911 M3x0.35 M10x1 p. 265	2921 M3x0.35 M10x1.25 p. 266
UNC	2B	DIN ~ 371	2904 No.6-32 3/8"-16 p. 267	2905 No.6-32 3/8"-16 p. 267		2912 No.6-32 3/8"-16 p. 267	2913 No.6-32 3/8"-16 p. 267	
					2918 No.6-32 3/8"-16 p. 268		2922 No.6-32 3/8"-16 p. 269	
UNF	2B	DIN ~ 371	2906 No.6-40 3/8"-24 p. 270	2907 No.6-40 3/8"-24 p. 270		2914 No.6-40 3/8"-24 p. 270	2915 No.6-40 3/8"-24 p. 270	
					2919 No.6-40 3/8"-24 p. 271		2923 No.6-40 3/8"-24 p. 272	

Taps Compass

☒ external coolant

☒ internal radial coolant

☒ internal axial coolant

☒ through hole

☒ blind hole

Hand taps for general steels $\leq 800 \text{ N/mm}^2$



Through and blind hole



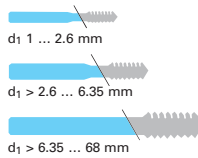
Taps Compass

Material examples

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-treatable 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



Second tap



Bottoming tap



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 $\leq 800 \dots 1200 \text{ N/mm}^2$ for stainless and acid-resistant steels										
Thread type	Tolerance zone	Dim. to DIN 2184-2	Guhring no.						\emptyset -range	
Prices on page										
M	ISO 2 6H	DIN 352	861 (Set) consisting of: 862 863 M1 - M36 p. 274	864	882 (Set) consisting of: 883 M2 - M12 p. 276	864	905	904 (Set) consisting of: 906 M2.2 - M22 p. 277	907	
MF	ISO 2 6H	DIN 2181			884 (Set) consisting of: 885 M2x0.25 - M36x1.50 p. 278	886				
UNC	2B	~ DIN 352	981 (Set) consisting of: 982 983 No.1-64 - 2"-4,5 p. 280	984						
UNF	2B	~ DIN 2181			985 (Set) consisting of: 986 No.1-72 - 1 3/8"-12 p. 281	987				
BSW	-	~ DIN 352	954 (Set) consisting of: 955 956 W1/16" - W2" p. 282	957						
G BSP	-	DIN 5157			958 (Set) consisting of: 959 G1/8" - G2" p. 283	960				

