

## Don't compromise - choose Guhring Taps

- Precision ground for perfect threads every time
- Premium cobalt for longer tool life
- A full range UNC, UNF and Metric sizes,
- Color ring system for quick and easy tap selection process
- Class of fit designation simplifies tap tolerance selection

Guhring has simplified the process of finding the right tap for your application. The color ring designation on each Guhring tap specifies the application best suited for the tap, and our class of fit tolerances takes the guesswork out of selecting thread tolerances. We've highlighted two of our most popular cut taps, to illustrate a good starting point for introducing Guhring taps which can be used in some of the most common workpiece materials.

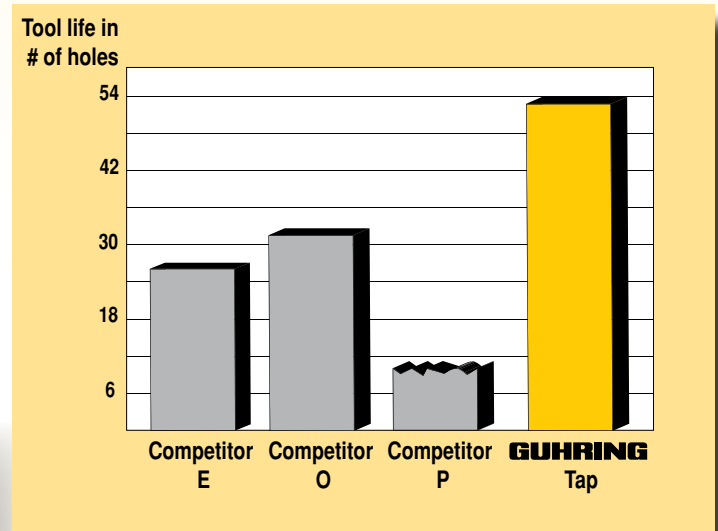


Green ring taps are designed to thread a wide range of materials from carbon & alloyed steel to ductile iron. This style tap is perfect for a job shop that needs a longer tool life for a wide range of applications. See reverse side for a sample of stocked sizes and styles.



Blue ring taps are specifically designed for stainless steel CNC tapping applications, but can also be used in alloyed and heat treated steel parts. These taps have a powdered metal cobalt substrate for added wear resistance and are the best choice for those hard-to-tap applications.

### Longer tool life from premium cobalt Guhring taps



In an blind hole in 316 stainless steel, Guhring's Series 3907 blue ring semi-bottoming tap, size 1/4-20, went head-to-head against three competitors to find the best tool life. The Guhring tap outperformed the others by up to 49% - not counting one competitor's tap which broke after only 8 holes.



Check out [www.guhring.com/products](http://www.guhring.com/products) & services for full details on Guhring cut and form taps. Visit our Technical section for running parameters and more valuable information.

### Haven't tried a Guhring tap yet?

Put us to the test. All Guhring taps are guaranteed to reduce your manufacturing costs or the tool is free. Guhring stands behind the quality of our taps. Ask your Authorized Guhring distributor for a guaranteed test & trial tap, and discover why Guhring taps should be the tap of choice in your shop.



Size	Universal (Green Ring)				Stainless Steels (Blue Ring)			
	Class of fit	Through (plug)	Blind (bottoming)	Order Code	Class of fit	Through (plug)	Blind (bottoming)	Order Code
		Series	Series			Series	Series	
2-56	2B	3916	3922	2.184	2B			
2-64	2B	3917	3923	2.184	2B			
3-48	2B	3916	3922	2.515	2B			
3-56	2B	3917	3923	2.515	2B			
4-40	2B	3916	3922	2.845	2B	3907	3910	2.845
4-48	2B	3917	3923	2.845	2B	3908	3911	2.845
5-40	2B	3916	3922	3.175	2B	3907	3910	3.175
5-44	2B	3917	3923	3.175	2B	3908	3911	3.175
6-32	2B	3916	3922	3.505	2B	3907	3910	3.505
6-40	2B	3917	3923	3.505	2B	3908	3911	3.505
8-32	2B	3916	3922	4.166	2B	3907	3910	4.166
8-36	2B	3917	3923	4.166	2B	3908	3911	4.166
10-24	2B	3916	3922	4.826	2B	3907	3910	4.826
10-32	2B	3917	3923	4.826	2B	3908	3911	4.826
12-24	2B	3916	3922	5.486	2B	3907	3910	5.486
12-28	2B	3917	3923	5.486	2B	3908	3911	5.486
1/4-20	2B	3916	3922	6.350	2B	3907	3910	6.350
1/4-28	2B	3917	3923	6.350	2B	3908	3911	6.350
5/16-18	2B	3916	3922	7.938	2B	3907	3910	7.938
5/16-24	2B	3917	3923	7.938	2B	3908	3911	7.938
3/8-16	2B	3916	3922	9.525	2B	3907	3910	9.525
3/8-24	2B	3917	3923	9.525	2B	3908	3911	9.525
7/16-14	2B	3916	3922	11.113	2B	3907	3910	11.113
7/16-20	2B	3917	3923	11.113	2B	3908	3911	11.113
1/2-13	2B	3916	3922	12.700	2B	3907	3910	12.700
1/2-20	2B	3917	3923	12.700	2B	3908	3911	12.700
9/16-12					2B	3907	3910	14.288
9/16-18					2B	3908	3911	14.288
5/8-11	2B	3916	3922	15.875	2B	3907	3910	15.875
5/8-18	2B	3917	3923	15.875	2B	3908	3911	15.875
3/4-10	2B	3916	3922	19.050	2B	3907	3910	19.050
3/4-16	2B	3917	3923	19.050	2B	3908	3911	19.050
7/8-9	2B	3916	3922	22.225	2B	3907	3910	22.225
7/8-14	2B	3917	3923	22.225	2B	3908	3911	22.225
1-8	2B	3916	3922	25.400	2B	3907	3910	25.400
1-12	2B	3917	3923	25.400	2B	3908	3911	25.400
1 1/4-7	2B	3916	3922	31.750	2B			
1 1/4-12	2B	3917	3923	31.750	2B			
1 1/2-6	2B	3916	3922	38.100	2B			
1 1/2-12	2B	3917	3923	38.100	2B			

Size	Universal (Green Ring)				Stainless Steels (Blue Ring)			
	Class of fit	Through (plug)	Blind (bottoming)	Order Code	Class of fit	Through (plug)	Blind (bottoming)	Order Code
		Series	Series			Series	Series	
M2 X 0.40	6H	3915	3921	2.000	6H	3906	3909	2.000
M3 X 0.50	6H	3915	3921	3.000	6H	3906	3909	3.000
M4 X 0.70	6H	3915	3921	4.000	6H	3906	3909	4.000
M5 X 0.80	6H	3915	3921	5.000	6H	3906	3909	5.000
M6 X 1.00	6H	3915	3921	6.000	6H	3906	3909	6.000
M8 X 1.00	6H	3973	3974	8.005	6H			
M8 X 1.25	6H	3915	3921	8.000	6H	3906	3909	8.000
M10 X 1.00	6H	3973	3974	10.005	6H			
M10 X 1.25	6H	3973	3974	10.006	6H			
M10 X 1.50	6H	3915	3921	10.000	6H	3906	3909	10.000
M12 X 1.00	6H	3973	3974	12.005	6H			
M12 X 1.25	6H	3973	3974	12.006	6H			
M12 X 1.50	6H	3973	3974	12.007	6H			
M12 X 1.75	6H	3915	3921	12.000	6H	3906	3909	12.000
M14 X 1.25	6H	3973	3974	14.006	6H			
M14 X 1.50	6H	3973	3974	14.007	6H			
M14 X 2.00	6H	3915	3921	14.000	6H	3906	3909	14.000
M16 X 1.50	6H	3973	3974	16.007	6H			
M16 X 2.00	6H	3915	3921	16.000	6H	3906	3909	16.000
M18 X 1.50	6H	3973	3974	18.007	6H			
M18 X 2.50	6H	3915	3921	18.000	6H	3906	3909	18.000
M20 X 1.50	6H	3973	3974	20.007	6H			
M20 X 2.50	6H	3915	3921	20.000	6H	3906	3909	20.000

To order: Specify Series and Order Code. Example: 3907 19.050



## What's the correct drill size for my tap?

Guhring has an easy-to-use Tap Drill Calculator to help you determine the correct drill size for a given tapped hole size. The calculator can work in mm, inch or wire sizes, and returns both metric and inch drill diameter values. Go to [www.guhring.com](http://www.guhring.com), click on the Technical tab, and the Tap Drill Calculator is the first option listed on the left-hand menu.