

GUHRING

The Tool Company

THE BEST OF BOTH SYSTEMS

THE ADVANTAGES OF HYDRAULIC
CHUCKS & SYNCHRO TAPPING CHUCKS
IN ONE TOOL HOLDER



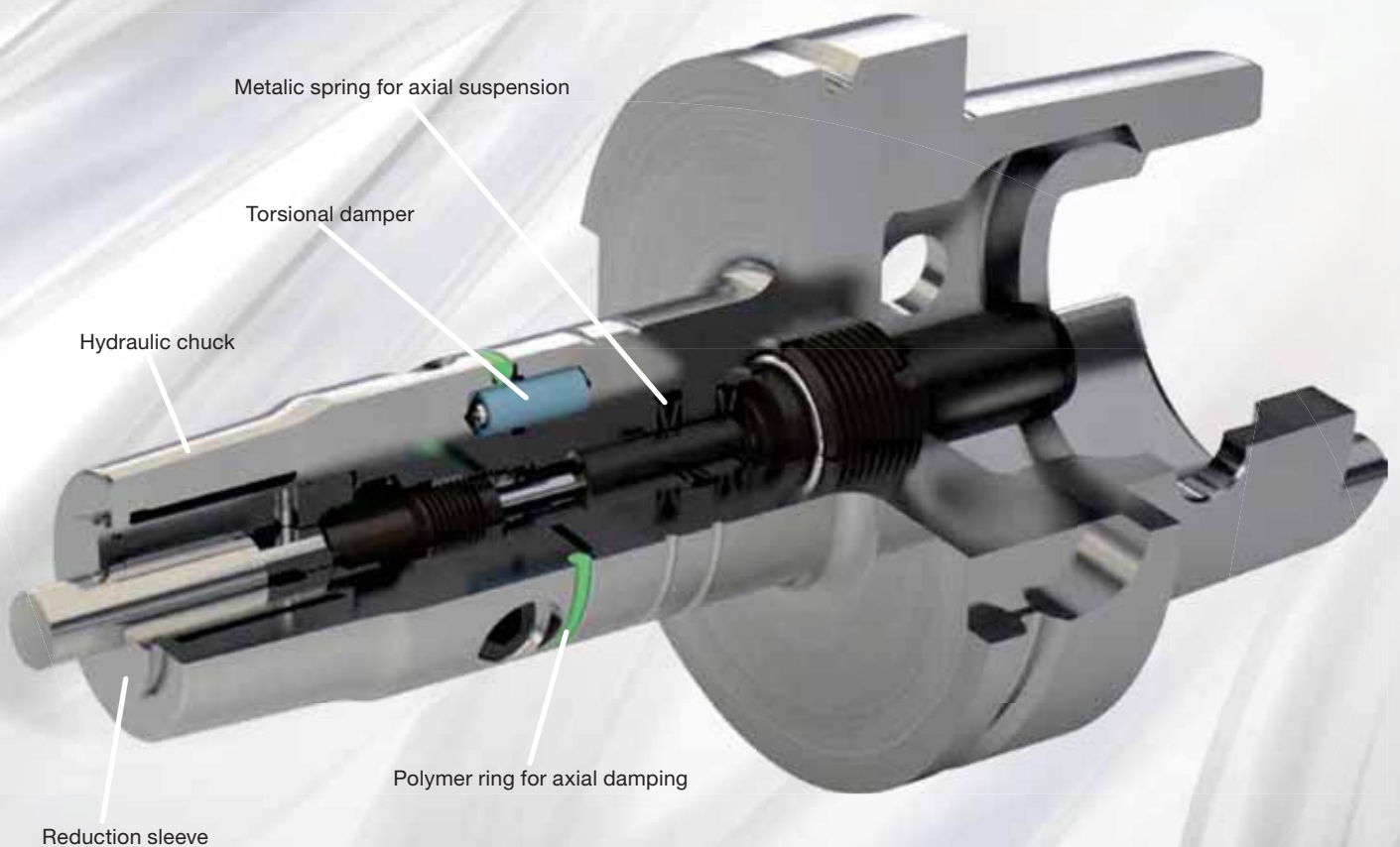
GUHROSynch

Synchro tapping chucks

GUHRING - YOUR WORLD-WIDE PARTNER

GUHROSYNC

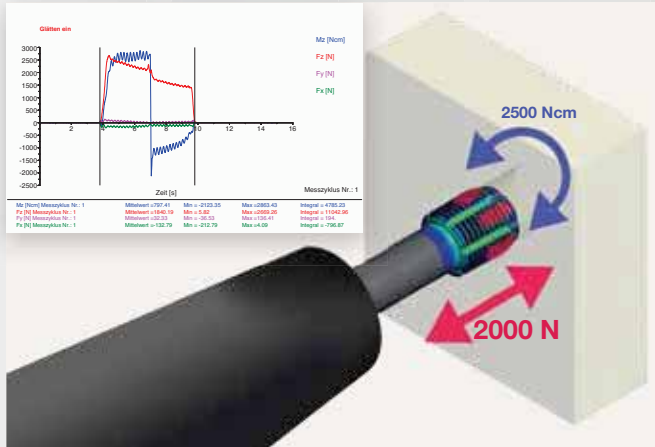
THE EASY WAY
TO THE PERFECT THREAD



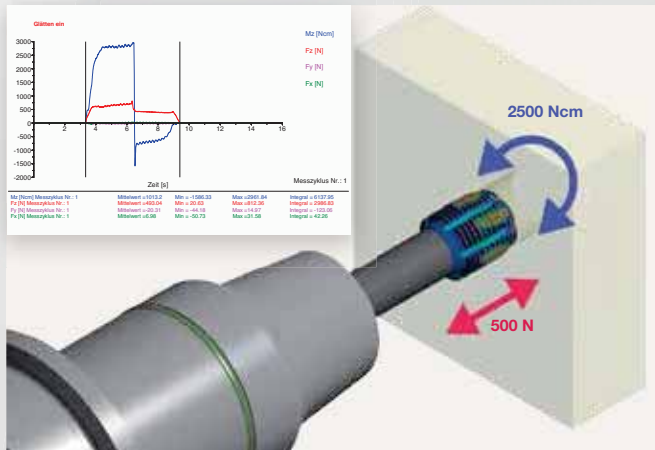
Intelligent design:

As well as the suspension and damping elements in the slender GUHROSync chucks (for the reduction of axial and radial forces during the tapping process) there is also room for the delivery set for MQL or conventional cooling lubrication and the length setting screw.

The optimal combination of long-life metal spring and polymer damping elements considerably reduces axial and radial forces



Rigid chuck



GUHROSynC

➔ **IMPROVED
TOOL LIFE**

➔ **IMPROVED THREAD
QUALITY**

➔ **GREATER PROCESS
RELIABILITY**



GUHRING

Made visible:
The spring symbol on the GUHROSynC displays the effect of axial and radial force.



*REDUCTION OF AXIAL
AND RADIAL FORCES*



*COMPENSATES
SYNCHRONIZATION ERRORS*



*QUICK AND ACCURATE
LENGTH SETTING OF TOOLS*



*MODULAR DESIGN
FOR DIFFERENT STANDARD
AND SPECIAL VERSIONS*



*LONGER
TOOL LIFE*



*REDUCED
CYCLE TIMES*



*IMPROVED
THREAD QUALITY*



*GREATER PROCESS
RELIABILITY*

GUHROSync synchro tapping chucks for internal cooling

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GUHROSync synchro tapping chucks for MQL

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Configuration of GUHROSynch synchro tapping chucks with straight shank for internal cooling

Side lock holders

4343 HSK-A

4322 ISO taper

4233 BT taper

4087 CAT taper

Shrink fit chucks

4736 HSK-A

4758 HSK-C

4764 CAT taper

Hydraulic synchro tapping chucks with increased clamping force

4221 MAS-BT

4299 HSK-A

4267 HSK-C

4213 ISO taper

4216 CAT taper

Hydraulic synchro tapping chucks

4601 HSK-A

Hydraulic synchro tapping chucks

4576 ISO taper

Hydraulic synchro tapping chucks

4577 MAS-BT



4525 Type B
Hydraulic synchro tapping chucks with cylindrical shank Ø 25, DIN 1835-B+E, internal cooling



4525 Type A
Hydraulic synchro tapping chucks with cylindrical shank Ø 20, DIN 1835-A, internal cooling



4364

Setting screws for synchro tapping chucks, with conventional int. cooling



4605

Sealed reduction sleeve

4606

GUHROJET reduction sleeve



Threading tool:
shank diameter x square

7

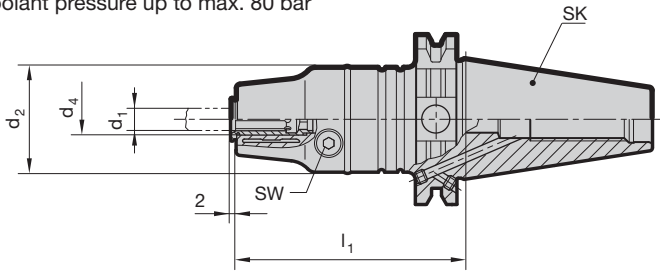
ISO taper hydraulic synchro tapping chucks with internal cooling

Product information

- SK30 to DIN ISO 7388 form AD without coolant supply over collar
- SK40 to DIN ISO 7388 form AD/AF
- form B supplied with threaded pins in bores
- compensates synchronization errors
- guarantees high thread quality and optimal tool life
- minimal length compensation in tension and compression direction balances very small pitch differences between synchro spindle and tap
- reduces an increase in axial forces during the cutting cycle to a minimum
- convenient hydraulic clamping using reduction sleeves with active drive
- length-setting screw allows 3 mm readjustment
- black colored polymer ring identifies conventional cooling
- coolant pressure up to max. 80 bar

Scope of delivery

- incl. hexagon clamping key
Guhring no. 4912
- incl. adjustment key for
adjustment screws
- order setting screw
Guhring no. 4364 separately
- order reduction sleeves
Guhring no. 4605 or 4606 separately
- order pull studs, Guhring no. 4925 or
4926 separately



|GÜHROJET|

Guhring no.

4576

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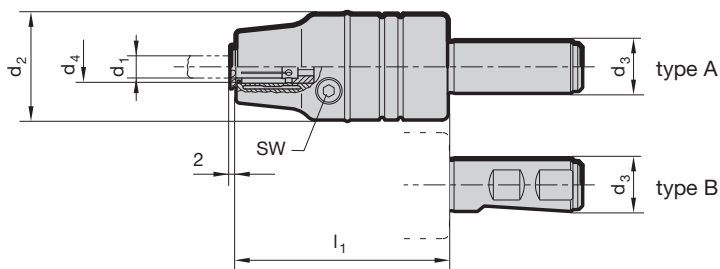
Straight shank hydraulic synchro tapping chucks for internal cooling

Product information

- compensates synchronization errors
- guarantees best thread quality and optimal life
- minimal length compensation in tension and compression direction balances very small pitch differences between synchro spindle and tap
- reduces an increase in axial forces during the cutting cycle to a minimum
- convenient hydraulic clamping using reduction sleeves with active drive
- length-setting screw allows 3 mm readjustment
- holder shank to DIN 1835-A (type A) for holding in precision chucks
- holder shank to DIN 1835-B+E (type B) for holding in side lock holders
- black colored polymer ring identifies conventional cooling
- coolant pressure up to max. 80 bar

Scope of delivery

- incl. hexagon clamping key
Guhring no. 4912
- incl. adjustment key for
adjustment screws
- order setting screw
Guhring no. 4364 separately
- order reduction sleeves
Guhring no. 4605 or 4606 separately



GÜHROJET

Guhring no.

4525

[illegible]

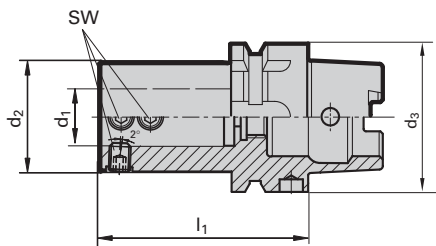
HSK-A adaptors for tapping chucks

Product information

- for quick change chucks and synchro tapping chucks with straight shank 25mm

Scope of delivery

- incl. clamping screws Guhring no. 4903, code no. 12,001
- order coolant delivery set Guhring no. 4949 separately

[illegible]

CAT shrink fit holder

Product information

- balancing quality G6.3 / 15.000 rev./min.
- incl. balancing threads 4 x M6
- taper according to ANSI/ASME B5.50
- Coolant through center and also through flange (plugged with threaded pins when supplied)
- CAT 40 - 5/8 x 11 retention knob thread
- CAT 50 - 1" x 8 retention knob thread

Scope of delivery

- Including setting screw, Guhring no. 4977 with axial force dampening for perfect runout accuracy
- Special dimensions on request

[illegible]

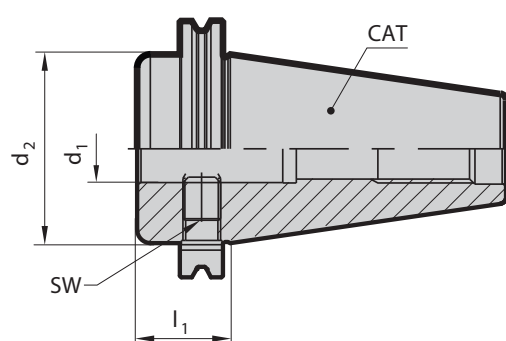
CAT side lock holder extra short

Product information

- balancing quality G6.3 / 15.000 rev./min.
- taper according to ANSI/ASME B5.50
- Coolant through center
- CAT 40 - 5/8 x 11 retention knob thread
- CAT 50 - 1" x 8 retention knob thread

Scope of delivery

- incl. clamping screw Guhring no. 4903

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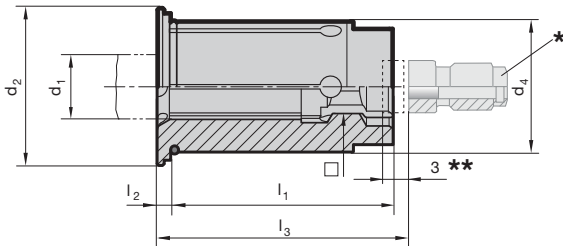
Sealed reduction sleeves for hydraulic synchro tapping chucks

Product information

- for clamping taps with square shank in GUHROSynch synchro tapping chucks
- clamping-Ø for tool shank tolerance h6-h9
- for threading tools with internal coolant
- positive drive
- position setting screw on tap shank
- length-setting screw allows 3 mm** readjustment

Scope of delivery

- order setting screw
Guhring no. 4364 separately
- order MQL setting screws
Guhring no. 4305 separately



Guhring no.

4605

d ₄ mm	d ₁ mm	□ mm	Standard	d ₁ inch	□ inch	d ₂ mm	l ₁ mm	l ₂ mm	l ₃ mm	* for adjustment screw	for thread	Code no.	EDP
12.00	2.800	2.100	DIN	-	-	16.50	29.00	2.00	-	-	M2 / M4	2.812	9046050028120
12.00	3.500	2.700	DIN	-	-	16.50	29.00	2.00	-	-	M3 / M4.5 / M5	3.512	9046050035120
12.00	4.000	3.200	JIS	-	-	16.50	29.00	2.00	-	-	M3	4.012	9046050040120
12.00	4.500	3.400	DIN	-	-	16.50	29.00	2.00	26.00	4364 5.020	M4 / M6	4.512	9046050045120
12.00	4.928	3.861	ANSI	0.194	0.152	16.50	29.00	2.00	26.00	4364 5.020	10-24 & 10-32	4.912	9046050049120
12.00	5.000	4.000	JIS	-	-	16.50	29.00	2.00	26.00	4364 5.020	M4	5.012	9046050050120
12.00	5.500	4.500	JIS	-	-	16.50	29.00	2.00	26.00	4364 5.020	M5	5.512	9046050055120
12.00	5.588	4.191	ANSI	0.220	0.165	16.50	29.00	2.00	26.00	4364 5.020	12-24 & 12-28	15.512	9046050155120
12.00	6.000	4.500	JIS	-	-	16.50	29.00	2.00	26.00	4364 5.020	M6	16.012	9046050160120
12.00	6.000	4.900	DIN	-	-	16.50	29.00	2.00	26.00	4364 6.020	M4.5/M5/M6/M8	6.012	9046050060120
12.00	6.200	5.000	JIS	-	-	16.50	29.00	2.00	26.00	4364 6.020	M7 / M8	6.212	9046050062120
12.00	6.477	4.851	ANSI	0.255	0.191	16.50	29.00	2.00	26.00	4364 6.020	1/4-20 & 1/4-28	6.412	9046050064120
12.00	7.000	5.500	DIN / JIS	-	-	16.50	29.00	2.00	26.00	4364 7.020	M7 / M9 / M10	7.012	9046050070120
12.00	7.938	5.944	ANSI	0.3125	0.234	16.50	29.00	2.00	31.00	4364 7.020	1/16-27	7.912	9046050079120
12.00	8.000	6.200	DIN	-	-	16.50	29.00	2.00	31.00	4364 8.020	M8 / M11	8.012	9046050080120
12.00	8.000	6.500	JIS	-	-	16.50	29.00	2.00	31.00	4364 8.020	M11	18.012	9046050180120
12.00	8.077	6.045	ANSI	0.318	0.238	16.50	29.00	2.00	31.00	4364 7.020	5/16-18 & 5/16-24	28.012	9046050280120
12.00	8.204	6.147	ANSI	0.323	0.242	16.50	29.00	2.00	31.00	4364 7.020	7/16-14 & 7/16-20	8.212	9046050082120
12.00	8.500	6.500	JIS	-	-	16.50	29.00	2.00	31.00	4364 8.020	M12	8.512	9046050085120
12.00	9.000	7.000	DIN	-	-	16.50	29.00	2.00	32.00	4364 9.020	M9 / M12	9.012	9046050090120
12.00	9.322	6.985	ANSI	0.367	0.275	16.50	29.00	2.00	32.00	4364 9.020	1/2-13 & 1/2-20	9.312	9046050093120
12.00	9.677	7.264	ANSI	0.381	0.286	16.50	29.00	2.00	33.00	4364 9.020	3/8-16 & 3/8-24	9.612	9046050096120
12.00	10.000	8.000	DIN	-	-	16.50	29.00	2.00	36.00	4364 10.020	M10	10.012	9046050100120

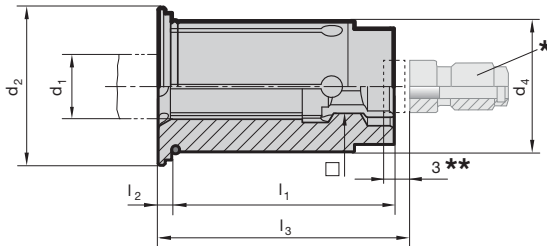
Sealed reduction sleeves for hydraulic synchro tapping chucks

Product information

- for clamping taps with square shank in GUHROSynch synchro tapping chucks
- clamping-Ø for tool shank tolerance h6-h9
- for threading tools with internal coolant
- positive drive
- position setting screw on tap shank
- length-setting screw allows 3 mm** readjustment

Scope of delivery

- order setting screw
Guhring no. 4364 separately
- order MQL setting screws
Guhring no. 4305 separately



Guhring no.

4605

d ₄ mm	d ₁ mm	□ mm	Standard	d ₁ inch	□ inch	d ₂ mm	l ₁ mm	l ₂ mm	l ₃ mm	* for adjustment screw	for thread	Code no.	EDP
20.00	6.000	4.500	JIS	-	-	24.10	34.00	2.00	26.00	4364 6.032	M6	26.020	9046050260200
20.00	6.000	4.900	DIN	-	-	24.10	34.00	2.00	26.00	4364 6.032	M4.5/M5/M6/M8	6.020	9046050060200
20.00	6.200	5.000	JIS	-	-	24.10	34.00	2.00	26.00	4364 6.032	M7 / M8	6.220	9046050062200
20.00	6.477	4.851	ANSI	0.255	0.191	24.10	34.00	2.00	26.00	4364 6.032	1/4-20 & 1/4-28	6.420	9046050064200
20.00	7.000	5.500	DIN / JIS	-	-	24.10	34.00	2.00	26.00	4364 7.032	M7 / M9 / M10	7.020	9046050070200
20.00	7.938	5.944	ANSI	0.3125	0.234	24.10	34.00	2.00	31.00	4364 7.032	1/16-27	7.920	9046050079200
20.00	8.000	6.200	DIN	-	-	24.10	34.00	2.00	31.00	4364 8.032	M8 / M11	8.020	9046050080200
20.00	8.000	6.500	JIS	-	-	24.10	34.00	2.00	31.00	4364 8.032	M11	18.020	9046050180200
20.00	8.077	6.045	ANSI	0.318	0.238	24.10	34.00	2.00	31.00	4364 8.032	5/16-18 & 5/16-24	28.020	9046050280200
20.00	8.204	6.147	ANSI	0.323	0.242	24.10	34.00	2.00	31.00	4364 8.032	7/16-14 & 7/16-20	8.220	9046050082200
20.00	8.500	6.500	JIS	-	-	24.10	34.00	2.00	31.00	4364 8.032	M12	8.520	9046050085200
20.00	9.000	7.000	DIN	-	-	24.10	34.00	2.00	32.00	4364 9.032	M9 / M12	9.020	9046050090200
20.00	9.322	6.985	ANSI	0.367	0.275	24.10	34.00	2.00	32.00	4364 8.032	1/2-13 & 1/2-20	9.320	9046050093200
20.00	9.677	7.264	ANSI	0.381	0.286	24.10	34.00	2.00	33.00	4364 9.032	3/8-16 & 3/8-24	9.620	9046050096200
20.00	10.000	8.000	DIN	-	-	24.10	34.00	2.00	36.00	4364 10.032	M10	10.020	9046050100200
20.00	10.500	8.000	JIS	-	-	24.10	34.00	2.00	36.00	4364 10.032	M14	10.520	9046050105200
20.00	10.897	8.179	ANSI	0.4290	0.3220	24.10	34.00	2.00	35.00	4364 10.032	9/16-12 & 9/16-18	10.820	9046050108200
20.00	11.000	9.000	DIN	-	-	24.10	34.00	2.00	37.00	4364 11.032	M14	11.020	9046050110200
20.00	12.000	9.000	DIN	-	-	24.10	34.00	2.00	37.00	4364 11.032	M12 / M16	12.020	9046050120200
20.00	12.192	9.144	ANSI	0.480	0.36	24.10	34.00	2.00	36.00	4364 11.032	5/8-11 & 5/8-18	12.120	9046050121200
20.00	12.500	10.000	JIS	-	-	24.10	34.00	2.00	38.00	4364 11.032	M16	12.520	9046050125200
20.00	13.000	10.000	JIS	-	-	24.10	34.00	2.00	38.00	4364 11.032	M17	13.020	9046050130200
20.00	14.000	11.000	DIN / JIS	-	-	24.10	34.00	2.00	39.00	4364 11.032	M18	14.020	9046050140200
20.00	14.288	10.693	ANSI	0.5625	0.421	24.10	34.00	2.00	38.00	4364 11.032	1/4-18	14.220	9046050142200
20.00	14.986	10.719	ANSI	0.590	0.422	24.10	34.00	2.00	39.00	4364 11.032	3/4-10 & 3/4-16	14.920	9046050149200
20.00	15.000	12.000	JIS	-	-	24.10	34.00	2.00	40.00	4364 16.032	M20	15.020	9046050150200
20.00	16.000	12.000	DIN	-	-	24.10	34.00	2.00	41.00	4364 16.032	M20	16.020	9046050160200

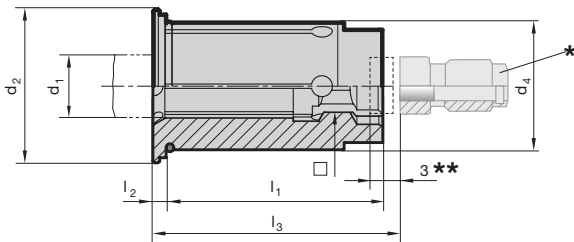
GUHROJET reduction sleeves for hydraulic synchro tapping chucks

Product information

- for clamping taps with square shank in GUHROSync synchro tapping chucks
- clamping-Ø for tool shank tolerance h6-h9
- positive drive of reduction sleeve in Guhrosync synchro chuck
- with coolant slots for peripheral cooling, therefore process and tool life improvement
- coiled swarf is consistently washed away
- position setting screw on tap shank
- length-setting screw allows 3 mm** readjustment

Scope of delivery

- order MQL setting screws
Guhring no. 4305 separately
- order setting screw
Guhring no. 4364 separately



GUHROJET

Guhring no.

4606

d ₄ mm	d ₁ mm	□ mm	Standard	d ₁ inch	□ inch	d ₂ mm	l ₁ mm	l ₂ mm	l ₃ mm	* for adjustment screw	for thread	Code no.	EDP
12.00	2.800	2.100	DIN	-	-	16.50	29.00	2.00	-	-	M2 / M4	2.812	9046060028120
12.00	3.500	2.700	DIN	-	-	16.50	29.00	2.00	-	-	M3 / M4.5 / M5	3.512	9046060035120
12.00	3.581	2.794	ANSI	0.1410	0.110	16.50	29.00	2.00	-	-	2-56 to 6-40	3.612	9046060036120
12.00	4.000	3.200	JIS	-	-	16.50	29.00	2.00	-	-	M3	4.012	9046060040120
12.00	4.268	3.327	ANSI	0.1680	0.131	16.50	29.00	2.00	-	-	8-32 & 8-36	4.312	9046060043120
12.00	4.500	3.400	DIN	-	-	16.50	29.00	2.00	-	-	M4 / M6	4.512	9046060045120
12.00	4.928	3.861	ANSI	0.194	0.152	16.50	29.00	2.00	-	-	10-24 & 10-32	4.912	9046060049120
12.00	5.000	4.000	JIS	-	-	16.50	29.00	2.00	-	-	M4	5.012	9046060050120
12.00	5.500	4.500	JIS	-	-	16.50	29.00	2.00	-	-	M5	5.512	9046060055120
12.00	5.588	4.191	ANSI	0.220	0.165	16.50	29.00	2.00	-	-	12-24 & 12-28	15.512	9046060155120
12.00	6.000	4.500	JIS	-	-	16.50	29.00	2.00	26.00	6.020	M6	16.012	9046060160120
12.00	6.000	4.900	DIN	-	-	16.50	29.00	2.00	26.00	6.020	M4.5/M5/M6/M8	6.012	9046060060120
12.00	6.200	5.000	JIS	-	-	16.50	29.00	2.00	26.00	6.020	M7 / M8	6.212	9046060062120
12.00	6.477	4.851	ANSI	0.255	0.191	16.50	29.00	2.00	26.00	6.020	1/4-20 & 1/4-28	6.412	9046060064120
12.00	7.000	5.500	DIN / JIS	-	-	16.50	29.00	2.00	26.00	7.020	M7 / M9 / M10	7.012	9046060070120
12.00	7.938	5.944	ANSI	0.3125	0.234	16.50	29.00	2.00	31.00	7.020	1/16-27	7.912	9046060079120
12.00	8.000	6.200	DIN	-	-	16.50	29.00	2.00	31.00	8.020	M8 / M11	8.012	9046060080120
12.00	8.000	6.500	JIS	-	-	16.50	29.00	2.00	31.00	8.020	M11	18.012	9046060180120
12.00	8.077	6.045	ANSI	0.318	0.238	16.50	29.00	2.00	31.00	7.020	5/16-18 & 5/16-24	28.012	9046060280120
12.00	8.204	6.147	ANSI	0.323	0.242	16.50	29.00	2.00	31.00	8.020	7/16-14 & 7/16-20	8.212	9046060082120
12.00	8.500	6.500	JIS	-	-	16.50	29.00	2.00	31.00	8.020	M12	8.512	9046060085120
12.00	9.000	7.000	DIN	-	-	16.50	29.00	2.00	32.00	9.020	M9 / M12	9.012	9046060090120
12.00	9.322	6.985	ANSI	0.367	0.275	16.50	29.00	2.00	32.00	9.020	1/2-13 & 1/2-20	9.312	9046060093120
12.00	9.677	7.264	ANSI	0.381	0.286	16.50	29.00	2.00	33.00	9.020	3/8-16 & 3/8-24	9.612	9046060096120
12.00	10.000	8.000	DIN	-	-	16.50	29.00	2.00	36.00	10.020	M10	10.012	9046060100120

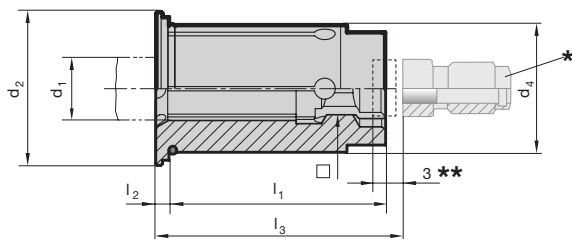
GUHROJET reduction sleeves for hydraulic synchro tapping chucks

Product information

- for clamping taps with square shank in GUHROSync synchro tapping chucks
- clamping-Ø for tool shank tolerance h6-h9
- positive drive of reduction sleeve in Guhrosync synchro chuck
- with coolant slots for peripheral cooling, therefore process and tool life improvement
- coiled swarf is consistently washed away
- position setting screw on tap shank
- length-setting screw allows 3 mm** readjustment

Scope of delivery

- order MQL setting screws
Guhring no. 4305 separately
- order setting screw
Guhring no. 4364 separately



GUHROJET

Guhring no.

4606

d ₄ mm	d ₁ mm	□ mm	Standard	d ₁ inch	□ inch	d ₂ mm	l ₁ mm	l ₂ mm	l ₃ mm	* for adjustment screw	for thread	Code no.	EDP
20.00	6.000	4.500	JIS	-	-	24.10	34.00	2.00	26.00	6.032	M6	26.020	9046060260200
20.00	6.000	4.900	DIN	-	-	24.10	34.00	2.00	26.00	6.032	M4.5/M5/M6/M8	6.020	9046060060200
20.00	6.200	5.000	JIS	-	-	24.10	34.00	2.00	26.00	6.032	M7 / M8	6.220	9046060062200
20.00	6.477	4.851	ANSI	0.255	0.191	24.10	34.00	2.00	26.00	6.032	1/4-20 & 1/4-28	6.420	9046060064200
20.00	7.000	5.500	DIN / JIS	-	-	24.10	34.00	2.00	26.00	7.032	M7 / M9 / M10	7.020	9046060070200
20.00	7.938	5.944	ANSI	0.3125	0.234	24.10	34.00	2.00	31.00	7.032	1/16-27	7.920	9046060079200
20.00	8.000	6.200	DIN	-	-	24.10	34.00	2.00	31.00	8.032	M8 / M11	8.020	9046060080200
20.00	8.000	6.500	JIS	-	-	24.10	34.00	2.00	31.00	8.032	M11	18.020	9046060180200
20.00	8.077	6.045	ANSI	0.318	0.238	24.10	34.00	2.00	31.00	8.032	5/16-18 & 5/16-24	28.020	9046060280200
20.00	8.204	6.147	ANSI	0.323	0.242	24.10	34.00	2.00	31.00	8.032	7/16-14 & 7/16-20	8.220	9046060082200
20.00	8.500	6.500	JIS	-	-	24.10	34.00	2.00	31.00	8.032	M12	8.520	9046060085200
20.00	9.000	7.000	DIN	-	-	24.10	34.00	2.00	32.00	9.032	M9 / M12	9.020	9046060090200
20.00	9.322	6.985	ANSI	0.367	0.275	24.10	34.00	2.00	32.00	9.032	1/2-13 & 1/2-20	9.320	9046060093200
20.00	9.677	7.264	ANSI	0.381	0.286	24.10	34.00	2.00	33.00	9.032	3/8-16 & 3/8-24	9.620	9046060096200
20.00	10.000	8.000	DIN	-	-	24.10	34.00	2.00	36.00	10.032	M10	10.020	9046060100200
20.00	10.500	8.000	JIS	-	-	24.10	34.00	2.00	36.00	10.032	M14	10.520	9046060105200
20.00	10.897	8.179	ANSI	0.4290	0.3220	24.10	34.00	2.00	35.00	10.032	9/16-12 & 9/16-18	10.820	9046060108200
20.00	11.000	9.000	DIN	-	-	24.10	34.00	2.00	37.00	11.032	M14	11.020	9046060110200
20.00	12.000	9.000	DIN	-	-	24.10	34.00	2.00	37.00	11.032	M12 / M16	12.020	9046060120200
20.00	12.192	9.144	ANSI	0.480	0.36	24.10	34.00	2.00	36.00	11.032	5/8-11 & 5/8-18	12.120	9046060121200
20.00	12.500	10.000	JIS	-	-	24.10	34.00	2.00	38.00	11.032	M16	12.520	9046060125200
20.00	13.000	10.000	JIS	-	-	24.10	34.00	2.00	38.00	11.032	M17	13.020	9046060130200
20.00	14.000	11.000	DIN / JIS	-	-	24.10	34.00	2.00	39.00	14.032	M18	14.020	9046060140200
20.00	14.288	10.693	ANSI	0.5625	0.421	24.10	34.00	2.00	38.00	11.032	1/4-18	14.220	9046060142200
20.00	14.986	10.719	ANSI	0.590	0.422	24.10	34.00	2.00	39.00	11.032	3/4-10 & 3/4-16	14.920	9046060149200
20.00	15.000	12.000	JIS	-	-	24.10	34.00	2.00	40.00	16.032	M20	15.020	9046060150200
20.00	16.000	12.000	DIN	-	-	24.10	34.00	2.00	41.00	16.032	M20	16.020	9046060160200

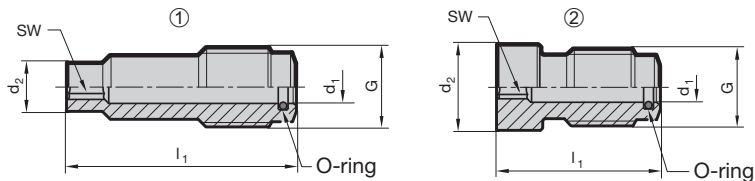
Setting screws for synchro tapping chucks with conventional internal cooling

Product information

- for GuhroSync synchro tapping chucks
Guhring no. 4601, 4576, 4577, 4525
- for conventional internal cooling
- for standard shank ends
- position setting screw on tap shank
- length-setting screw allows 3 mm readjustment

Scope of delivery

- with O-ring for secure seal



Guhring no.

4364

for nominal size	for tap shank-Ø x □	G	d ₁ mm	d ₂ mm	l ₁ mm	SW	O-ring	image	Code no.	EDP
ER20 / Hydro12	< Ø6	M8x1	3.6	3.3	28.0	2.0	3.5x1	1	5.020	9043640050200
ER20 / Hydro12	6x4.9	M8x1	3.6	4.8	26.0	2.5	3.5x1	1	6.020	9043640060200
ER20 / Hydro12	7x5.5	M8x1	3.6	5.4	25.8	2.5	3.5x1	1	7.020	9043640070200
ER20 / Hydro12	8x6.2	M8x1	3.6	6.1	20.9	2.5	3.5x1	1	8.020	9043640080200
ER20 / Hydro12	9x7	M8x1	3.6	6.9	20.3	2.5	3.5x1	1	9.020	9043640090200
ER20 / Hydro12	10x8	M8x1	3.6	7.8	15.8	2.5	3.5x1	2	10.020	9043640100200
ER20 / Hydro12	11x9	M8x1	3.6	8.8	14.8	2.5	3.5x1	2	11.020	9043640110200
ER32 / Hydro20	< Ø6	M10x1	4.1	3.3	33.0	2.0	4x1	1	5.032	9043640050320
ER32 / Hydro20	6x4.9	M10x1	4.1	4.8	34.0	3.0	4x1	1	6.032	9043640060320
ER32 / Hydro20	7x5.5	M10x1	4.1	5.4	33.8	3.0	4x1	1	7.032	9043640070320
ER32 / Hydro20	8x6.2	M10x1	4.1	6.1	28.8	3.0	4x1	1	8.032	9043640080320
ER32 / Hydro20	9x7	M10x1	4.1	6.9	28.3	3.0	4x1	1	9.032	9043640090320
ER32 / Hydro20	10x8	M10x1	4.1	7.8	23.8	3.0	4x1	1	10.032	9043640100320
ER32 / Hydro20	11x9 & 12x9	M10x1	4.1	8.8	22.9	3.0	4x1	1	11.032	9043640110320
ER32 / Hydro20	14x11	M10x1	4.1	10.8	20.7	3.0	4x1	2	14.032	9043640140320
ER32 / Hydro20	16x12	M10x1	4.1	11.8	19.7	3.0	4x1	2	16.032	9043640160320
ER32 / Hydro20	18x14.5 & 20x16	M10x1	4.1	14.3	18.0	3.0	4x1	2	18.032	9043640180320

GUHRING

MQL

BY GUHRING



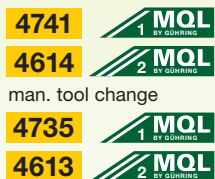
Guhring – Innovative machining

As one of the pioneers of MQL technology we have an extensive knowledge of minimal quantity lubrication.

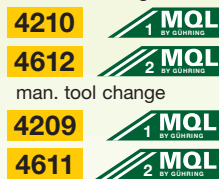
Higher cutting speeds and longer tool life are possible thanks to adapted cooling as well as highest surface qualities thanks to the pure lubricant. Workpieces and chips remain dry! Save the cost of de-greasing your workpieces as well as disposal of swarf and soluble oil.

Configuration of GUHROSynch tapping chucks for internal cooling with MQL

MQL shrink fit chucks
HSK-A
auto. tool change



MQL hydraulic tapping chucks
HSK-A
auto. tool change



4508
MQL coolant delivery set
for single channel
HSK-A



MQL HSK-A hydraulic
synchro tapping chucks for
single channel
auto. tool change



4511
MQL coolant delivery set
for 2 channel systems
HSK-A



MQL HSK-A hydraulic
synchro tapping chucks for
2 channel systems
auto. tool change



4513
MQL coolant delivery set
HSK-A (filler)



MQL HSK-A hydraulic
synchro tapping chucks
man. tool change



4524
MQL hydraulic synchro tapping chuck with internal coolant
cylindrical shank Ø20.0 mm



4305
MQL setting screws with internal cone
for MQL synchro tapping chucks



4605
Reduction sleeves, sealed



4606
GUHROJET reduction sleeves



Threading tool with MQL shank:
shank diameter x square



Synchro tapping chucks **GUHRING** 21

23

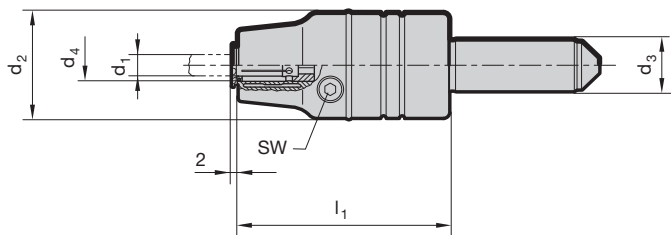
MQL hydraulic synchro tapping chucks with internal cooling

Product information

- for MQL single and double channel systems
- MQL coolant pressure up to max. 16 bar
- compensates synchronization errors
- guarantees high thread quality and optimal tool life
- minimal length compensation in tension and compression direction balances very small pitch differences between synchro spindle and tap
- reduces an increase in axial forces during the cutting cycle to a minimum
- convenient hydraulic clamping using reduction sleeves with active drive
- length-setting screw allows 3 mm readjustment
- holder shank to DIN 1835-A or holding in precision chucks (hydraulic, shrink fit or power clamping chucks)
- Guhring MQL identifiable by green colored polymer ring

Scope of delivery

- incl. hexagon clamping key
Guhring no. 4912
- incl. adjustment key for
MQL adjustment screws
- order MQL adjustment screw
Guhring no. 4305 separately
- order reduction sleeves
Guhring no. 4605 or 4606 separately



1 MQL
BY GÜHRING



GÜHROSync

Guhring no.

4524

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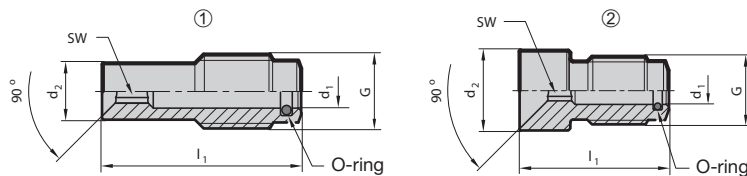
MQL setting screws with internal cone for MQL synchro tapping chucks.

Product information

- MQL setting screws with internal cone
- for MQL single and double channel systems
- for MQL taps with external cone
- for MQL synchro tapping chucks
Guhring no. 4602, 4603 and 4604
- position setting screw on tap shank
- length-setting screw allows 3 mm readjustment

Scope of delivery

- with O-ring for secure seal



Guhring no.

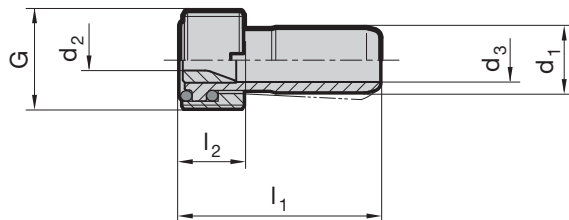
4305

for nom. size	for tap shank-Ø x □	G	d ₁ mm	d ₂ mm	l ₁ mm	SW	O-ring	image	Code no.	EDP
ER20 / Hydro12	6x4.9	M8x1	3.6	4.8	26.5	2.5	3.5x1	1	6.020	9043050060200
ER20 / Hydro12	7x5.5	M8x1	3.6	5.4	26.5	2.5	3.5x1	1	7.020	9043050070200
ER20 / Hydro12	8x6.2	M8x1	3.6	6.1	21.5	2.5	3.5x1	1	8.020	9043050080200
ER20 / Hydro12	9x7	M8x1	3.6	6.9	21.0	2.5	3.5x1	1	9.020	9043050090200
ER20 / Hydro12	10x8	M8x1	3.6	7.8	17.0	2.5	3.5x1	2	10.020	9043050100200
ER20 / Hydro12	11x9	M8x1	3.6	8.8	16.0	2.5	3.5x1	2	11.020	9043050110200
ER32 / Hydro20	6x4.9	M10x1	4.1	4.8	34.5	3.0	4x1	1	6.032	9043050060320
ER32 / Hydro20	7x5.5	M10x1	4.1	5.4	34.5	3.0	4x1	1	7.032	9043050070320
ER32 / Hydro20	8x6.2	M10x1	4.1	6.1	29.5	3.0	4x1	1	8.032	9043050080320
ER32 / Hydro20	9x7	M10x1	4.1	6.9	29.0	3.0	4x1	1	9.032	9043050090320
ER32 / Hydro20	10x8	M10x1	4.1	7.8	25.0	3.0	4x1	1	10.032	9043050100320
ER32 / Hydro20	11x9 & 12x9	M10x1	4.1	8.8	24.0	3.0	4x1	1	11.032	9043050110320
ER32 / Hydro20	14x11	M10x1	4.1	10.8	22.5	3.0	4x1	2	14.032	9043050140320
ER32 / Hydro20	16x12	M10x1	4.1	11.8	22.0	3.0	4x1	2	16.032	9043050160320
ER32 / Hydro20	18x14.5 & 20x16	M10x1	4.1	14.3	20.5	3.0	4x1	2	18.032	9043050180320

MQL coolant delivery set for single channel HSK-A

Product information

- to MQL standard
- version sim. to DIN 69895
- for MQL 1-channel systems
- for tool holders with automatic tool clamping
- dimensions d_2 and l_1 based on installed condition



Guhring no.

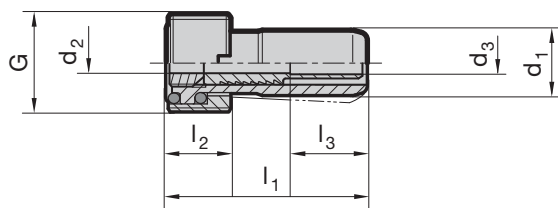
4508

for HSK-A	d_1 mm	d_2 mm	d_3 mm	l_1 mm	l_2 mm	G	Code no.	EDP
32	6.00	3.00	4.00	26.00	5.50	M10x1	10.032	9045080100320
40	8.00	3.80	5.40	29.50	7.50	M12x1	12.040	9045080120400
50	10.00	3.80	6.40	33.00	9.50	M16x1	16.050	9045080160500
63	12.00	3.80	8.00	36.50	11.50	M18x1	18.063	9045080180630
80	14.00	3.80	10.00	40.00	13.50	M20x1.5	20.080	9045080200800
100	16.00	3.80	12.00	44.00	15.50	M24x1.5	24.100	9045080241000

MQL coolant delivery set for 2 channel systems HSK-A

Product information

- to MQL standard
- version sim. to DIN 69895
- for MQL 2-channel systems
- for tool holders with automatic tool clamping
- "Crashsafe" version similar to DIN 69090-2 neck design
- dimensions d_2 and l_1 based on installed condition



Guhring no.

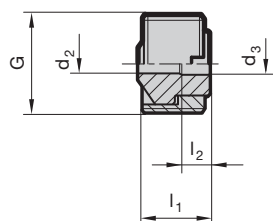
4511

for HSK-A	d_1 mm	d_2 mm	d_3 mm	l_1 mm	l_2 mm	l_3 mm	G	Code no.	EDP
32	6.00	3.00	4.00	26.00	5.50	-	M10x1	10.032	9045110100320
40	8.00	3.80	5.40	29.50	7.50	-	M12x1	12.040	9045110120400
50	10.00	3.60	4.00	33.00	9.50	21.00	M16x1	16.050	9045110160500
63	12.00	3.60	4.00	36.50	11.50	13.80	M18x1	18.063	9045110180630
80	14.00	3.60	4.00	40.00	13.50	14.00	M20x1.5	20.080	9045110200800
100	16.00	3.60	4.00	44.00	15.50	14.00	M24x1.5	24.100	9045110241000

ML coolant delivery set HSK-A (filler)

Product information

- to MQL standard
- for internal cooling MQL 1 and 2 channel systems
- for tool holders with manual tool clamping
- optimally sealed for MQL clamping set
- dimensions d_2 and l_1 based on installed condition



Guhring no.

4513

[illegible]

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The Tool Company

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Shipping Address

1445 Commerce Avenue

Brookfield, WI 53045

Tel (262) 784-6730 (800) 776-6170

Fax (262) 784-9096

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15581 Computer Ln.

Huntington Beach, CA 92649

Reconditioning Facility

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29550 W.K. Smith Rd. Suite B

New Hudson, MI 48165

Guhring Corporation

20 Steckle Place, Unit #14

Kitchener, ON N2E 2C3

Tel (519) 748-9664 (800) 463-5555

Fax (519) 748-2954