

GUHRING

THE BEST OF BOTH SYSTEMS

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



NOW ALSO AVAILABLE WITH ISO TAPER, MAS/BT AND STRAIGHT SHANK



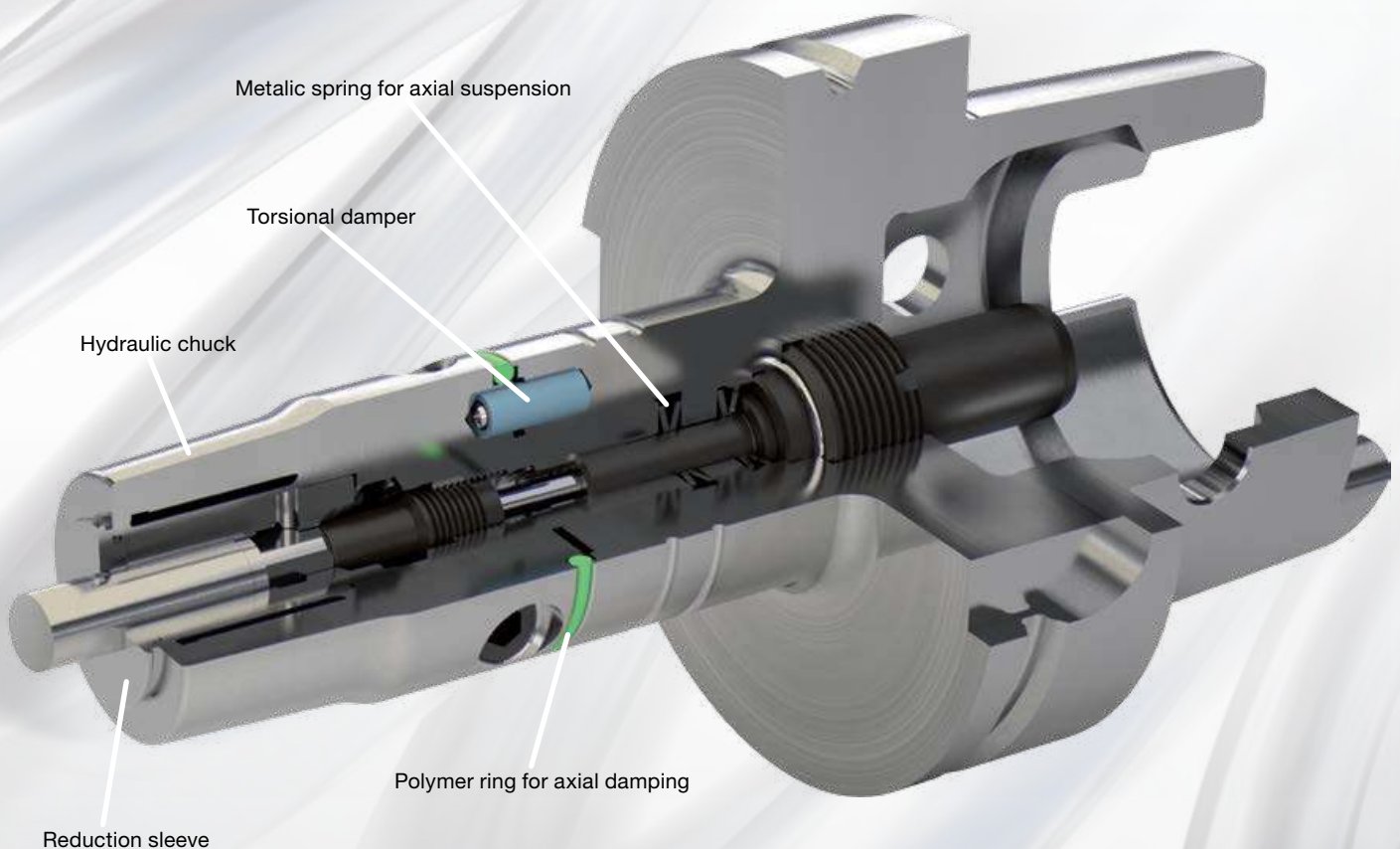
GUHROSyc

Synchro tapping chucks

GUHRING - YOUR WORLD-WIDE PARTNER

GUHROSYNC

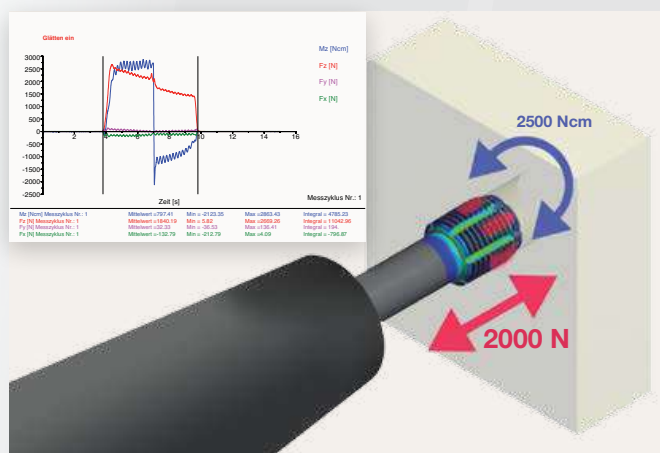
THE EASY WAY
TO THE PERFECT THREAD



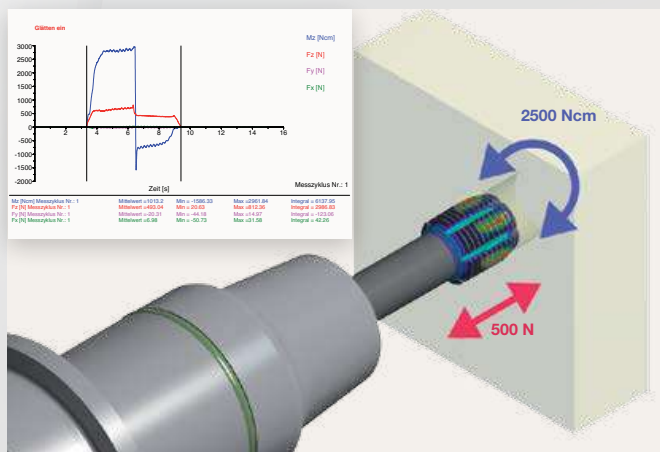
Intelligent design:

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

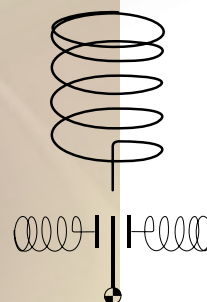


GUHROSyc

➔ **IMPROVED
TOOL LIFE**

➔ **IMPROVED THREAD
QUALITY**

➔ **GREATER PROCESS
RELIABILITY**



GUHRING

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



*REDUCTION OF AXIAL
AND RADIAL FORCES*



*COMPENSATES
SYNCHRONISATION 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*



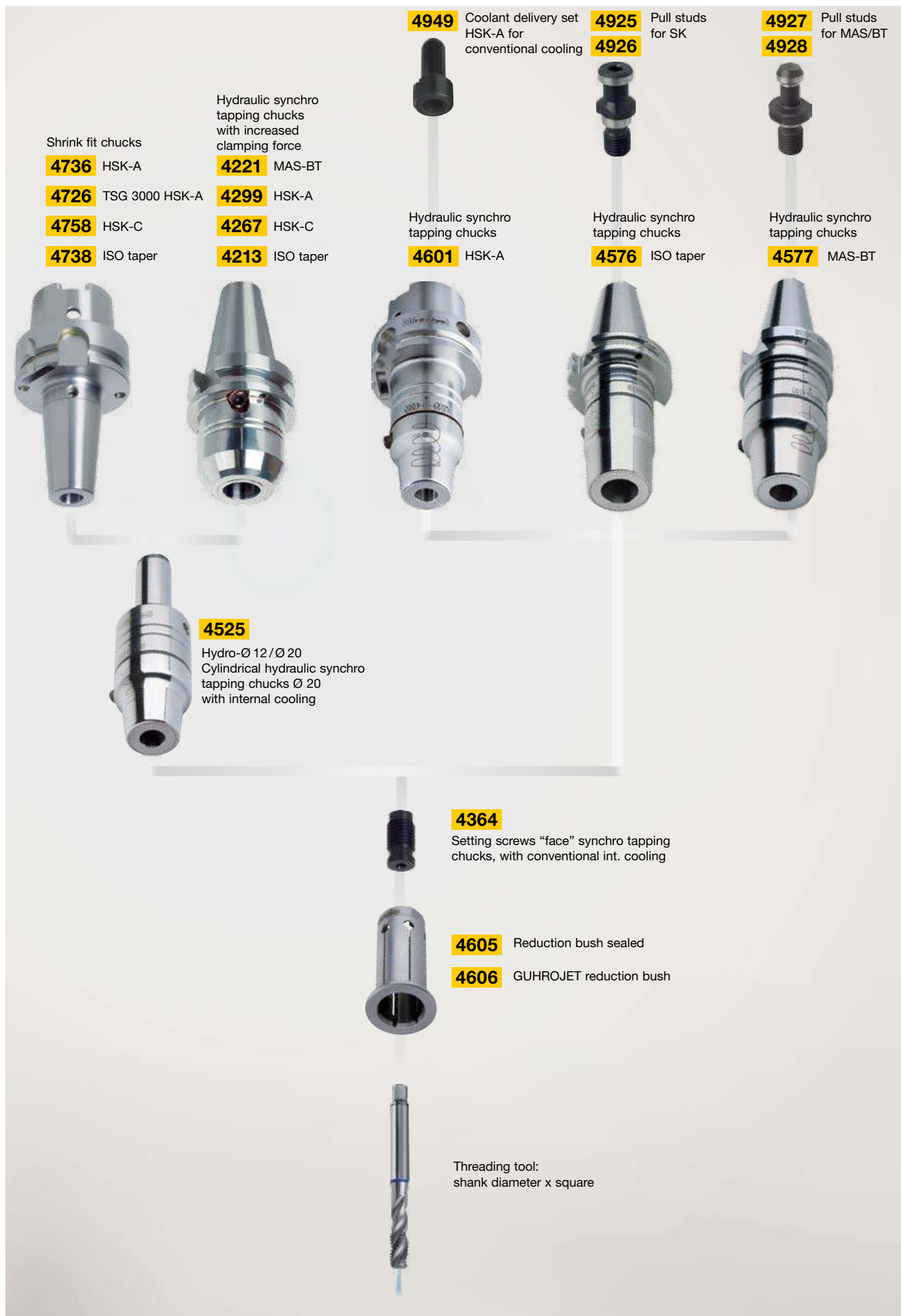
*GREATER PROCESS
RELIABILITY*

GUHROSync synchro tapping chucks for internal cooling

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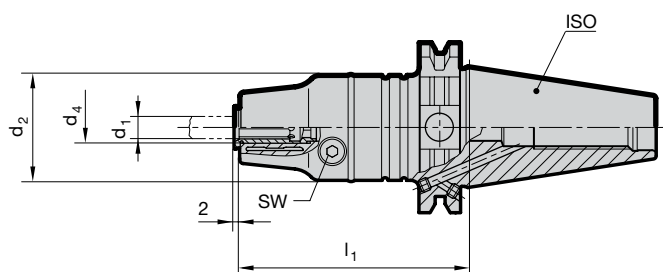


Product information

- SK30 to DIN 69871 form AD without coolant supply over collar
- SK40 to DIN 69871 form AD/B
- form B supplied with threaded pins in bores
- compensates synchronisation 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 bushes with active drive
- length-setting screw allows 3 mm readjustment
- suitable for internal cooling identifiable by black coloured ring
- 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 "face"
Guhring no. 4364 separately
- order reduction bushes
Guhring no. 4605 or 4606 separately
- order pull studs, Guhring no. 4925 or
4926 separately

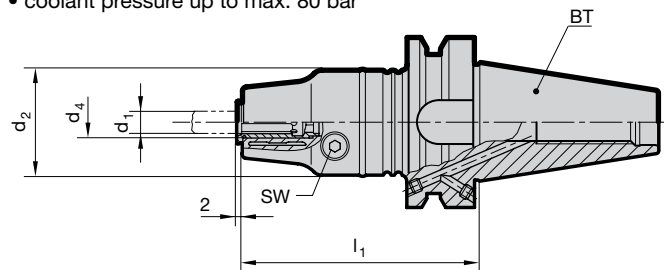


GÜHROSync

[illegible]

Product information

- MAS/BT30 to JIS B 6339-2 form JD without coolant supply over collar
- MAS/BT40 to JIS B 6339-2 form JD/JF (form AD/B)
- form B supplied with threaded pins in bores
- compensates synchronisation 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 bushes with active drive
- length-setting screw allows 3 mm readjustment
- suitable for internal cooling identifiable by black coloured ring
- 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 "face"
Guhring no. 4364 separately
- order reduction bushes
Guhring no. 4605 or 4606 separately
- order pull studs, Guhring no. 4927 or 4928 separately



GÜHROSync

Guhring no. 4577

Discount group 114

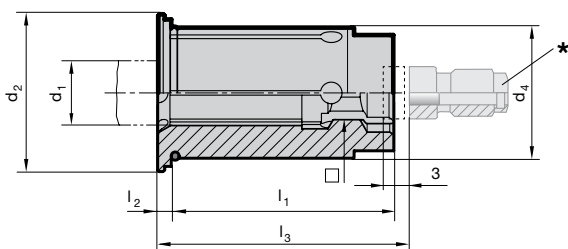
BT	d ₄ mm	for shank Ø d ₁	for thread	d ₂ mm	l ₁ mm	tension/ compr. ± mm	SW	kg	Code no.	Availability
30	12.00	2.8-10	M3-M12	40	81	0.3	4	0.8	12,030	●
30	20.00	6-16	M8-M20	40	95	0.3	5	0.9	20,030	●
40	12.00	2.8-10	M3-M12	40	85	0.3	4	1.3	12,040	●
40	20.00	6-16	M8-M20	40	99	0.3	5	1.4	20,040	●

Product information

- for clamping taps with square shank in GUHROSynch synchro tapping chucks
- clamping-Ø for tool shank tolerance h6-h9
- face side closed, therefore coolant leak-proof for threading tools with IC
- positive drive
- position setting screw on tap shank
- length-setting screw allows 3 mm readjustment

Scope of delivery

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

Guhring no. **4605**Discount group **114**

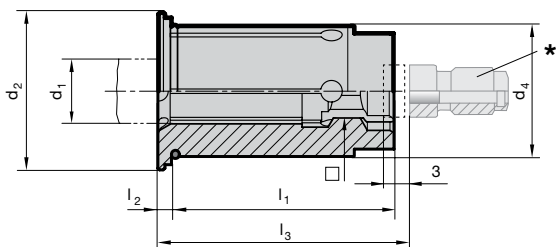
d4 mm	d1 mm	□ mm	Standard	d1 inch	□ inch	d2 mm	l1 mm	l2 mm	l3 mm	* for adjustment screw	for thread	Code no.	Availability
12.00	2.800	2.100	DIN	-	-	16.50	29.00	2.00	-	-	M2 / M4	2,812	●
12.00	3.500	2.700	DIN	-	-	16.50	29.00	2.00	-	-	M3 / M4.5 / M5	3,512	●
12.00	4.000	3.200	JIS	-	-	16.50	29.00	2.00	-	-	M3	4,012	●
12.00	4.500	3.400	DIN	-	-	16.50	29.00	2.00	26.00	4364 5.020	M4 / M6	4,512	●
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	●
12.00	5.000	4.000	JIS	-	-	16.50	29.00	2.00	26.00	4364 5.020	M4	5,012	●
12.00	5.500	4.500	JIS	-	-	16.50	29.00	2.00	26.00	4364 5.020	M5	5,512	●
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	●
12.00	6.000	4.500	JIS	-	-	16.50	29.00	2.00	26.00	4364 5.020	M6	16,012	●
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	●
12.00	6.200	5.000	JIS	-	-	16.50	29.00	2.00	26.00	4364 6.020	M7 / M8	6,212	●
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	●
12.00	7.000	5.500	DIN / JIS	-	-	16.50	29.00	2.00	26.00	4364 7.020	M7 / M9 / M10	7,012	●
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	●
12.00	8.000	6.200	DIN	-	-	16.50	29.00	2.00	31.00	4364 8.020	M8 / M11	8,012	●
12.00	8.000	6.500	JIS	-	-	16.50	29.00	2.00	31.00	4364 8.020	M11	18,012	●
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	●
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	●
12.00	8.500	6.500	JIS	-	-	16.50	29.00	2.00	31.00	4364 8.020	M12	8,512	●
12.00	9.000	7.000	DIN	-	-	16.50	29.00	2.00	32.00	4364 9.020	M9 / M12	9,012	●
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	●
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	●
12.00	10.000	8.000	DIN	-	-	16.50	29.00	2.00	36.00	4364 10.020	M10	10,012	●

Product information

- for clamping taps with square shank in GUHROSynch synchro tapping chucks
- clamping-Ø for tool shank tolerance h6-h9
- face side closed, therefore coolant leak-proof for threading tools with IC
- positive drive
- position setting screw on tap shank
- length-setting screw allows 3 mm readjustment

Scope of delivery

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



Guhring no.	4605
Discount group	114

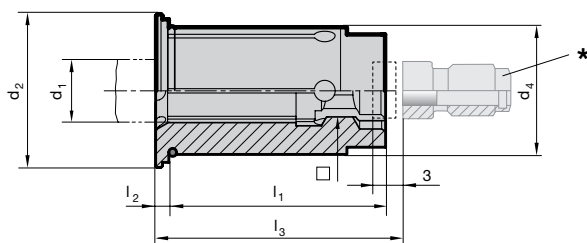
d4 mm	d1 mm	□ mm	Standard	d1 inch	□ inch	d2 mm	l1 mm	l2 mm	l3 mm	* for adjustment screw	for thread	Code no.	Availability
20.00	6.000	4.500	JIS	-	-	24.10	34.00	2.00	26.00	4364 6.032	M6	26,020	●
20.00	6.000	4.900	DIN	-	-	24.10	34.00	2.00	26.00	4364 6.032	M4.5/M5/M6/M8	6,020	●
20.00	6.200	5.000	JIS	-	-	24.10	34.00	2.00	26.00	4364 6.032	M7 / M8	6,220	●
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	●
20.00	7.000	5.500	DIN / JIS	-	-	24.10	34.00	2.00	26.00	4364 7.032	M7 / M9 / M10	7,020	●
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	●
20.00	8.000	6.200	DIN	-	-	24.10	34.00	2.00	31.00	4364 8.032	M8 / M11	8,020	●
20.00	8.000	6.500	JIS	-	-	24.10	34.00	2.00	31.00	4364 8.032	M11	18,020	●
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	●
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	●
20.00	8.500	6.500	JIS	-	-	24.10	34.00	2.00	31.00	4364 8.032	M12	8,520	●
20.00	9.000	7.000	DIN	-	-	24.10	34.00	2.00	32.00	4364 9.032	M9 / M12	9,020	●
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	●
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	●
20.00	10.000	8.000	DIN	-	-	24.10	34.00	2.00	36.00	4364 10.032	M10	10,020	●
20.00	10.500	8.000	JIS	-	-	24.10	34.00	2.00	36.00	4364 10.032	M14	10,520	●
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	●
20.00	11.000	9.000	DIN	-	-	24.10	34.00	2.00	37.00	4364 11.032	M14	11,020	●
20.00	12.000	9.000	DIN	-	-	24.10	34.00	2.00	37.00	4364 11.032	M12 / M16	12,020	●
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	●
20.00	12.500	10.000	JIS	-	-	24.10	34.00	2.00	38.00	4364 11.032	M16	12,520	●
20.00	13.000	10.000	JIS	-	-	24.10	34.00	2.00	38.00	4364 11.032	M17	13,020	●
20.00	14.000	11.000	DIN / JIS	-	-	24.10	34.00	2.00	39.00	4364 11.032	M18	14,020	●
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	●
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	●
20.00	15.000	12.000	JIS	-	-	24.10	34.00	2.00	40.00	4364 16.032	M20	15,020	●
20.00	16.000	12.000	DIN	-	-	24.10	34.00	2.00	41.00	4364 16.032	M20	16,020	●

Product information

- for clamping taps with square shank in GUHROSynchro tapping chucks
- clamping-Ø for tool shank tolerance h6-h9
- positive drive of reduction bush in Guhrosynchro 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 "face"
Guhring no. 4364 separately



GUHROJET

Guhring no. **4606**

Discount group **114**

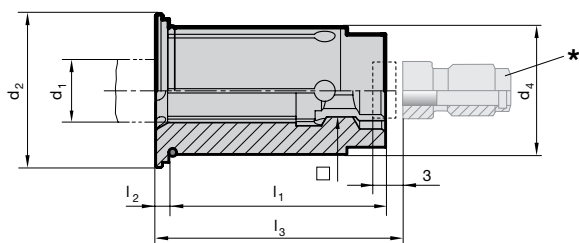
d ₄ mm	d ₁ mm	□ mm	Standard	d ₁ inch	□ inch	d ₂ mm	l ₁ mm	l ₂ mm	l ₃ mm	* for adjustment screw	for thread	Code no.	Availability
12.00	2.800	2.100	DIN	-	-	16.50	29.00	2.00	-	-	M2 / M4	2.812	●
12.00	3.500	2.700	DIN	-	-	16.50	29.00	2.00	-	-	M3 / M4.5 / M5	3.512	●
12.00	4.000	3.200	JIS	-	-	16.50	29.00	2.00	-	-	M3	4.012	●
12.00	4.500	3.400	DIN	-	-	16.50	29.00	2.00	-	-	M4 / M6	4.512	●
12.00	4.928	3.861	ANSI	0.194	0.152	16.50	29.00	2.00	-	-	10-24 & 10-32	4.912	●
12.00	5.000	4.000	JIS	-	-	16.50	29.00	2.00	-	-	M4	5.012	●
12.00	5.500	4.500	JIS	-	-	16.50	29.00	2.00	-	-	M5	5.512	●
12.00	5.588	4.191	ANSI	0.220	0.165	16.50	29.00	2.00	-	-	12-24 & 12-28	15.512	●
12.00	6.000	4.500	JIS	-	-	16.50	29.00	2.00	26.00	6.020	M6	16.012	●
12.00	6.000	4.900	DIN	-	-	16.50	29.00	2.00	26.00	6.020	M4.5/M5/M6/M8	6.012	●
12.00	6.200	5.000	JIS	-	-	16.50	29.00	2.00	26.00	6.020	M7 / M8	6.212	●
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	●
12.00	7.000	5.500	DIN / JIS	-	-	16.50	29.00	2.00	26.00	7.020	M7 / M9 / M10	7.012	●
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	●
12.00	8.000	6.200	DIN	-	-	16.50	29.00	2.00	31.00	8.020	M8 / M11	8.012	●
12.00	8.000	6.500	JIS	-	-	16.50	29.00	2.00	31.00	8.020	M11	18.012	●
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	●
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	●
12.00	8.500	6.500	JIS	-	-	16.50	29.00	2.00	31.00	8.020	M12	8.512	●
12.00	9.000	7.000	DIN	-	-	16.50	29.00	2.00	32.00	9.020	M9 / M12	9.012	●
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	●
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	●
12.00	10.000	8.000	DIN	-	-	16.50	29.00	2.00	36.00	10.020	M10	10.012	●

Product information

- for clamping taps with square shank in GUHROSynch synchro tapping chucks
- clamping-Ø for tool shank tolerance h6-h9
- positive drive of reduction bush in Guhrosynch 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 "face"
Guhring no. 4364 separately

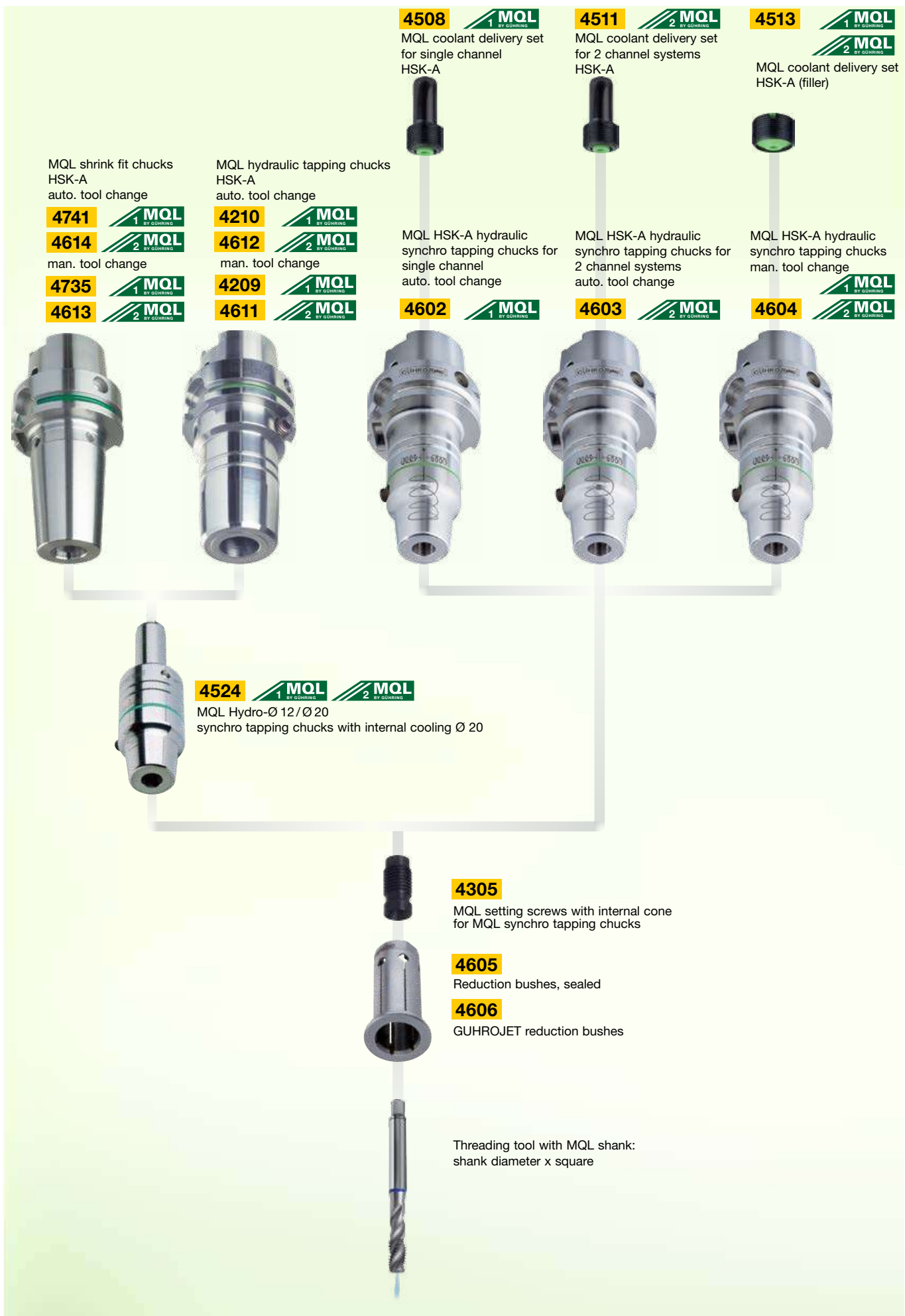


GUHROJET

Guhring no. **4606**

Discount group **114**

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.	Availability
20.00	6.000	4.500	JIS	-	-	24.10	34.00	2.00	26.00	6.032	M6	26,020	●
20.00	6.000	4.900	DIN	-	-	24.10	34.00	2.00	26.00	6.032	M4.5/M5/M6/M8	6,020	●
20.00	6.200	5.000	JIS	-	-	24.10	34.00	2.00	26.00	6.032	M7 / M8	6,220	●
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	●
20.00	7.000	5.500	DIN / JIS	-	-	24.10	34.00	2.00	26.00	7.032	M7 / M9 / M10	7,020	●
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	●
20.00	8.000	6.200	DIN	-	-	24.10	34.00	2.00	31.00	8.032	M8 / M11	8,020	●
20.00	8.000	6.500	JIS	-	-	24.10	34.00	2.00	31.00	8.032	M11	18,020	●
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	●
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	●
20.00	8.500	6.500	JIS	-	-	24.10	34.00	2.00	31.00	8.032	M12	8,520	●
20.00	9.000	7.000	DIN	-	-	24.10	34.00	2.00	32.00	9.032	M9 / M12	9,020	●
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	●
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	●
20.00	10.000	8.000	DIN	-	-	24.10	34.00	2.00	36.00	10.032	M10	10,020	●
20.00	10.500	8.000	JIS	-	-	24.10	34.00	2.00	36.00	10.032	M14	10,520	●
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	●
20.00	11.000	9.000	DIN	-	-	24.10	34.00	2.00	37.00	11.032	M14	11,020	●
20.00	12.000	9.000	DIN	-	-	24.10	34.00	2.00	37.00	11.032	M12 / M16	12,020	●
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	●
20.00	12.500	10.000	JIS	-	-	24.10	34.00	2.00	38.00	11.032	M16	12,520	●
20.00	13.000	10.000	JIS	-	-	24.10	34.00	2.00	38.00	11.032	M17	13,020	●
20.00	14.000	11.000	DIN / JIS	-	-	24.10	34.00	2.00	39.00	14.032	M18	14,020	●
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	●
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	●
20.00	15.000	12.000	JIS	-	-	24.10	34.00	2.00	40.00	16.032	M20	15,020	●
20.00	16.000	12.000	DIN	-	-	24.10	34.00	2.00	41.00	16.032	M20	16,020	●

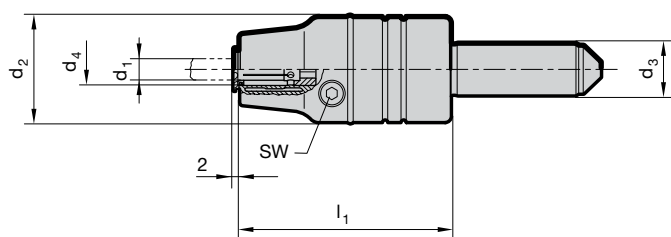


Product information

- for MQL single and double channel systems
- MQL coolant pressure up to max. 16 bar
- compensates synchronisation 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 bushes 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 coloured 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 bushes
Guhring no. 4605 or 4606 separately



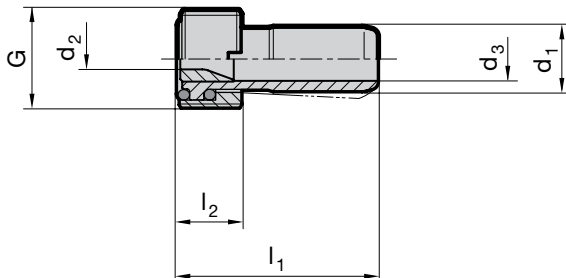
Guhring no.	4524
Discount group	114

[illegible]

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

Discount group

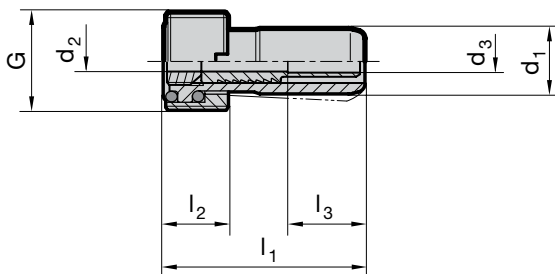
114

for HSK-A	d_1 mm	d_2 mm	d_3 mm	l_1 mm	l_2 mm	G	Code no.	Availability
32	6.00	3.00	4.00	26.00	5.50	M10x1	10,032	●
40	8.00	3.80	5.40	29.50	7.50	M12x1	12,040	●
50	10.00	3.80	6.40	33.00	9.50	M16x1	16,050	●
63	12.00	3.80	8.00	36.50	11.50	M18x1	18,063	●
80	14.00	3.80	10.00	40.00	13.50	M20x1.5	20,080	●
100	16.00	3.80	12.00	44.00	15.50	M24x1.5	24,100	●

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.

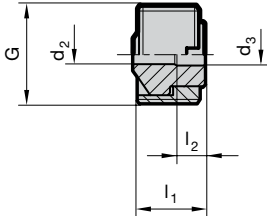
4511

Discount group

114

for HSK-A	d_1 mm	d_2 mm	d_3 mm	l_1 mm	l_2 mm	l_3 mm	G	Code no.	Availability
32	6.00	3.00	4.00	26.00	5.50	-	M10x1	10,032	●
40	8.00	3.80	5.40	29.50	7.50	-	M12x1	12,040	●
50	10.00	3.60	4.00	33.00	9.50	21.00	M16x1	16,050	●
63	12.00	3.60	4.00	36.50	11.50	13.80	M18x1	18,063	●
80	14.00	3.60	4.00	40.00	13.50	14.00	M20x1.5	20,080	●
100	16.00	3.60	4.00	44.00	15.50	14.00	M24x1.5	24,100	●

- 



Guhring no.	4513
Discount group	114

Synchro tapping chucks **GUHRING** 23

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