



**GÜHRING**

**XF無屑擠牙絲攻  
鋼材專用**

多角型牙鋒數增加  
壽命提升

***Fluteless taps XF***

High-performance tool  
for forming steel materials



# Fluteless taps XF

## HSS-E-PM XF系列 無屑擠牙絲攻 6HX 公差

Fluteless taps with coolant ducts for ISO metric threads

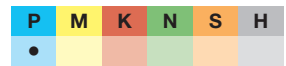
Article no. **8325**



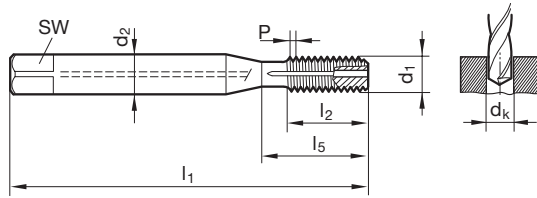
cutting data see page 6



with internal cooling  $\geq$  M5 • maximum performance • optimised polygon shape • for steel materials  
M5以上中心出水



P類鋼材專用



Standard ~DIN 371/~DIN 376  
Article no. **8325**

d1	P mm	d2 mm	SW mm	dk mm	l1 mm	l2 mm	l5 mm		Order no.	價格
M3	0.500	3.50	2.70	2.80	56.00	6.00	18.00	~DIN 371	8325 3.000	2,400
M4	0.700	4.50	3.40	3.70	63.00	7.50	21.00	~DIN 371	8325 4.000	2,500
M5	0.800	6.00	4.90	4.65	70.00	8.50	25.00	~DIN 371	8325 5.000	3,100
M6	1.000	6.00	4.90	5.55	80.00	11.00	30.00	~DIN 371	8325 6.000	3,400
M8	1.250	8.00	6.20	7.40	90.00	14.00	35.00	~DIN 371	8325 8.000	3,900
M10	1.500	10.00	8.00	9.30	100.00	16.00	39.00	~DIN 371	8325 10.000	5,100
M12	1.750	9.00	7.00	11.20	110.00	18.50	49.00	~DIN 376	8325 12.000	5,900
M14	2.000	11.00	9.00	13.10	110.00	20.00	53.00	~DIN 376	8325 14.000	10,500
M16	2.000	12.00	9.00	15.10	110.00	20.00	54.00	~DIN 376	8325 16.000	11,100
M20	2.500	16.00	12.00	18.90	140.00	25.00	62.00	~DIN 376	8325 20.000	14,000
M24	3.000	18.00	14.50	22.70	160.00	30.00	73.00	~DIN 376	8325 24.000	15,500

## HSS-E-PM XF系列 無屑擠牙絲攻 6HX 公差 中心出水型 盲孔用

Fluteless taps with coolant ducts for ISO metric threads

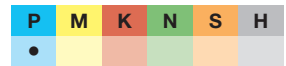
Article no. **8327**



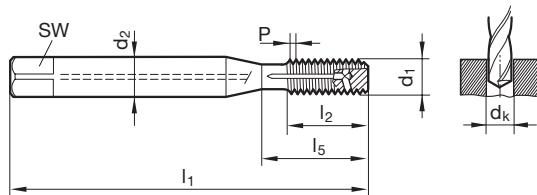
cutting data see page 6



maximum performance • optimised polygon shape • for steel materials



P類鋼材專用



Standard ~DIN 371/~DIN 376  
Article no. **8327**

d1	P mm	d2 mm	SW mm	dk mm	l1 mm	l2 mm	l5 mm		Order no.	價格
M5	0.800	6.00	4.90	4.65	70.00	8.50	25.00	~DIN 371	8327 5.000	3,300
M6	1.000	6.00	4.90	5.55	80.00	11.00	30.00	~DIN 371	8327 6.000	3,700
M8	1.250	8.00	6.20	7.40	90.00	14.00	35.00	~DIN 371	8327 8.000	4,200
M10	1.500	10.00	8.00	9.30	100.00	16.00	39.00	~DIN 371	8327 10.000	5,500
M12	1.750	9.00	7.00	11.20	110.00	18.50	49.00	~DIN 376	8327 12.000	6,300
M14	2.000	11.00	9.00	13.10	110.00	20.00	53.00	~DIN 376	8327 14.000	11,300
M16	2.000	12.00	9.00	15.10	110.00	20.00	54.00	~DIN 376	8327 16.000	12,000
M20	2.500	16.00	12.00	18.90	140.00	25.00	62.00	~DIN 376	8327 20.000	15,100
M24	3.000	18.00	14.50	22.70	160.00	30.00	73.00	~DIN 376	8327 24.000	16,800



HSS-E-PM XF系列 無屑擠牙絲攻 6HX 公差 公制細牙

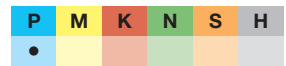
Fluteless taps with coolant ducts for ISO metric fine threads

Article no. 8326

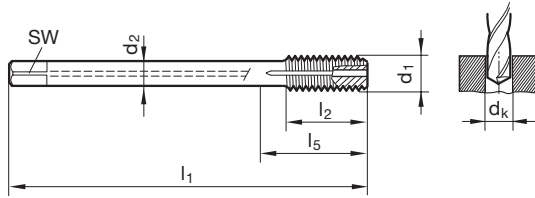


maximum performance • optimised polygon shape • for steel materials

cutting data see page 6



P類鋼材專用

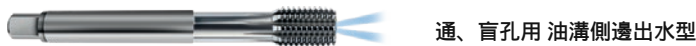


								Standard	~DIN 374	
								Article no.	8326	
d1	P	d2	SW	dk	l1	l2	l5	Order no.	價格	
M8 x 1	1.000	6.00	4.90	7.55	90.00	11.00	35.00	8326 8.005	5,700	
M10 x 1	1.000	7.00	5.50	9.55	90.00	11.00	35.00	8326 10.005	6,000	
M12 x 1,25	1.250	9.00	7.00	11.40	100.00	15.00	40.00	8326 12.006	6,700	
M12 x 1,5	1.500	9.00	7.00	11.30	100.00	15.00	40.00	8326 12.007	6,700	
M14 x 1,25	1.250	11.00	9.00	13.40	100.00	15.00	40.00	8326 14.006	9,300	
M14 x 1,5	1.500	11.00	9.00	13.30	100.00	15.00	40.00	8326 14.007	9,300	
M16 x 1,5	1.500	12.00	9.00	15.30	100.00	15.00	44.00	8326 16.007	12,100	
M20 x 1,5	1.500	16.00	12.00	19.30	125.00	16.00	44.00	8326 20.007	15,000	
M22 x 1,5	1.500	18.00	14.50	21.30	125.00	16.00	44.00	8326 22.007	19,000	
M24 x 1,5	1.500	18.00	14.50	23.30	140.00	16.00	48.00	8326 24.007	21,100	

HSS-E-PM XF系列 無屑擠牙絲攻 6HX 公差 公制細牙

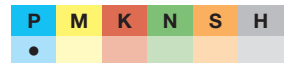
Fluteless taps with coolant ducts for ISO metric fine threads

Article no. 8328

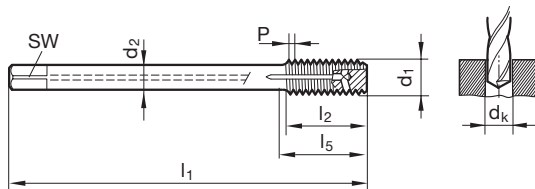


maximum performance • optimised polygon shape • for steel materials

cutting data see page 6



P類鋼材專用



								Standard	~DIN 374	
								Article no.	8328	
d1	P	d2	SW	dk	l1	l2	l5	Order no.	價格	
M8 x 1	1.000	6.00	4.90	7.55	90.00	11.00	35.00	8328 8.005	6,100	
M10 x 1	1.000	7.00	5.50	9.55	90.00	11.00	35.00	8328 10.005	6,400	
M12 x 1,25	1.250	9.00	7.00	11.40	100.00	15.00	40.00	8328 12.006	7,200	
M12 x 1,5	1.500	9.00	7.00	11.30	100.00	15.00	40.00	8328 12.007	7,200	
M14 x 1,25	1.250	11.00	9.00	13.40	100.00	15.00	40.00	8328 14.006	10,100	
M14 x 1,5	1.500	11.00	9.00	13.30	100.00	15.00	40.00	8328 14.007	10,100	
M16 x 1,5	1.500	12.00	9.00	15.30	100.00	15.00	44.00	8328 16.007	13,100	
M20 x 1,5	1.500	16.00	12.00	19.30	125.00	16.00	44.00	8328 20.007	16,200	
M22 x 1,5	1.500	18.00	14.50	21.30	125.00	16.00	44.00	8328 22.007	20,500	
M24 x 1,5	1.500	18.00	14.50	23.30	140.00	16.00	48.00	8328 24.007	22,800	



## Fluteless taps XF, ISO P M/MF



Machining group	HSS-E-PM
	<b>P</b>
	$v_c$ (m/min)
<b>P1.1.1</b> Unalloyed steel, annealed, 0.15 % C, Rm 420 N/mm <sup>2</sup> , 125 HB	31
<b>P1.1.2</b> Unalloyed steel, heat-treated, 0.15 % C, Rm 420 N/mm <sup>2</sup> , 125 HB	31
<b>P1.1.3</b> Unalloyed steel, annealed, 0.45 % C, Rm 640 N/mm <sup>2</sup> , 190 HB	31
<b>P1.1.4</b> Unalloyed steel, heat-treated, 0.45 % C, Rm 640 N/mm <sup>2</sup> , 190 HB	31
<b>P1.1.5</b> Unalloyed steel, heat-treated, 0.45 % C, Rm 850 N/mm <sup>2</sup> , 250 HB	31
<b>P1.1.6</b> Unalloyed steel, annealed, 0.75 % C, Rm 915 N/mm <sup>2</sup> , 270 HB	31
<b>P1.1.7</b> Unalloyed steel, heat-treated, 0.75 % C, Rm 1020 N/mm <sup>2</sup> , 300 HB	31
<b>P2.1.1</b> Low-alloy steel, annealed, Rm 610 N/mm <sup>2</sup> , 180 HB	25
<b>P2.1.2</b> Low-alloy steel, heat-treated, Rm 930 N/mm <sup>2</sup> , 275 HB	25
<b>P2.1.3</b> Low-alloy steel, heat-treated, Rm 1020 N/mm <sup>2</sup> , 300 HB	25
<b>P2.1.4</b> Low-alloy steel, heat-treated, Rm 1190 N/mm <sup>2</sup> , 350 HB	25
<b>P3.1.1</b> High-alloy steel and tool steel, annealed, Rm 680 N/mm <sup>2</sup> , 200 HB	19
<b>P3.1.2</b> High-alloy steel and tool steel, hardened and tempered, Rm 1100 N/mm <sup>2</sup> , 325 HB	19
<b>M1.1.1</b> Stainless steel, ferritic/martensitic, with machining additives	
<b>M1.1.2</b> Stainless steel, ferritic/martensitic, annealed, Rm 680 N/mm <sup>2</sup> , 200 HB	
<b>M1.1.3</b> Stainless steel, ferritic/martensitic, heat-treated, Rm 810 N/mm <sup>2</sup> , 240 HB	
<b>M2.1.1</b> Stainless steel, austenitic, quenched, 180 HB	
<b>M2.2.1</b> Duplex steel, high-strength stainless steels	
<b>K1.1.1</b> Grey cast iron, pearlitic/ferritic, 180 HB	
<b>K1.1.2</b> Grey cast iron, pearlitic/martensitic, 260 HB	
<b>K1.2.1</b> Cast iron with spheroidal graphite, ferritic, 160 HB	
<b>K1.2.2</b> Cast iron with spheroidal graphite, pearlitic, 250 HB	
<b>K1.3.1</b> Malleable cast iron, ferritic, 130 HB	
<b>K1.3.2</b> Malleable cast iron, pearlitic, 230 HB	
<b>K2.1.1</b> Vermicular graphite cast iron (GJV)	
<b>K2.2.1</b> Austenitic-ferritic spheroidal graphite cast iron (ADI)	
<b>N1.1.1</b> Wrought aluminium alloys, non-hardened, 60 HB	
<b>N1.1.2</b> Wrought aluminium alloys, hardened, 100 HB	
<b>N2.1.1</b> Aluminium casting alloys, non-hardened, ≤ 12 % Si, 75 HB	
<b>N2.1.2</b> Aluminium casting alloys, hardened, ≤ 12 % Si, 90 HB	
<b>N2.1.3</b> Aluminium casting alloys, non-hardened, > 12 % Si, 130 HB	
<b>N3.1.1</b> Copper and copper alloys: Free-machining alloy, Pb > 1 %	
<b>N3.1.2</b> Copper and copper alloys: CuZn, CuSnZn	
<b>N3.1.3</b> Copper and copper alloys: CuSn, lead-free copper and copper electrolyte	
<b>N4.1.1</b> Non-metallic materials: Duroplastics, fibre-reinforced plastics	
<b>N4.1.2</b> Non-metallic materials: Hard rubber, wood, etc.	
<b>N4.1.3</b> Non-metallic materials: Graphite	
<b>S1.1.1</b> Heat-resistant alloys, Fe-based, annealed, 200 HB	
<b>S1.1.2</b> Heat-resistant alloys, Fe-based, hardened, 280 HB	
<b>S1.1.3</b> Heat-resistant alloys, Ni- or Co-based, annealed, 250 HB	
<b>S1.1.4</b> Heat-resistant alloys, Ni- or Co-based, hardened, 350 HB	
<b>S1.1.5</b> Heat-resistant alloys, Ni- or Co-based, cast, 320 HB	
<b>S2.1.1</b> Titanium alloys, pure titanium, Rm 400 N/mm <sup>2</sup>	
<b>S2.1.2</b> Titanium alloys, Alpha and Beta alloys, hardened, Rm 1050 N/mm <sup>2</sup>	
<b>H1.1.1</b> Hardened steel, hardened and tempered, < 55 HRC	
<b>H1.1.2</b> Hardened steel, hardened and tempered, < 60 HRC	
<b>H1.1.3</b> Hardened steel, hardened and tempered, > 60 HRC	
<b>H2.1.1</b> Chilled cast iron, 400 HB	
<b>H2.1.2</b> Chilled cast iron, hardened and tempered, < 55 HRC	