



GÜHRING

風力發電
大尺寸絲攻
M16 ~ M48



***Energy
high-performance
taps***

High-performance taps for the energy industry



High-performance taps Energy

HSS-E-PM 中心出水型 風力發電 大尺寸絲攻 6HX 公差

Taps with coolant ducts for ISO metric threads

Article no. **8313**



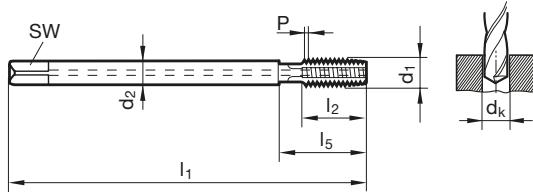
cutting data see page 7



for short chips and optimal thread surface

$P \leq 1200 \text{ N/mm}^2$

直溝短屑型



d1	P	d2	SW	dk	l1	l2	l5
mm	mm	mm	mm	mm	mm	mm	mm
M16	2.000	12.00	9.00	14.00	110.00	26.00	54.00
M20	2.500	16.00	12.00	17.50	140.00	32.00	62.00
M24	3.000	18.00	14.50	21.00	160.00	36.00	73.00
M27	3.000	20.00	16.00	24.00	160.00	36.00	73.00
M30	3.500	22.00	18.00	26.50	180.00	40.00	85.00
M33	3.500	25.00	20.00	29.50	180.00	40.00	91.00
M36	4.000	28.00	22.00	32.00	200.00	50.00	102.00
M39	4.000	32.00	24.00	35.00	200.00	50.00	107.00
M42	4.500	32.00	24.00	37.50	200.00	56.00	112.00
M48	5.000	36.00	29.00	43.00	250.00	65.00	127.00

Standard **DIN 376**
Article no. **8313**

Order no.	價格
8313 16.000	4,000
8313 20.000	5,900
8313 24.000	7,200
8313 27.000	9,700
8313 30.000	10,800
8313 33.000	15,500
8313 36.000	19,000
8313 39.000	21,200
8313 42.000	29,400
8313 48.000	39,600

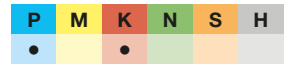
HSS-E-PM 中心出水型 風力發電 大尺寸絲攻 6HX 公差 加長型

Taps with coolant ducts for ISO metric threads

Article no. **8314**



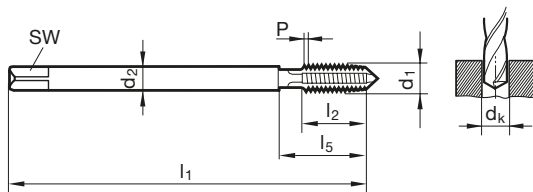
cutting data see page 7



for short chips and optimal thread surface • long design

$P \leq 1200 \text{ N/mm}^2$

直溝短屑型



d1	P	d2	SW	dk	l1	l2	l5
mm	mm	mm	mm	mm	mm	mm	mm
M16	2.000	12.00	9.00	14.00	160.00	26.00	100.00
M20	2.500	16.00	12.00	17.50	180.00	32.00	120.00
M24	3.000	18.00	14.50	21.00	200.00	36.00	120.00
M27	3.000	20.00	16.00	24.00	225.00	36.00	145.00
M30	3.500	22.00	18.00	26.50	250.00	40.00	160.00
M33	3.500	25.00	20.00	29.50	275.00	40.00	170.00
M36	4.000	28.00	22.00	32.00	300.00	50.00	180.00
M39	4.000	32.00	24.00	35.00	325.00	50.00	210.00
M42	4.500	32.00	24.00	37.50	350.00	56.00	235.00
M48	5.000	36.00	29.00	43.00	400.00	65.00	275.00

Standard **~DIN 376**
Article no. **8314**

Order no.	價格
8314 16.000	5,300
8314 20.000	7,900
8314 24.000	9,600
8314 27.000	12,900
8314 30.000	14,400
8314 33.000	20,600
8314 36.000	25,300
8314 39.000	28,200
8314 42.000	39,100
8314 48.000	52,700

Taps Energy



Machining group	Through-, blind holes	
	HSS-E-PM	
	P	
	v _c (m/min)	
P1.1.1 Unalloyed steel, annealed, 0.15 % C, Rm 420 N/mm ² , 125 HB		
P1.1.2 Unalloyed steel, heat-treated, 0.15 % C, Rm 420 N/mm ² , 125 HB		
P1.1.3 Unalloyed steel, annealed, 0.45 % C, Rm 640 N/mm ² , 190 HB		
P1.1.4 Unalloyed steel, heat-treated, 0.45 % C, Rm 640 N/mm ² , 190 HB		
P1.1.5 Unalloyed steel, heat-treated, 0.45 % C, Rm 850 N/mm ² , 250 HB		
P1.1.6 Unalloyed steel, annealed, 0.75 % C, Rm 915 N/mm ² , 270 HB		
P1.1.7 Unalloyed steel, heat-treated, 0.75 % C, Rm 1020 N/mm ² , 300 HB		
P2.1.1 Low-alloy steel, annealed, Rm 610 N/mm ² , 180 HB		
P2.1.2 Low-alloy steel, heat-treated, Rm 930 N/mm ² , 275 HB		18
P2.1.3 Low-alloy steel, heat-treated, Rm 1020 N/mm ² , 300 HB		15
P2.1.4 Low-alloy steel, heat-treated, Rm 1190 N/mm ² , 350 HB		12
P3.1.1 High-alloy steel and tool steel, annealed, Rm 680 N/mm ² , 200 HB		10
P3.1.2 High-alloy steel and tool steel, hardened and tempered, Rm 1100 N/mm ² , 325 HB		10
M1.1.1 Stainless steel, ferritic/martensitic, with machining additives		
M1.1.2 Stainless steel, ferritic/martensitic, annealed, Rm 680 N/mm ² , 200 HB		
M1.1.3 Stainless steel, ferritic/martensitic, heat-treated, Rm 810 N/mm ² , 240 HB		
M2.1.1 Stainless steel, austenitic, quenched, 180 HB		
M2.2.1 Duplex steel, high-strength stainless steels		
K1.1.1 Grey cast iron, pearlitic/ferritic, 180 HB		28
K1.1.2 Grey cast iron, pearlitic/martensitic, 260 HB		28
K1.2.1 Cast iron with spheroidal graphite, ferritic, 160 HB		28
K1.2.2 Cast iron with spheroidal graphite, pearlitic, 250 HB		28
K1.3.1 Malleable cast iron, ferritic, 130 HB		28
K1.3.2 Malleable cast iron, pearlitic, 230 HB		28
K2.1.1 Vermicular graphite cast iron (GJV)		14
K2.2.1 Austenitic-ferritic spheroidal graphite cast iron (ADI)		14
N1.1.1 Wrought aluminium alloys, non-hardened, 60 HB		
N1.1.2 Wrought aluminium alloys, hardened, 100 HB		
N2.1.1 Aluminium casting alloys, non-hardened, ≤ 12 % Si, 75 HB		
N2.1.2 Aluminium casting alloys, hardened, ≤ 12 % Si, 90 HB		
N2.1.3 Aluminium casting alloys, non-hardened, > 12 % Si, 130 HB		
N3.1.1 Copper and copper alloys: Free-machining alloy, Pb > 1 %		
N3.1.2 Copper and copper alloys: CuZn, CuSnZn		
N3.1.3 Copper and copper alloys: CuSn, lead-free copper and copper electrolyte		
N4.1.1 Non-metallic materials: Duroplastics, fibre-reinforced plastics		
N4.1.2 Non-metallic materials: Hard rubber, wood, etc.		
N4.1.3 Non-metallic materials: Graphite		
S1.1.1 Heat-resistant alloys, Fe-based, annealed, 200 HB		
S1.1.2 Heat-resistant alloys, Fe-based, hardened, 280 HB		
S1.1.3 Heat-resistant alloys, Ni- or Co-based, annealed, 250 HB		
S1.1.4 Heat-resistant alloys, Ni- or Co-based, hardened, 350 HB		
S1.1.5 Heat-resistant alloys, Ni- or Co-based, cast, 320 HB		
S2.1.1 Titanium alloys, pure titanium, Rm 400 N/mm ²		
S2.1.2 Titanium alloys, Alpha and Beta alloys, hardened, Rm 1050 N/mm ²		
H1.1.1 Hardened steel, hardened and tempered, < 55 HRC		
H1.1.2 Hardened steel, hardened and tempered, < 60 HRC		
H1.1.3 Hardened steel, hardened and tempered, > 60 HRC		
H2.1.1 Chilled cast iron, 400 HB		
H2.1.2 Chilled cast iron, hardened and tempered, < 55 HRC		