

# powertap

UNIVERSAL TAPS

MADE BY  
**GUHRING**



**PowerTaps**  
to ISO 529  
Standard

TOP OF THE LINE  
FORMERLY  
UNIVERSAL  
POWER TAPS  
perfect choice  
PROCESSED  
PERFECT  
UNIVERSAL  
powerful  
Power

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PERFECT CHOICE  
FOR MANY MATERIALS  
POWER  
PRICE  
UNIVERSAL TAPS  
UNC Power  
IVERSAL TAPS  
ERSAL perfect thread form  
TAPS powerful UNF

Available from:

# MORE POWER FOR YOUR PRODUCTION

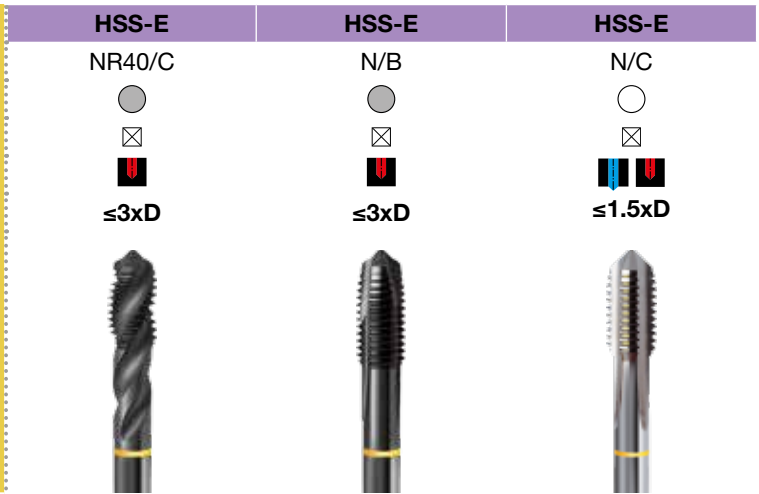
ISO PowerTaps – top quality from Germany at a power price

## YOUR ADVANTAGES:

- » UNMATCHABLE PRICE-PERFORMANCE RATIO
- » MAXIMUM STOCK AVAILABILITY
- » SUPER QUALITY
- » PERFECT THREADS
- » MAXIMUM PROCESS RELIABILITY



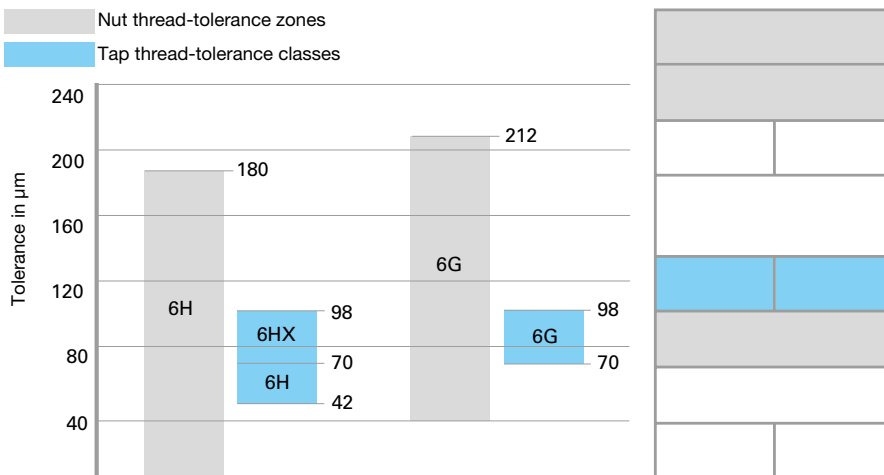
**powertap**  
UNIVERSAL TAPS



Thread		6	4	5	
Material / ISO Material		Recommended cutting speed $v_c$ m/min			
<b>P</b>	Struct./free-cut./unall. heat-treat./case hard. steels	≤ 800	10	12	6
	Free-cutting steels, unall. case hard. steels, nitr. steels	800 - 1 000	8	10	x
	Alloyed heat-treatable, tool and high speed steels	800 - 1200	6	8	x
<b>M</b>	Stainless steel - easy to machine / sulphured	≤ 0750	6	8	x
	Stainless steel - moderately difficult to machine	750 - 950	6	8	x
<b>K</b>	Cast iron, grey cast iron, spher. graph./mall. cast iron		12	15	10
<b>N</b>	Aluminium, Al-wrought alloys, Al-alloys	≤ 6% Si	12	15	x
	Aluminium-cast alloys	≥ 6% Si	8	10	10
<b>S</b>	Titan, Ti-alloys		2	4	x
	Ni-alloys		x	x	x
<b>H</b>	Hardened steels	45 - 55 HRC	x	x	x
	Hardened steels	55 - 62 HRC	x	x	x

Available in all essential tolerances

Tolerance zone / tolerance class allocation



6H:

The tolerance zone 6H corresponds with the standard tolerance for taps to DIN EN 22857.

6HX:

The additional letter "X" (6HX) indicates taps produced with deviating tolerance to standard. These deviations are based upon the company standard. Taps produced to tolerance 6HX are, for example, selected for abrasive or tough materials.

6G:

The tolerance zone 6G corresponds with an over-size condition tolerance for taps to DIN EN 22857 and is applied for components that are, for example, surface treated.



## ISO PowerTaps for ISO metric threads



through holes



steam tempered



external cooling

Guhring no.

4034

Standard

ISO 529

Tool material

HSS-E

Type

N

Form

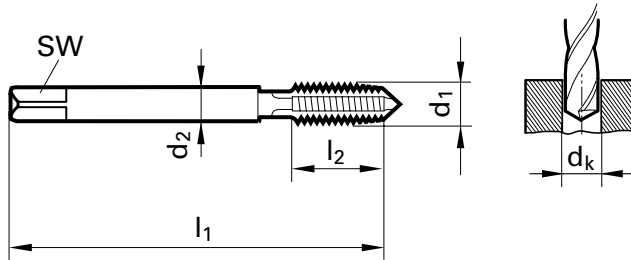
B

Tolerance

ISO 2 / 6H

Cutting direction

right-hand



d1	P	d2	SW	dk	l1	l2	Code no.
	mm	mm		mm	mm	mm	
M 3	0.50	3.15	2.50	2.50	48.00	10.00	3.000
M 4	0.70	4.00	3.15	3.30	53.00	12.00	4.000
M 5	0.80	5.00	4.00	4.20	58.00	16.00	5.000
M 6	1.00	6.30	5.00	5.00	66.00	18.00	6.000
M 8	1.25	8.00	6.30	6.80	72.00	22.00	8.000
M10	1.50	10.00	8.00	8.50	80.00	22.00	10.000
M 12	1.75	9.00	7.10	10.20	89.00	24.00	12.000
M 14	2.00	11.20	9.00	12.00	95.00	26.00	14.000
M 16	2.00	12.50	10.00	14.00	102.00	32.00	16.000
M 18	2.50	14.00	11.20	15.50	112.00	32.00	18.000
M 20	2.50	14.00	11.20	17.50	112.00	32.00	20.000

Price per item in £

6.60

6.20

6.40

6.40

7.20

9.30

13.00

16.20

18.80

28.50

30.50

### Table of application

ISO	P			M		K	N		S		H	
Material	Steel			Stainless steel		Cast iron	Aluminium		Special alloys		Hardened steel	
Properties	<800	<1000	<1200	<750	<950	GG	<6% Si	>6% Si	Ti	Ni	45-55 HRC	55-62 HRC
v <sub>c</sub> m/min	12	10	8	8	8	15	15	10	4	x	x	x

## ISO PowerTaps for ISO metric threads



through and  
blind holes

○ bright finish

☒ external cooling

Guhring no.

4035

Standard

ISO 529

Tool material

HSS-E

Type

N

Form

C

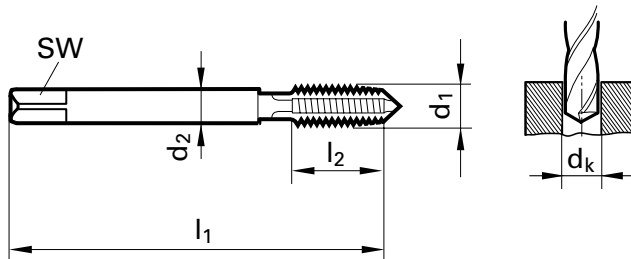
Tolerance

ISO 2 / 6H

Cutting direction

right-hand

**Tolerance  
ISO 2/6H**



d1	P	d2	SW	dk	l1	l2	Code no.
	mm	mm		mm	mm	mm	
M 3	0.50	3.15	2.50	2.50	48.00	10.00	3.000
M 4	0.70	4.00	3.15	3.30	53.00	12.00	4.000
M 5	0.80	5.00	4.00	4.20	58.00	16.00	5.000
M 6	1.00	6.30	5.00	5.00	66.00	18.00	6.000
M 8	1.25	8.00	6.30	6.80	72.00	22.00	8.000
M10	1.50	10.00	8.00	8.50	80.00	22.00	10.000
M 12	1.75	9.00	7.10	10.20	89.00	24.00	12.000
M 14	2.00	11.20	9.00	12.00	95.00	26.00	14.000
M 16	2.00	12.50	10.00	14.00	102.00	32.00	16.000
M 18	2.50	14.00	11.20	15.50	112.00	32.00	18.000
M 20	2.50	14.00	11.20	17.50	112.00	32.00	20.000

Price per item in £

4.30

4.00

4.10

4.10

4.80

6.20

8.50

10.50

12.90

19.20

21.30

### Table of application

ISO	P			M		K	N		S		H	
Material	Steel			Stainless steel		Cast iron	Aluminium		Special alloys		Hardened steel	
Properties	<800	<1000	<1200	<750	<950	GG	<6% Si	>6% Si	Ti	Ni	45-55 HRC	55-62 HRC
v <sub>c</sub> m/min	6	x	x	x	x	10	x	10	x	x	x	x

by **GUHRING**



## ISO PowerTaps for ISO metric threads

	<b>Guhring no.</b>	<b>4036</b>
	<b>Standard</b>	<b>ISO 529</b>
	<b>Tool material</b>	<b>HSS-E</b>
	<b>Type</b>	<b>N R40</b>
	<b>Form</b>	<b>C</b>
	<b>Tolerance</b>	<b>ISO 2 / 6H</b>
	<b>Cutting direction</b>	<b>right-hand</b>



blind holes

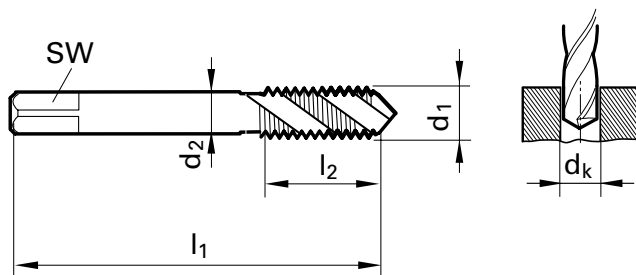


steam tempered



external cooling

**Tolerance  
ISO 2/6H**



d1	P	d2	SW	dk	l1	l2	Code no.	Price per item in £
	mm	mm		mm	mm	mm		
M 3	0.50	3.15	2.50	2.50	48.00	10.00	3.000	<b>8.40</b>
M 4	0.70	4.00	3.15	3.30	53.00	12.00	4.000	<b>7.70</b>
M 5	0.80	5.00	4.00	4.20	58.00	16.00	5.000	<b>8.30</b>
M 6	1.00	6.30	5.00	5.00	66.00	18.00	6.000	<b>8.30</b>
M 8	1.25	8.00	6.30	6.80	72.00	22.00	8.000	<b>9.30</b>
M10	1.50	10.00	8.00	8.50	80.00	22.00	10.000	<b>11.00</b>
M 12	1.75	9.00	7.10	10.20	89.00	24.00	12.000	<b>15.50</b>
M 14	2.00	11.20	9.00	12.00	95.00	26.00	14.000	<b>21.50</b>
M 16	2.00	12.50	10.00	14.00	102.00	32.00	16.000	<b>24.00</b>
M 18	2.50	14.00	11.20	15.50	112.00	32.00	18.000	<b>35.00</b>
M 20	2.50	14.00	11.20	17.50	112.00	32.00	20.000	<b>39.00</b>

for blind holes

6

### Table of application

ISO	P			M		K	N		S		H	
Material	Steel			Stainless steel		Cast iron	Aluminium		Special alloys		Hardened steel	
Properties	<800	<1000	<1200	<750	<950	GG	<6% Si	>6% Si	Ti	Ni	45-55 HRC	55-62 HRC
v <sub>c</sub> m/min	<b>10</b>	8	6	6	6	12	<b>12</b>	8	2	x	x	x

SAME PRICE  
MORE PERFORMANCE

GÜHROSYNC



by **GUHRING**

# powertap

## UNIVERSAL TAPS

### Universal taps to ISO 529 Standard



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