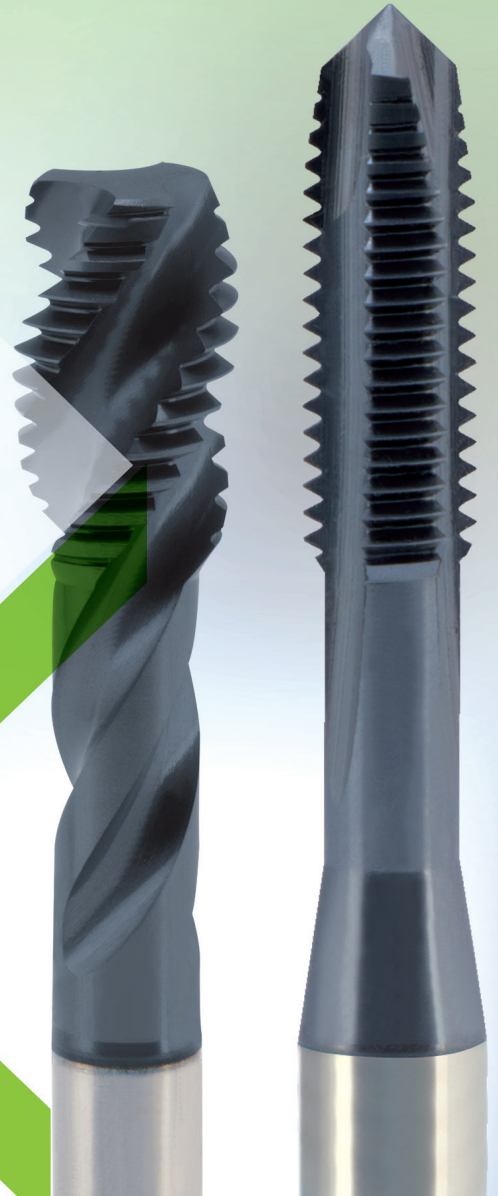


GUHRING

适用于大多数材料
性价比高

适用于普通钻床和CNC加工中心
德国制造

JIS > eco < tap
just smart!



JIS eco丝锥

GUHRING - YOUR WORLD-WIDE PARTNER

JIS > eco < tap

just smart!

特殊的刃口处理工艺，实现完美的涂层效果

全新设计的切削槽及头部几何参数，丝锥具有更长，更稳定的刀具寿命

高性能TiCN 涂层使得切削刃口更加耐磨，从而提高刀具寿命

与无涂层丝锥相比该丝锥可将刀具寿命延长一倍
涂层丝锥使得切削速度可以翻倍——降低成本



All these features ensure a

perfect
chip
evacuation

由于其优异的头部几何参数及刃口处理工艺，ecotaps可以在任何工况下正常工作，因此ecotaps既可以应用于立式钻床，也可以在CNC加工中心使用。与没有涂层的丝锥相比，使用TiCN涂层的ecotap可以使刀具寿命延长一倍。德国最新的磨削工艺和涂层技术保证了ecotap丝锥高性价比。

JIS Eco Taps



Guhring no.

7777



Guhring no.

7778



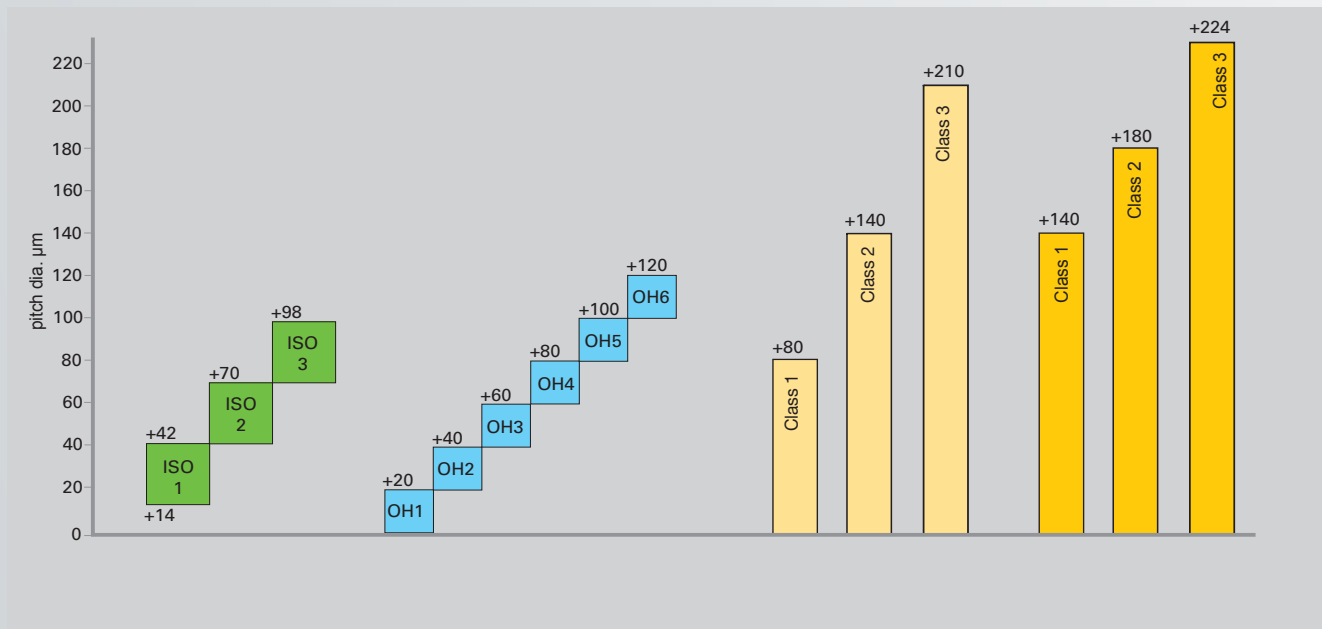
	Thread	Ø-range on page	
	M	4	5
工件材料	Hardness N/mm ²	推荐线速度vc m/min	
Struct./free-cut./unall. heat-treat./case hard. steels	≤ 800	18	18
P Free-cutting steels, unall. case hard. steels, nitr. steels	800–1000	15	15
Alloyed heat-treatable, tool and high speed steels	800–1200	10	10
M Stainless steel - easy to machine / sulphured	≤ 750	10	10
Stainless steel - moderately difficult to machine	750–950	10	10
K Cast iron, grey cast iron, spher. graph./mall. cast iron		18	18
N Aluminium, Al-wrought alloys, Al-alloys	≤ 6% Si	18	18
Aluminium-cast alloys	≥ 6% Si	18	18
S Titan, Ti-alloys		2	2
Ni-alloys		x	x
H Hardened steels	45–55 HRC	x	x
Hardened steels	55–62 HRC	x	x

螺纹公差

Example M10 (x 1.5)

ISO limits
OH limits

JIS internal thread
ISO internal thread

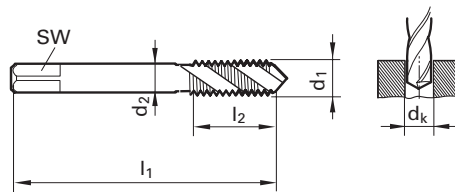


ISO公制切削丝锥-盲孔丝锥



P	•
M	•
K	•
N	•
S	○
H	

刀具材料	HSS-E
公差	OH2-OH5
表面涂层	C
型号	N R40
类型	C
冷却	外冷



JIS B 4430

产品代码

7777

d1	P	Tolerance	d2	SW	dk	l1	l2	l5
	mm		mm	mm	mm	mm	mm	mm
M3	0.500	OH2	4.000	3.200	2.50	46.000	6.000	19.000
M4	0.700	OH3	5.000	4.000	3.30	52.000	7.500	20.000
M5	0.800	OH3	5.500	4.500	4.20	60.000	8.500	24.000
M6	1.000	OH3	6.000	4.500	5.00	62.000	11.000	29.000
M8	1.250	OH3	6.200	5.000	6.80	70.000	14.000	37.000
M10	1.500	OH3	7.000	5.500	8.50	75.000	16.000	41.000
M12	1.750	OH4	8.500	6.500	10.20	82.000	18.500	48.000
M14	2.000	OH4	10.500	8.000	12.00	88.000	20.000	48.000
M16	2.000	OH4	12.500	10.000	14.00	95.000	20.000	52.000
M18	2.500	OH5	14.000	11.000	15.50	100.000	25.000	55.000
M20	2.500	OH5	15.000	12.000	17.50	105.000	25.000	58.000

切削参数

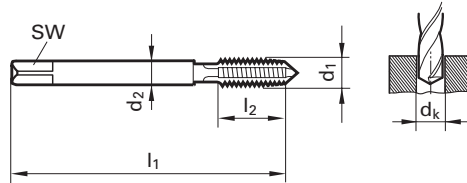
ISO	P钢件			M不锈钢		K铸铁	N非铁合金, 铝合金		S特殊合金		H硬钢	
Material	Steel			Stainless steel		Cast iron	Aluminium		Special alloys		Hardened steel	
Properties	<800	<1000	<1200	<750	<950		<6% Si	>6% Si	Ti	Ni	45-55 HRC	55-62 HRC
v _c m/min	18	15	10	10	10	18	18	18	2	x	x	x

ISO公制切削丝锥-通孔丝锥



P	•
M	•
K	•
N	•
S	○
H	

刀具材料	HSS-E
公差	OH2-OH5
表面涂层	C
型号	N
类型	B
冷却	外冷



JIS B 4430

产品代码

7778

d1	P	Tolerance	d2	SW	dk	l1	l2	l5
	mm		mm	mm	mm	mm	mm	mm
M3	0.500	OH2	4.000	3.200	2.50	46.000	10.000	19.000
M4	0.700	OH3	5.000	4.000	3.30	52.000	12.000	20.000
M5	0.800	OH3	5.500	4.500	4.20	60.000	14.000	24.000
M6	1.000	OH3	6.000	4.500	5.00	62.000	16.000	29.000
M8	1.250	OH3	6.200	5.000	6.80	70.000	17.000	37.000
M10	1.500	OH3	7.000	5.500	8.50	75.000	20.000	41.000
M12	1.750	OH4	8.500	6.500	10.20	82.000	24.000	48.000
M14	2.000	OH4	10.500	8.000	12.00	88.000	26.000	48.000
M16	2.000	OH4	12.500	10.000	14.00	95.000	26.000	52.000
M18	2.500	OH5	14.000	11.000	15.50	100.000	30.000	55.000
M20	2.500	OH5	15.000	12.000	17.50	105.000	32.000	58.000

切削参数

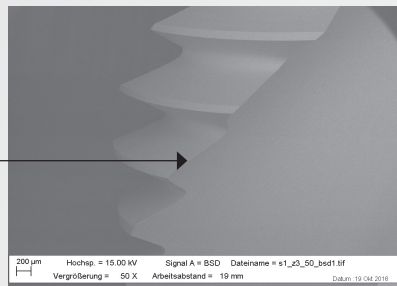
ISO	P钢件			M不锈钢		K铸铁	N非铁合金, 铝合金		S特殊合金		H硬钢	
Material	Steel			Stainless steel		Cast iron	Aluminium		Special alloys		Hardened steel	
Properties	<800	<1000	<1200	<750	<950	GG	<6% Si	>6% Si	Ti	Ni	45-55 HRC	55-62 HRC
v _c m/min	18	15	10	10	10	18	18	18	2	x	x	x

切削丝锥底孔直径

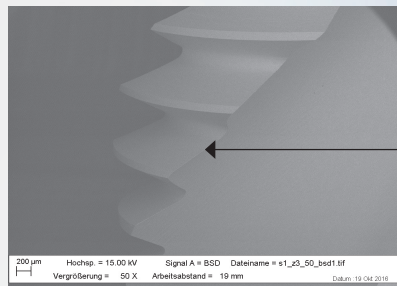
Std. ISO metric threads DIN 13				ISO metric fine threads DIN 13				UNC threads ASME B1.1					
nom. Ø	pitch P	tapping size hole Ø DIN 336 mm	core diameter of int. thread 6H* min. max. mm	nom. x pitch P	tapping size hole Ø DIN 336 mm	core diameter of int. thread 6H min. max. mm	nom. x pitch P	tapping size hole Ø DIN 336 mm	core diameter of int. thread 6H min. max. mm	nom. Ø	threads per inch	tapping size hole Ø DIN 336 mm	core diameter of int. thread 2B min. max. mm
M 1	0.25	0.75	0.729 0.785	M 2.5 x 0.35	2.15	2.121 2.221	M 22 x 1.50	20.50	20.376 20.676	Nr. 1 - 64		1.55	1.425 1.580
M 1.1	0.25	0.85	0.829 0.885	M 3.0 x 0.35	2.65	2.621 2.721	M 22 x 2.00	20.00	19.835 20.210	Nr. 2 - 56		1.85	1.694 1.872
M 1.2	0.25	0.95	0.929 0.985	M 3.5 x 0.35	3.15	3.121 3.221	M 24 x 1.00	23.00	22.917 23.153	Nr. 3 - 48		2.10	1.941 2.146
M 1.4	0.30	1.10	1.075 1.142	M 4.0 x 0.50	3.50	3.459 3.599	M 24 x 1.50	22.50	22.376 22.676	Nr. 4 - 40		2.35	2.157 2.385
M 1.6	0.35	1.25	1.221 1.321	M 4.5 x 0.50	4.00	3.959 4.099	M 24 x 2.00	22.00	21.835 22.210	Nr. 5 - 40		2.65	2.487 2.698
M 1.8	0.35	1.45	1.421 1.521	M 5.0 x 0.50	4.50	4.459 4.599	M 25 x 1.00	24.00	23.917 24.153	Nr. 6 - 32		2.85	2.642 2.896
M 2	0.40	1.60	1.567 1.679	M 5.5 x 0.50	5.00	4.959 5.099	M 25 x 1.50	23.50	23.376 23.676	Nr. 8 - 32		3.50	3.302 3.531
M 2.2	0.45	1.75	1.713 1.838	M 6.0 x 0.75	5.20	5.188 5.378	M 25 x 2.00	23.00	22.835 23.210	Nr. 10 - 24		3.90	3.683 3.937
M 2.5	0.45	2.05	2.013 2.138	M 7.0 x 0.75	6.20	6.188 6.378	M 27 x 1.00	26.00	25.917 26.153	Nr. 12 - 24		4.50	4.343 4.597
M 3	0.50	2.50	2.459 2.599	M 8.0 x 0.50	7.50	7.459 7.599	M 27 x 1.50	25.50	25.376 25.676	1/4 - 20		5.10	4.978 5.258
M 3.5	0.60	2.90	2.850 3.010	M 8.0 x 0.75	7.20	7.188 7.378	M 27 x 2.00	25.00	24.835 25.210	5/16 - 18		6.60	6.401 6.731
M 4	0.70	3.30	3.242 3.422	M 8.0 x 1.00	7.00	6.917 7.153	M 28 x 1.00	27.00	26.917 27.153	3/8 - 16		8.00	7.798 8.153
M 4.5	0.75	3.70	3.688 3.878	M 9.0 x 0.75	8.20	8.188 8.378	M 28 x 1.50	26.50	26.376 26.676	7/16 - 14		9.40	9.144 9.550
M 5	0.80	4.20	4.134 4.334	M 9.0 x 1.00	8.00	7.917 8.153	M 28 x 2.00	26.00	25.835 26.210	1/2 - 13		10.80	10.592 11.024
M 6	1.00	5.00	4.917 5.153	M 10 x 0.75	9.20	9.188 9.378	M 30 x 1.00	29.00	28.917 29.153	9/16 - 12		12.20	11.989 12.446
M 7	1.00	6.00	5.917 6.153	M 10 x 1.00	9.00	8.917 9.153	M 30 x 1.50	28.50	28.376 28.676	5/8 - 11		13.50	13.386 13.868
M 8	1.25	6.80	6.647 6.912	M 10 x 1.25	8.80	8.647 8.912	M 30 x 2.00	28.00	27.835 28.210	3/4 - 10		16.50	16.307 16.840
M 9	1.25	7.80	7.647 7.912	M 11 x 0.75	10.20	10.188 10.378	M 30 x 3.00	27.00	26.752 27.252	7/8 - 9		19.50	19.177 19.761
M 10	1.50	8.50	8.376 8.676	M 11 x 1.00	10.00	9.917 10.153	M 32 x 1.50	30.50	30.376 30.676	1 - 8		22.25	21.971 22.606
M 11	1.50	9.50	9.376 9.676	M 12 x 1.00	11.00	10.917 11.153	M 32 x 2.00	30.00	29.835 30.210	1 1/8 - 7		25.00	24.638 25.349
M 12	1.75	10.20	10.106 10.441	M 12 x 1.25	10.80	10.647 10.912	M 33 x 1.50	31.50	31.376 31.676	1 1/4 - 7		28.00	27.813 28.524
M 14	2.00	12.00	11.835 12.210	M 12 x 1.50	10.50	10.376 10.676	M 33 x 2.00	31.00	30.835 31.210	1 3/8 - 6		30.75	30.353 31.115
M 16	2.00	14.00	13.835 14.210	M 14 x 1.00	13.00	12.917 13.153	M 33 x 3.00	30.00	29.752 30.252	1 1/2 - 6		34.00	33.528 34.290
M 18	2.50	15.50	15.294 15.744	M 14 x 1.25	12.80	12.647 12.912	M 35 x 1.50	33.50	33.376 33.676	1 3/4 - 5		39.50	38.938 39.802
M 20	2.50	17.50	17.294 17.744	M 14 x 1.50	12.50	12.376 12.676	M 36 x 1.50	34.50	34.376 34.676	2 - 4.5		45.00	44.679 45.593
M 22	2.50	19.50	19.294 19.744	M 15 x 1.00	14.00	13.917 14.153							
M 24	3.00	21.00	20.752 21.252	M 15 x 1.50	13.50	13.376 13.676							
M 27	3.00	24.00	23.752 24.252	M 16 x 1.00	15.00	14.917 15.153							
M 30	3.50	26.50	26.211 26.771	M 16 x 1.25	14.80	14.647 14.912							
M 33	3.50	29.50	29.211 29.771	M 16 x 1.50	14.50	14.376 14.676							
M 36	4.00	32.00	31.670 32.270	M 17 x 1.00	16.00	15.917 16.153							
M 39	4.00	35.00	34.670 35.270	M 17 x 1.50	15.50	15.376 15.676							
M 42	4.50	37.50	37.129 37.799	M 18 x 1.00	17.00	16.917 17.153							
M 45	4.50	40.50	40.129 40.799	M 18 x 1.50	16.50	16.376 16.676							
M 48	5.00	43.00	42.587 43.297	M 20 x 1.00	19.00	18.917 19.153							
M 52	5.00	47.00	46.587 47.297	M 20 x 1.50	18.50	18.376 18.676							
M 56	5.50	50.50	50.046 50.796	M 20 x 2.00	18.00	17.835 18.210							
				M 22 x 1.00	21.00	20.917 21.153							

* M 1.1 up to M 1.4 tapping size hole of int. thread 5H

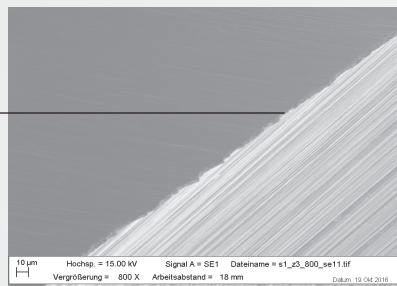
Cutting Edge Finishing



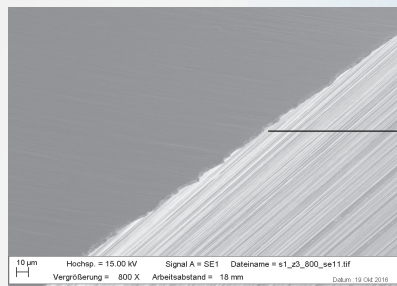
普通丝锥刃口处理



JIS ecotap刃口处理



毛刷



喷砂

- 更高的表面质量
- 更均匀的切削刃口处理
- 更好的涂层附着力
- 更高的螺纹质量

GÜHROSYNC

by **GUHRING**



GÜHRO Sync

JIS>eco<tap

just smart!

by **GUHRING**

价格优势
应用广泛
高质量

GUHRING

钴钨（常州）刀具有限公司

江苏省常州市新北区峨眉山路19号

邮编：213022

电话：（0519）85109713

传真：（0519）85104832

E-mail: info@guhiringchina.com

Http: www.guhiringchina.com

