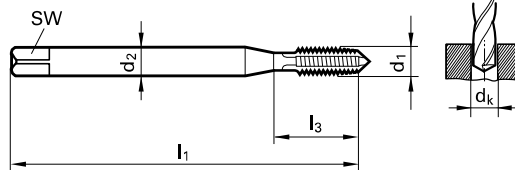



Series
4406

-  through holes
-  TiCN coated
-  external cooling


Standard
ASME B94.9-1999
Standard
ANSI
Tool Material
HSS-E (Cobalt)
Flute
Spiral Point
Chamfer Form
B (3.5 - 5)

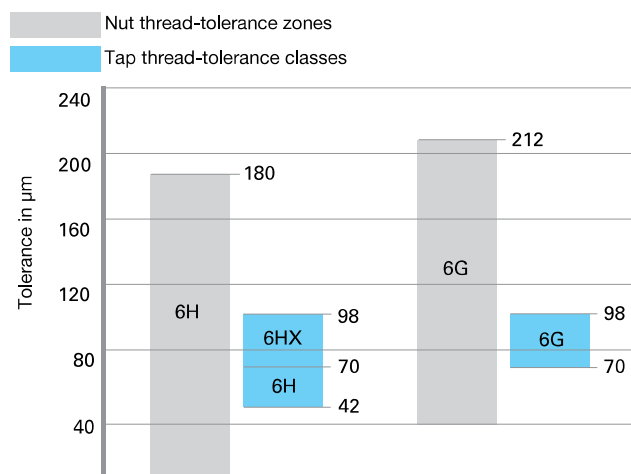
Class of Fit
2B / 3B see H Limits
Cutting Direction
right-hand

d1 - P inch	Thread Limits	d2 inch	SW inch	dk inch	l1 inch	l3 inch	Order Code	EDP Number
3-56	H2	0.141	0.110	0.0827	1.811	0.500	202.515	9044062025150
4-48	H2	0.141	0.110	0.0937	1.882	0.709	202.845	9044062028450
6-40	H2	0.141	0.110	0.1161	2.000	0.748	203.505	9044062035050
8-36	H2	0.168	0.131	0.1378	2.130	0.827	204.166	9044062041660
10-32	H3	0.194	0.152	0.1610	2.382	0.945	304.826	9044063048260
10-32	H5	0.194	0.152	0.1610	2.382	0.945	504.826	9044065048260
10-32	H6	0.194	0.152	0.1610	2.382	0.945	604.826	9044066048260
12-28	H3	0.220	0.165	0.1820	2.382	1.024	305.486	9044063054860
1/4-28	H3	0.255	0.191	0.2165	2.500	1.181	306.350	9044063063500
1/4-28	H5	0.255	0.191	0.2165	2.500	1.181	506.350	9044065063500
5/16-24	H3	0.318	0.238	0.2717	2.721	1.377	307.938	9044063079380
5/16-24	H5	0.318	0.238	0.2717	2.721	1.377	507.938	9044065079380
3/8-24	H3	0.381	0.285	0.3346	2.941	1.456	309.525	9044063095250
3/8-24	H5	0.381	0.285	0.3346	2.941	1.456	509.525	9044065095250
7/16-20	H3	0.323	0.242	0.3906	3.161	N/A	311.113	9044063111130
7/16-20	H5	0.323	0.242	0.3906	3.161	N/A	511.113	9044065111130
1/2-20	H3	0.367	0.275	0.4531	3.382	N/A	312.700	9044063127000
1/2-20	H5	0.367	0.275	0.4531	3.382	N/A	512.700	9044065127000
9/16-18	H3	0.429	0.322	0.5118	3.591	N/A	314.288	9044063142880
5/8-18	H3	0.480	0.360	0.5709	3.811	N/A	315.875	9044063158750
5/8-18	H5	0.480	0.360	0.5709	3.811	N/A	515.875	9044065158750
3/4-16	H3	0.590	0.442	0.6874	4.252	N/A	319.050	9044063190500
3/4-16	H5	0.590	0.442	0.6874	4.252	N/A	519.050	9044065190500
7/8-14	H4	0.697	0.523	0.8030	4.689	N/A	422.225	9044064222250
1-12	H4	0.800	0.600	0.9220	5.130	N/A	425.400	9044064254000



	Hardness		Cutting speed SFM	
	Rc	BRN	Steam Oxide	Hard Coatings
Structural steels	–	< 250	30 - 45	30 - 60
Free-cutting steels	–	< 250	30 - 60	30 - 70
Unalloyed case hardened steels	< 20	< 230	30 - 45	30 - 65
Unalloyed heat-treatable steels	< 24	< 250	30 - 45	30 - 65
Alloyed case hardened steels	< 30	< 285	25 - 35	25 - 30
Alloyed heat-treatable steels	< 30	< 285	20 - 30	20 - 45
Alloyed tool steels	< 30	< 285	20 - 30	20 - 45
High speed tool steels	< 30	< 290	20 - 30	20 - 45
Stainl./acid-resist. steels, sulphured	< 24	< 250	20 - 35	30 - 40
austenitic	< 24	< 250	20 - 35	30 - 40
martensitic	< 24	< 250	20 - 35	30 - 40
Aluminum and Al-alloys	–	< 120	45 - 60	45 - 85
Al wrought alloys	–	< 120	45 - 60	45 - 85
Al cast alloys ≤ 10 % Si	–	< 180	45 - 60	45 - 85
> 10 % Si	–	< 180	45 - 60	45 - 85
Cast iron	–	< 240	45 - 60	45 - 85
Spheroidal graphite iron	–	< 240	45 - 60	45 - 85
Malleable cast iron	–	< 300	30 - 50	45 - 85

Tolerance zone / tolerance class allocation



DIN EN 22857	
Application class of tap	
Class 2 ISO 2	Class 3 ISO 3
Tolerance zone of internal thread to be cut	
6H	6G
DIN 802 part 1 (withdrawn)	
Tolerance class of tap	
6H	6G

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.



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» GUHRING QUALITY

» SHORT DELIVERY TIMES

» LONG TOOL LIFE

» PERFECT THREADS

» MAXIMUM PROCESS RELIABILITY

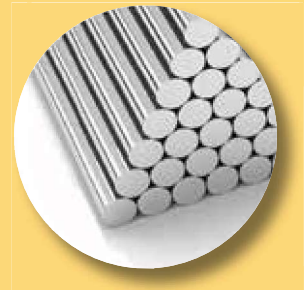
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