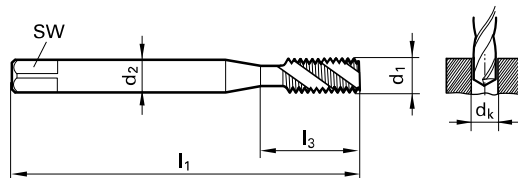




Series 4408

-  blind holes
-  TiCN coated
-  external cooling



Standard ASME B94.9-1999

Standard ANSI

Tool Material HSS-E (Cobalt)

Flute RH 40° Spiral

Chamfer Form C (2 - 3)



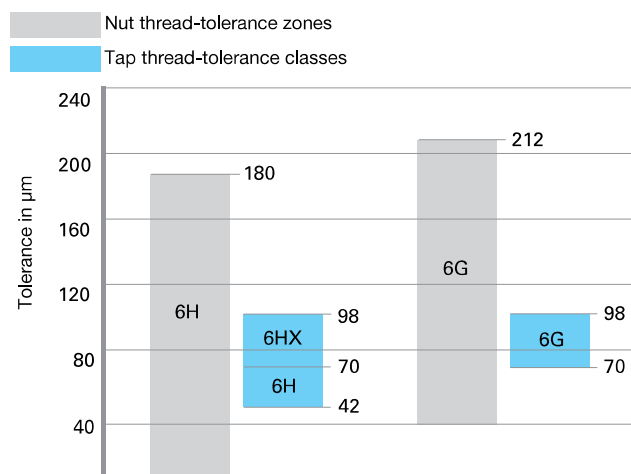
Class of Fit 2B / 3B see H Limits
Cutting Direction right-hand

d1 - P	Thread Limits	d2	SW	dk	l1	l3	Order Code	EDP Number
inch		inch	inch	inch	inch	inch		
2-56	H2	0.141	0.110	0.0700	1.752	0.441	202.184	9044082021840
3-48	H2	0.141	0.110	0.0811	1.811	0.500	202.515	9044082025150
4-40	H2	0.141	0.110	0.0890	1.882	0.709	202.845	9044082028450
4-40	H3	0.141	0.110	0.0890	1.882	0.709	302.845	9044083028450
4-40	H5	0.141	0.110	0.0890	1.882	0.709	502.845	9044085028450
5-40	H2	0.141	0.110	0.1016	1.941	0.709	203.175	9044082031750
6-32	H3	0.141	0.110	0.1094	2.000	0.748	303.505	9044083035050
6-32	H5	0.141	0.110	0.1094	2.000	0.748	503.505	9044085035050
8-32	H3	0.168	0.131	0.1358	2.130	0.827	304.166	9044083041660
8-32	H5	0.168	0.131	0.1358	2.130	0.827	504.166	9044085041660
10-24	H3	0.194	0.152	0.1520	2.382	0.945	304.826	9044083048260
10-24	H5	0.194	0.152	0.1520	2.382	0.945	504.826	9044085048260
12-24	H3	0.220	0.165	0.1772	2.382	1.024	305.486	9044083054860
1/4-20	H3	0.255	0.191	0.2031	2.500	1.181	306.350	9044083063500
1/4-20	H5	0.255	0.191	0.2031	2.500	1.181	506.350	9044085063500
5/16-18	H3	0.318	0.238	0.2610	2.721	1.377	307.938	9044083079380
5/16-18	H5	0.318	0.238	0.2610	2.721	1.377	507.938	9044085079380
3/8-16	H3	0.381	0.286	0.3161	2.941	1.456	309.525	9044083095250
3/8-16	H5	0.381	0.286	0.3161	2.941	1.456	509.525	9044085095250
7/16-14	H3	0.323	0.242	0.3677	3.161	N/A	311.113	9044083111130
7/16-14	H5	0.323	0.242	0.3677	3.161	N/A	511.113	9044085111130
1/2-13	H3	0.367	0.275	0.4220	3.382	N/A	312.700	9044083127000
1/2-13	H5	0.367	0.275	0.4220	3.382	N/A	512.700	9044085127000
9/16-12	H3	0.429	0.322	0.4843	3.591	N/A	314.288	9044083142880
5/8-11	H3	0.480	0.360	0.5311	3.811	N/A	315.875	9044083158750
5/8-11	H5	0.480	0.360	0.5311	3.811	N/A	515.875	9044085158750
3/4-10	H3	0.590	0.442	0.6563	4.252	N/A	319.050	9044083190500
3/4-10	H5	0.590	0.442	0.6563	4.252	N/A	519.050	9044085190500
7/8-9	H5	0.697	0.523	0.7680	4.689	N/A	522.225	9044085222250
1-8	H5	0.800	0.600	0.8748	5.130	N/A	525.400	9044085254000



	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.



powertap™
MADE IN GERMANY UNIVERSAL TAPS

MADE BY
GUHRING

TOP QUALITY
FROM GERMANY
at a Power Price

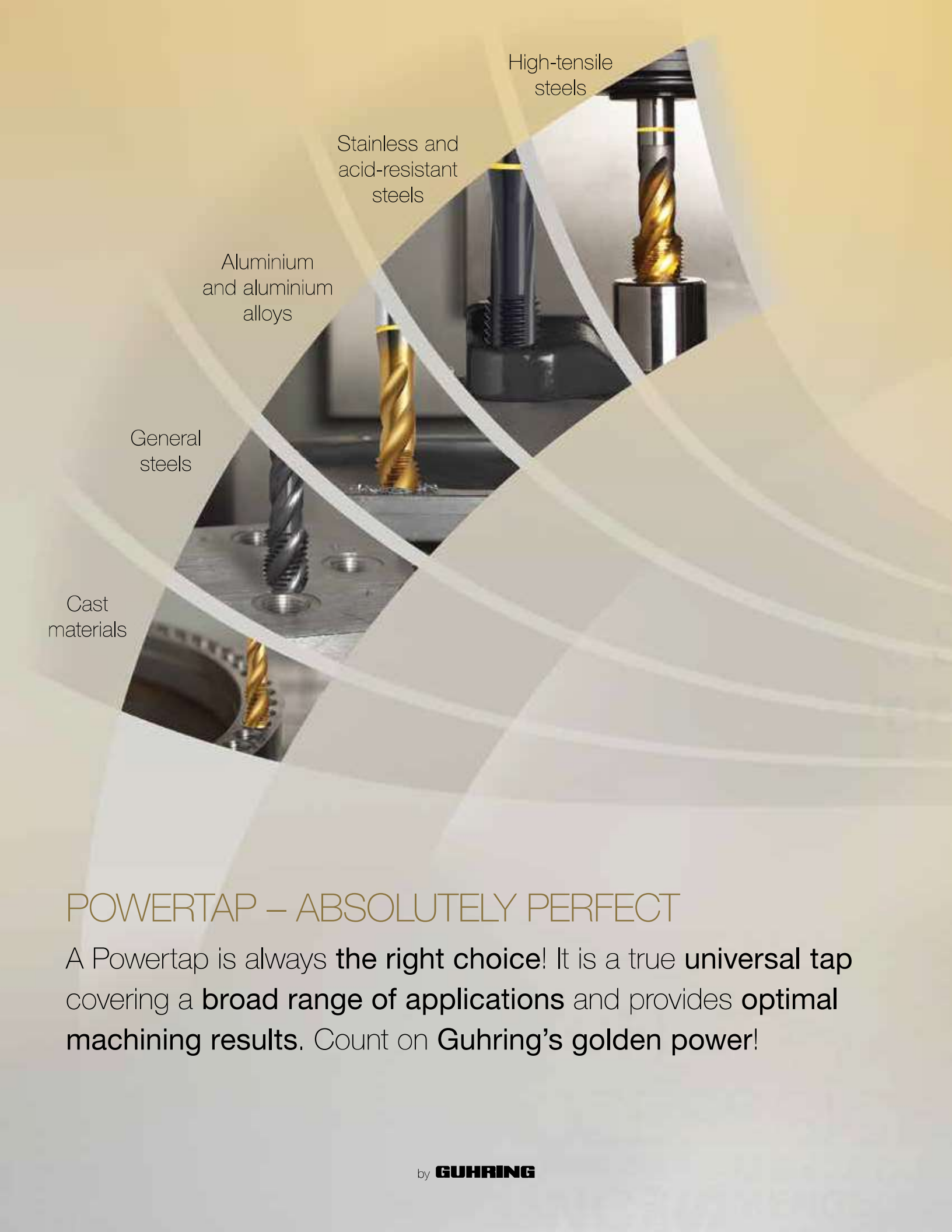
TO FORM
FOR UNIV
UNIVERSAL
perfect
perfect
choice
PR
PER
UN
po
P

ISO-METRIC
THREADS
utes
GUHRING
QUALITY
METAL
UNIVERSAL
UNIVERSAL
UNIVERSAL
perfect thre
powerfu

PERFECT CHOICE
FOR ALL MATERIALS
**POWER
PRICE**
UNI
VER
SAL
Power
UNIVERSAL TAPS
UNIVERSAL TAPS
UNIVERSAL TAPS

QR CODE

www.guhring.com/powertap



High-tensile
steels

Stainless and
acid-resistant
steels

Aluminium
and aluminium
alloys

General
steels

Cast
materials

POWERTAP – ABSOLUTELY PERFECT

A Powertap is always **the right choice!** It is a true **universal tap** covering a **broad range of applications** and provides **optimal machining results**. Count on **Guhring's golden power!**

MORE POWER FOR YOUR PRODUCTION

PowerTap – top quality from Germany at a power price

YOUR ADVANTAGES:

» UNMATCHABLE

PRICE/PERFORMANCE RATIO

» MAXIMUM STOCK AVAILABILITY

» GUHRING QUALITY

» SHORT DELIVERY TIMES

» LONG TOOL LIFE

» PERFECT THREADS

» MAXIMUM PROCESS RELIABILITY

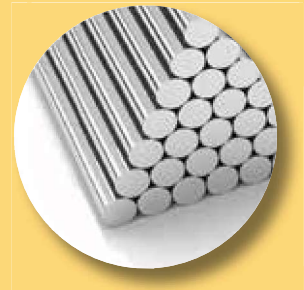
Optimized geometries for
maximum performance



Completely precision ground on
specially developed machines



Finest quality substrates



More power for your production



by **GUHRING**

TECHNICAL

GÜHROSync

UP TO 30% BETTER PERFORMANCE AT A POWER PRICE

Allows for 0.3 mm of compensation for up
to 75% reduction in axial forces

Offers internal, peripheral or
MQL lubrication

Extreme concentricity and
application speed

First tapping chuck to offer combination
of steel and polymer components
for independent axial and torsional
force dampening

Quick and simple handling, slim design

Maximum tool life and thread accuracy



The new **GÜHROSync** tapping chuck

Synchro and hydraulic clamping technology intelligently combined

by **GUHRING**