

The Guhring colour code

The Guhring colour-code simplifies the selection of the optimal Guhring threading tool for the workpiece material. The structure of the compass pages for taps and thread milling cutters is corresponding to this colour-code.

Malleable materials are signed with the forming symbol in the material examples.

Material examples:

General Information

General steels		High tensile steels		Acid-/stainl. resist. steels		Universal		Al and Al-alloys	
Material no. to DIN EN 10 027	Abbreviation	Material no. to DIN EN 10 027	Abbreviation	Material no. to DIN EN 10 027	Abbreviation	Material no. to DIN EN 10 027	Abbreviation	Material no.	Abbreviation
Common structural steels		Alloyed heat-treatable steels		Sulphured stainless steels		Common structural steels		Al and al-alloys	
1.0035 1.0039 1.0036 1.0060	S 185 (St 33) S 235 JRH S 235JRG1+CR E 335 (St 60-2)	1.6511 1.7033 1.7225	36 CrNiMo 4 34 Cr 4 42 CrMo 4	1.4005 1.4104 1.4105 1.4305	X 12 CrS 13 X 14 CrMo S 17 X 6 CrMo S 17 X 8CrNi S 18-9	1.0035 1.0421 1.0067 1.0425	S185 (St33) St 52.0 RSt 37-1 P265GH	3.0250 3.0280 3.3308	Al 99,5H AL 99,8H Al99,9Mg0.5
Free-cutting steels		Tool steels		Austenitic stainless steels		Free-cutting steels		Al wrought alloys	
1.0718 1.0721 1.0758 1.0726	11SMnPb30 10S20 60SPb20 35S20	1.2316 1.2067	X 36 CrMo 17 10 S20	1.4300 1.4301 1.4541	X 12 CrNi 18-8 X 5 CrNi 18-10 X 6 CrNiTi 18-10	1.0711 1.0718 1.0727 1.0728	9S20 11SMnPb30 46S20 (60 S 20)	3.2315 3.1655 3.4335	AlMgSi1 AlCuMgPb AlZn4,5Mg1
Case hardened steels		High speed steels		Martens. stainless steels		Case hardened steels		Al cast alloys ≤ 10% Si	
1.0401 1.7016 1.7131 1.5919	(C 15) 17 CR3 16MnCr5 15CrNi6	1.3343 1.3344 1.3243 1.3247	HS 6-5-2 HS 6-5-3 HS 6-5-2-5 HS 2-19-1-8	1.4057 1.4112 1.4006	X 17 CrNi 16-2 X 90 CrMoV 18 X 12 Cr 13	1.7131 1.6523 1.7321 1.7325	16MnCr5 21NiCrMo2-2 20MoCr4 25MoCr4	3.2134 3.2162 3.2373	GD-AlSi5Cu1Mg GD-AlSi8Cu3 G-AlSi9Mg
Unalloyed heat-treatable steels		Hardened steels				Unalloyed heat-treatable steels		Al cast alloys > 10% Si	
1.0402 1.1151 1.0503 1.1191	C 22 C22E (Ck 22) C 45 C45E (Ck 45)	The above mentioned materials hardened to 45...62 HRC				1.0402 1.1151 1.0503 1.0601	C22 C22E C45 C60	3.2581 3.2583 3.2581	G-AlSi12 G-AlSi12Cu G-AlSi10Mg
						Nitriding steels			
						1.8504 1.8507 1.8509 1.8515 1.8550	34CrAl6 34CrAlMo5 41CrAlMo7 31CrMo12 34CrAlNi4		
						Spher. graphite iron			
						0.7040 0.7060	EN-GJS-400-15 EN-GJS-600-3		

Taps for general steels are suitable for conventional machining with quick change tapping chucks.

Taps for universal applications are suitable for CNC machining with synchro tapping chucks for extended tool life.

Cast materials		Non-ferrous metals		Plastics		Magnesium-alloys		Special-alloys	
Material no.	Abbreviation	Material no.	Abbreviation	Material no.	Description	Material no.	Abbreviation	Material no.	Abbreviation
Cast iron		Brass, short-chipping		Duroplastics		Magnesium-alloys		Titanium	
0.6015 (GG15) 0.6025 (GG25) 0.6040 (GG40)	EN-GJL-150 EN-GJL-250 EN-JLZ	2.0380 2.0401 2.0410	CuZn39Pb2 CuZn39Pb3 CuZn43Pb2	-	Bakelit Resopal Pertinax Moltopren	3.5200 3.5612 3.5812 3.5812.05 3.5612.05 3.5662.01	MgMn2 MgAl6Zn MgAl8Zn GDMgAl8Zn1 GDMgAl6Zn1 GMgAl6	3.7025 3.7065	Ti Ti
spheroidal graphite iron and alleable cast iron		Brass, long-chipping		Thermoplastics				Titanium-alloys	
0.7040 (GGG40) 0.7060 (GGG60) 0.8035 0.8135	EN-GJS-400-15 EN-GJS-600-3 EN-GJMW-350-4 EN-GJMB-350-10	2.0250 2.0280 2.0332	CuZn20 CuZn33 CuZn37Pb0.5	-	Plexiglass Hostalen Novodur Makralon			3.7115 3.7165	TiAl 5Sn2 TiAl 6 V4
Compacted graphite iron				Glass/carbon re-inforced				Special-alloys	
-	EN-GJV250 EN-GJV350 EN-GJV400 EN-GJV500			-	Polypropylene glass fibre carbon fibre			2.4610 2.4876 2.4816 2.4668 2.4634	Hastelloy C4 Incoloy 800 Inconel 600 Inconel 718 Nimonic 105 CuNi12Zn24 CuNi18Zn20

bright steam tempered nitrided TiAlN TiCN TiN AlCrN MolyGlide