Technical Information

Hand tap sets

HSS-G



Suitable materials

HSS-G is intended for general use and readily machinable materials up to approximately 900 N/mm². These include unalloyed and low-alloy steels, structural steels, carbon steels, case-hardening steels, free-cutting steels, spheroidal graphite cast iron and malleable cast iron, as well as selected non-ferrous metals.

The following table lists example materials and represents only a selection of suitable materials.

Material number	Designation
Unalloyed steels	
1.0044	S275JR structural steel
1.0060	St 60-2 structural steel
1.0070	St 70-2 structural steel
1.0116	St 37-3 structural steel
1.0301	C 10 carbon steel
1.0402	C 22 carbon steel
1.0501	C 35 carbon steel
1.0511	C 40 carbon steel
1.0570	St 52-3 structural steel
Free-cutting, case-hardening and quenched and tempered steels	
1.0711	9S 20 free-cutting steel
1.0712	18S10 steel
1.0715	9SMn 28 free-cutting steel
1.0718	9SMnPb 28 free-cutting steel
1.0726	35S 20 free-cutting steel
1.0736	9SMn 36 free-cutting steel
1.0737	9SMnPb 36 free-cutting steel
1.1121	Ck 10 case-hardening steel
1.1141	Ck 15 case-hardening steel
1.1151	Ck 22 quenched and tempered steel
1.1158	Ck 25 quenched and tempered steel
1.1183	Cf 35 quenched and tempered steel
Unalloyed steels	
1.0503	C 45 quenched and tempered steel
1.1191	Ck 45 structural steel
1.1203	Ck 55 structural steel
1.1213	Cf 53 structural steel
1.1221	Ck 60 structural steel
Graphitic cast iron and malleable cast iron	
0.7040	GGG40 spheroidal graphite cast iron
0.7050	GGG50 spheroidal graphite cast iron

Material number	Designation
Graphitic cast iron and malleable cast iron	
0.7060	GGG60 spheroidal graphite cast iron
0.7070	GGG70 spheroidal graphite cast iron
0.8035	GTW35-04 malleable cast iron
0.8055	GTW-55 malleable cast iron
Short-chipping copper alloys	
2.0401	CuZn39Pb 3 (MS58) short-chipping brass
2.0410	CuZn44Pb 2 short-chipping brass
2.0580	CuZn40MnPb short-chipping brass
Long-chipping brass	
2.0250	CuZn 20 long-chipping brass
2.0265	CuZn 30 long-chipping brass
2.0321	CuZn 37 long-chipping brass
2.0335	CuZn 36 (MS63) long-chipping brass
Unalloyed aluminium and magnesium	
3.0250	AL 99.5 H unalloyed aluminium
3.0280	AL 99.8 H unalloyed aluminium
3.0305	AL 99.9 unalloyed aluminium
Aluminium alloys	
3.0515	ALMn 1 aluminium alloy, Si < 0.5%
3.0525	AlMn 1 Mg 05 aluminium alloy, Si < 0.5%
3.0615	AlMgSi-Pb aluminium alloy, Si < 0.5%
3.1325	AlCuMg 1 aluminium alloy, Si < 0.5%
3.1355	AlCuMg 2 aluminium alloy, Si < 0.5%
3.2134	G-AlSi 5 Cu 1 Mg aluminium alloy, Si 0.5-10%

Material number	Designation
Aluminium alloys	
3.2152	G-AlSi 6 Cu 4 aluminium alloy, Si 0.5-10%
3.2162	G-AlSi 8 Cu 3 aluminium alloy, Si 0.5-10%
3.2373	G-AlSi 9 Mg aluminium alloy, Si 0.5-10%