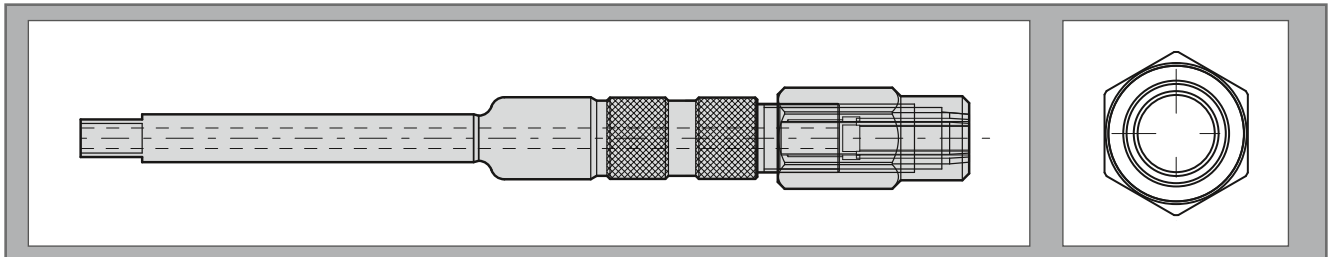


# GBV

## Gewindebohrer-Verlängerungen Tap extension

**Anwendung: Gewindeschneiden**  
**Maschinentyp: auf allen Arten von Maschinen**

**Application: tapping**  
**Machine type: on all types of machines**

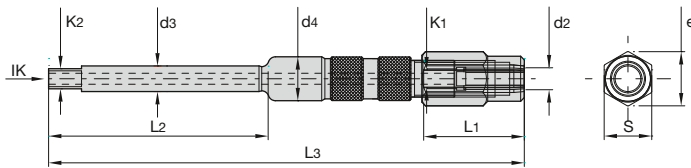


Gewindebohrer mit verlängertem Schaft werden zum Gewindeschneiden in Werkstücke mit tief liegenden Innengewinden oder zum Gewindeschneiden unmittelbar an Gusswänden, Absätzen, Störkanten von Vorrichtungen usw. benötigt. Um dies zu vermeiden setzt man Gewindebohrer verlängerungen ein.

For tapping operations in work pieces with extremely deep internal threads or for tapping close to cast iron walls, interference edges or shoulders of fixtures there is the need of taps with an extended shank. To avoid special taps extensions are useful.

Merkmale:	Vorteile:	Nutzen:
<ul style="list-style-type: none"> <li>• Schafttoleranz h6</li> </ul>	<ul style="list-style-type: none"> <li>• Höhere Rundlaufgenauigkeit</li> <li>• Der Schaft kann in Schrumpffutter oder Hydrodehnspannfuttern gespannt werden</li> </ul>	<ul style="list-style-type: none"> <li>• Erhöhte Standzeit</li> <li>• Höhere Rundlaufgenauigkeit</li> </ul>
<ul style="list-style-type: none"> <li>• Innere Kühlmitteldurchführung bis 50 bar</li> </ul>	<ul style="list-style-type: none"> <li>• Bessere Späneabfuhr</li> <li>• Spülen der Grundlochbohrung</li> </ul>	<ul style="list-style-type: none"> <li>• Längere Standzeit des Gewindebohrers</li> <li>• Keine extra Reinigung notwendig</li> </ul>
<ul style="list-style-type: none"> <li>• Schlanke Bauform</li> </ul>	<ul style="list-style-type: none"> <li>• Engere Abstände zur Störkontur möglich</li> </ul>	<ul style="list-style-type: none"> <li>• Keine Sondergewindebohrer erforderlich.</li> <li>• Kostenersparnis. Einmalige Anschaffung</li> </ul>
<ul style="list-style-type: none"> <li>• Schaft mit Vierkant</li> </ul>	<ul style="list-style-type: none"> <li>• Verlängerungen können wie Gewindebohrer in Schnellwechsel-Einsätzen gespannt werden</li> <li>• Problemlose Kraftübertragung</li> </ul>	<ul style="list-style-type: none"> <li>• Reduzierte Stillstandszeit der Maschine beim Werkzeugwechsel</li> <li>• Kein Durchdrehen des Gewindebohrers</li> </ul>
<ul style="list-style-type: none"> <li>• Spannmutter mit Aussensechskant</li> </ul>	<ul style="list-style-type: none"> <li>• Sicheres Spannen des Gewindebohrers</li> </ul>	<ul style="list-style-type: none"> <li>• Erhöhte Prozesssicherheit</li> </ul>
Features:	Advantages:	Benefits:
<ul style="list-style-type: none"> <li>• Shank tolerance h6</li> </ul>	<ul style="list-style-type: none"> <li>• Better run out accuracy</li> <li>• Shank can be clamped in shrinking chucks or hydraulic chucks.</li> </ul>	<ul style="list-style-type: none"> <li>• Longer tool life</li> <li>• Better run out accuracy</li> </ul>
<ul style="list-style-type: none"> <li>• Coolant pressure max. 50ba</li> </ul>	<ul style="list-style-type: none"> <li>• Better chip removal</li> <li>• Rinsing of the base hole</li> </ul>	<ul style="list-style-type: none"> <li>• Extended tool life of the tap</li> <li>• No additional cleaning required</li> </ul>
<ul style="list-style-type: none"> <li>• Slim design</li> </ul>	<ul style="list-style-type: none"> <li>• Closer distances to the interfering contour possible</li> </ul>	<ul style="list-style-type: none"> <li>• No special taps required. Cost saving.</li> <li>• One off purchase.</li> </ul>
<ul style="list-style-type: none"> <li>• Shank with square</li> </ul>	<ul style="list-style-type: none"> <li>• Extensions can be fixed such as taps in quick-change inserts</li> <li>• Easy power transmission</li> </ul>	<ul style="list-style-type: none"> <li>• Reduced down time of the machine during tool change.</li> <li>• No twisting of the tap</li> </ul>
<ul style="list-style-type: none"> <li>• Clamping nut with hexagon</li> </ul>	<ul style="list-style-type: none"> <li>• Safe clamping of the tap.</li> </ul>	<ul style="list-style-type: none"> <li>• Increased process safety</li> </ul>

**GBV – Gewindebohrer-Verlängerungen**  
**GBV – Tap extension**

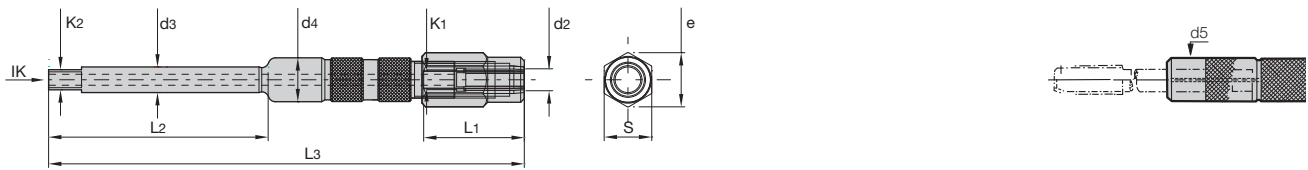


Bezeichnung Designation	DIN 371	DIN 374 376	Ø d2	□ K1	L1	Ø d3	□ K2	Ø d4	e	S	L2	L3	Id. No.
GBV2x35x27x130	M3	M4,5/M 5	3,5	2,7	24,0	6	4,9	7,5	9,0	8	60	130	5063404
GBV2x35x27x230 *			3,5	2,7	24,0	6	4,9	7,5	9,0	8	60	230	5063406*
GBV3x45x34x130	M4	M6	4,5	3,4	24,0	6	4,9	8,4	10,2	9	60	130	5063407
GBV3x45x34x230 *			4,5	3,4	24,0	6	4,9	8,4	10,2	9	60	230	5063408*
GBV4x60x49x130	M4,5/M 6	M8	6,0	4,9	27,5	7	5,5	12,0	14,8	13	60	130	5062047
GBV4x60x49x230			6,0	4,9	27,5	7	5,5	12,0	14,8	13	60	230	5062048
GBV4x60x49-80x62x130	M4,5/M 6	M8	6,0	4,9	27,5	8	6,2	12,0	14,8	13	60	130	5062049
GBV4x60x49-80x62x230			6,0	4,9	27,5	8	6,2	12,0	14,8	13	60	230	5062050
GBV5x70x55x130	M7	M9/M 10	7,0	5,5	27,5	7	5,5	12,0	14,8	13	60	130	5062051
GBV5x70x55x230			7,0	5,5	27,5	7	5,5	12,0	14,8	13	60	230	5062052
GBV5x70x55-80x62x130	M7	M9/M 10	7,0	5,5	27,5	8	6,2	12,0	14,8	13	60	130	5062053
GBV5x70x55-80x62x230			7,0	5,5	27,5	8	6,2	12,0	14,8	13	60	230	5062054
GBV6x80x62x130	M8	M11	8,0	6,2	30,0	8	6,2	13,0	15,6	14	60	130	5062055
GBV6x80x62x230			8,0	6,2	30,0	8	6,2	13,0	15,6	14	80	230	5062056
GBV7x90x70x130	M9	M12	9,0	7,0	31,0	9	7,0	15,0	17,9	16	60	130	5062057
GBV7x90x70x230			9,0	7,0	31,0	9	7,0	15,0	17,9	16	80	230	5062058
GBV7x90x70-100x80x130	M9	M12	9,0	7,0	31,0	10	8,0	15,0	17,9	16	60	130	5062059
GBV7x90x70-100x80x230			9,0	7,0	31,0	10	8,0	15,0	17,9	16	80	230	5062060
GBV8x100x80x130	M10		10,0	8,0	33,0	10	8,0	15,0	17,9	16	60	130	5062061
GBV8x100x80x230			10,0	8,0	33,0	10	8,0	15,0	17,9	16	80	230	5062062
GBV9x110x90x130		M14	11,0	9,0	36,0	11	9,0	18,0	21,4	19	90	130	5062063
GBV9x110x90x230			11,0	9,0	36,0	11	9,0	18,0	21,4	19	90	230	5062064
GBV9x110x90-120x90x130		M14	11,0	9,0	36,0	12	9,0	18,0	21,4	19	90	130	5062065
GBV9x110x90-120x90x230			11,0	9,0	36,0	12	9,0	18,0	21,4	19	90	230	5062066
GBV10x120x90x130		M16	12,0	9,0	36,0	12	9,0	19,0	21,4	19	90	130	5062067
GBV10x120x90x230			12,0	9,0	36,0	12	9,0	19,0	21,4	19	90	230	5062068
GBV11x140x110x200		M18	14,0	11,0	46,0	14	11,0	22,0	26,0	23	100	200	5062069
GBV11x140x110x330			14,0	11,0	46,0	14	11,0	22,0	26,0	23	100	330	5062070
GBV12x160x120x200		M20	16,0	12,0	46,0	16	12,0	22,0	26,0	23	100	200	5062072
GBV12x160x120x330			16,0	12,0	46,0	16	12,0	22,0	26,0	23	100	330	5062073
GBV13x180x145x200		M22/M 24	18,0	14,5	47,0	18	14,5	26,0	30,5	27	100	200	5062074
GBV13x180x145x330			18,0	14,5	47,0	18	14,5	26,0	30,5	27	100	330	5062075
GBV14x200x160x200		M27	20	16,0	52,0	20	16,0	28,0	33,5	30	100	200	5062076
GBV14x200x160x330			20	16,0	52,0	20	16,0	28,0	33,5	30	100	330	5062077
GBV15x220x180x200		M30	22	18,0	55,0	22	18,0	30,0	40,5	36	100	200	5062078
GBV15x220x180x330			22	18,0	55,0	22	18,0	30,0	40,5	36	100	330	5062079
GBV16x250x200x200		M33	25	20,0	56,0	25	20,0	35,0	40,5	36	100	200	5062080
GBV16x250x200x330			25	20,0	56,0	25	20,0	35,0	40,5	36	100	330	5062081
GBV17x280x220x200		M36	28	22,0	58,0	28	22,0	40,0	52,0	46	100	200	5062082
GBV17x280x220x330			28	22,0	58,0	28	22,0	40,0	52,0	46	100	330	5062083
GBV18x320x240x200		M39/M 42	32	24,0	60,0	32	24,0	44,0	52,0	46	100	200	5062084
GBV18x320x240x330			32	24,0	60,0	32	24,0	44,0	52,0	46	100	330	5062085

\* Ohne innere Kühlmitteldurchführung  
 \* With out internal coolant supply

Rändelmutter auf Anfrage  
 Knurled nut on request

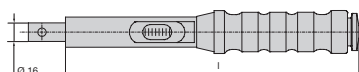
**GBV – Zubehör**  
**GBV – Accessories**



Bezeichnung Designation	S/Mutter S/Nut	e mm	Skt.-Mutter/Id. Nr. Hex.-Nut/Id. Nr.	Nm	Bez./Id. Nr. Des/Id. Nr.	TORCO-FIX Aufsteckschlüssel Fitting key	Rändelmutter Knurled nut	Ø d5 mm
GBV 2	8	9,0	GBVM2-SKT	3	16Z-SW8		GBVM2-RD	7,5
			5088694		5091123		5070238	
GBV 3	9	10,2	GBVM3-SKT	5	16Z-SW9		GBVM3-RD	8,4
			5088695		5091125		5070239	
GBV 4	13	14,8	GBVM4-SKT	6	16Z-SW13		GBVM4-RD	12,1
			5088696		5091126		5070240	
GBV 5	13	14,8	GBVM5-SKT	7	16Z-SW13		GBVM5-RD	12,1
			5088697		5091126		5070241	
GBV 6	14	15,6	GBVM6-SKT	9	16Z-SW14		GBVM6-RD	13,0
			5088698		5091129		5070242	
GBV 7	16	17,9	GBVM7-SKT	12	16Z-SW16		GBVM7-RD	15,0
			5088699		5091134		5070243	
GBV 8	16	17,9	GBVM8-SKT	14	16Z-SW16		GBVM7/8-RD	15,0
			5088700		5091134		5070244	
GBV 9	19	21,4	GBVM9-SKT	16	16Z-SW19		GBVM9-RD	18,0
			5088701		5091137		5070245	
GBV 10	19	21,4	GBVM10-SKT	18	16Z-SW19		GBVM10-RD	18,0
			5088702		5091137		5070246	
GBV 11	23	26,0	GBVM11-SKT	20	16Z-SW23	GBVM11-RD	22,0	
			5088703		5056896	5070247		
GBV 12	23	26,0	GBVM12-SKT	22	16Z-SW23	GBVM12-RD	22,0	
			5088704		5056896	5070248		
GBV 13	27	30,5	GBVM13-SKT	30	16Z-SW27	GBVM13-RD	26,0	
			5093668		5091140	5091146		
GBV 14	30	33,5	GBVM14-SKT	35	16Z-SW30	GBVM14-RD	28,0	
			5093669		5056897	5091147		
GBV 15	36	40,5	GBVM15-SKT	40	16Z-SW36	GBVM15-RD	30,0	
			5093670		5091143	5091148		
GBV 16	36	40,5	GBVM16-SKT	45	16Z-SW36	GBVM16-RD	35,0	
			5093671		5091143	5091149		
GBV 17	46	52,0	GBVM17-SKT	50		GBVM17-RD	40,0	
			5093672			5091150		
GBV 18	46	52,0	GBVM18-SKT	50		GBVM18-RD	44,0	
			5093673			5091151		

Hinweis: Rändelmutter auf Anfrage, wenn Aussendurchmesser der SKT-Mutter zu groß ist!  
 Please note: Knurled nut on request, in case if the diameter of the SKT nut is to big!

**Drehmomentschlüssel TORCO-FIX**  
**Torque wrench TORCO-FIX**



Bezeichnung Designation	Id.No.	I 1	Drehmoment Nm Torque Nm
TORCO-FIX 0	5093674	290	2 – 25
TORCO-FIX I	6734177	335	5 – 50