

A technical line drawing of two tool holders. The holder on the left is a long, tapered, multi-faceted sleeve with a central longitudinal slot containing a stylized mountain range and a gear icon. The holder on the right is a shorter, more complex assembly with a central circular opening and several small protrusions around its circumference. Both are shown in a perspective view, crossing each other.

USER MANUAL
GSR SILVER TOOL HOLDERS

062020

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1. Preface

Dear customer,

You have purchased a high-quality tool from our company.
Congratulations!

In order to take much pleasure in your new product for a long time, you should carefully follow the instructions in this manual. Please check the proper condition of the product before use and inform us immediately of any damage.

If any functional errors or other defects occur,
please contact us via e-mail:

info@gsr-germany.de

Enjoy your new GSR quality product!

Your GSR Team

2. Technical Data

Specifications of the die holders:

Size	Total length	For round dies	
16x5	160	M 1-2,6	MF 1-2,6
20x5	175	M 3-4	MF 3-6
20x7	175	M 4,5-6	MF 5-6
25x9	210	M 7-9	MF 7-9
30x11	260	M 10-11	MF 10-11
38x10	310		MF 12-15
38x14	310	M12-14	

For round dies

W 1/6"-3/32"		NC Nr. 1-4	NF Nr.0-4
W 1/8"-5/32"		NC Nr. 5	NF Nr.5-6
W 3/16"-1/4"		NC Nr. 6-1/4"	NF Nr.8-1/4"
W 5/16"		NC 5/16"	NF 5/16"
W 3/8"-7/16"	G 1/8"	NC 3/8"-7/16"	NF 3/8"-7/16"
	G 1/4"		NF 1/2"-9/16"
W 1/2"-9/16"		NC 1/2"-9/16"	

Size	Total length	For round dies
45x14	440	MF 16-20
45x18	440	M 16-20
55x16	495	MF 21-26
55x22	495	M 22-24
65x18	630	MF 27-36
65x25	630	M 27-36

For round dies		
	G 3/8"-1/2"	NF 5/8"-3/4"
W 5/8"-13/16"		NC 5/8"-3/4"
	G 5/8"-3/4"	NF 7/8"-1"
W 7/8"-1"		NC 7/8"-1"
	G 7/8"-1"	NF 1.1/8"-1.3/8"
W 1.1/8"-1.3/8"		NC 1.1/8"-1.3/8"

Specifications of the adjustable tap wrenches:

Size	Total length	◇-range	For DIN 371	For DIN 376
No. 0	125	2-5mm	M 2-6	M 4-8
No. 1	175	2-6,3 mm	M 3-8	M 4-10
No. 1.1/2	175	2-8 mm	M 3-10	M 4-12
No. 2	265	3-9 mm		M 6-16
No. 3	370	4,9-12 mm		M 8-20
No. 4	480	5,5-16 mm		M 10-27
No. 5	700	7-20 mm		M 12-33
No. 6	1000	9-24 mm		M 16-42

A more detailed table can be found under:

<https://gsr-germany.de/en/downloads/>

	For hand taps		Reamers
M 1-8	W 1/16"-5/16"		2,5-6,5
M 1-10	W 1/16"-3/8"	G 1/8"	2,5-7,5
M 1-12	W 1/16"-1/2"	G 1/8"	2,5-9,5
M 4-12	W 5/32"-1/2"	G 1/8"	5-10
M 5-20	W 7/32"-3/4"	G 1/8"-1/2"	6,5-15
M 9-27	W 7/16"-1"	G 1/4"-3/4"	7-20
M 12-33	W 1/2"-1.1/4"	G 1/4"-1"	9-26
M 16-42	W 3/4"-1.1/2"	G 1/2"-1.1/4"	11-32

3. Intended Use

This product is a holding tool for threading tools. Use the product only as described and for the specified applications.

We assume no liability for damage due to improper use.

4. Safety Instructions

Read these safety instructions before using your tool for the first time and act accordingly. Keep this user manual in a safe place for later use or for the subsequent owner.

Read the safety instructions before using the tool for the first time!

Non-observance of the user manual and the safety instructions may cause damage to the device and danger to the operator and other persons.

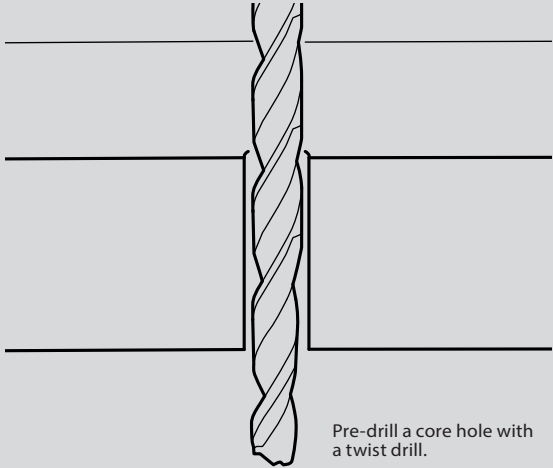


GENERAL SAFETY ADVICE

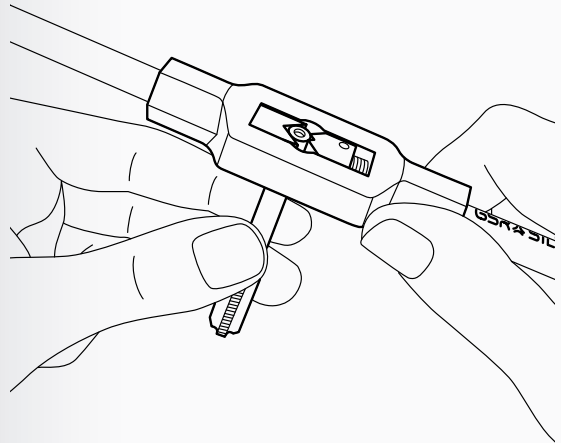
- Please always wear protective goggles and working gloves
- Check the tools before use for damage or wear and tear
- Only use the tools in accordance with their intended use and not for other purposes
- Always use cutting paste or another appropriate lubricant
- Always clamp tools and workpieces firmly and securely
- Clean the tools after use and remove the chips with suitable tools, but never with bare hands!
- Pay close attention to the definite determination of the thread type and thread size
- Do not recut a thread if you do not have any reliable information about the type and size of the thread
- Please select the correct core hole dimensions and bolt diameter according to the table
- Follow the instructions in this manual carefully



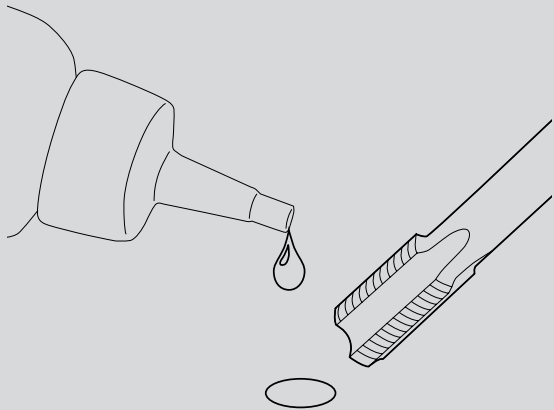
5. Tutorial: Internal Thread Cutting



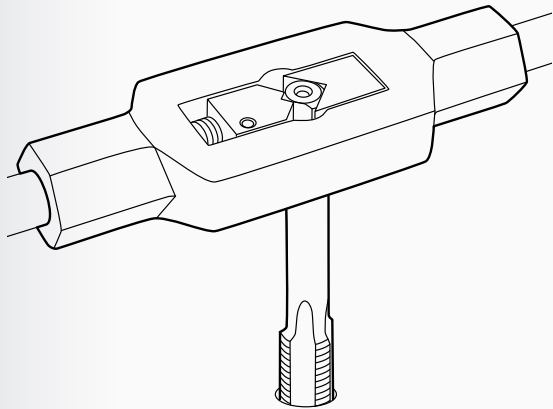
Clamp the tap in the adjustable tap wrench.



Apply sufficient cutting paste
and chamfer the thread.

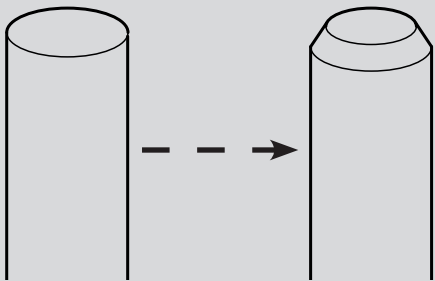


Finish cutting the thread.

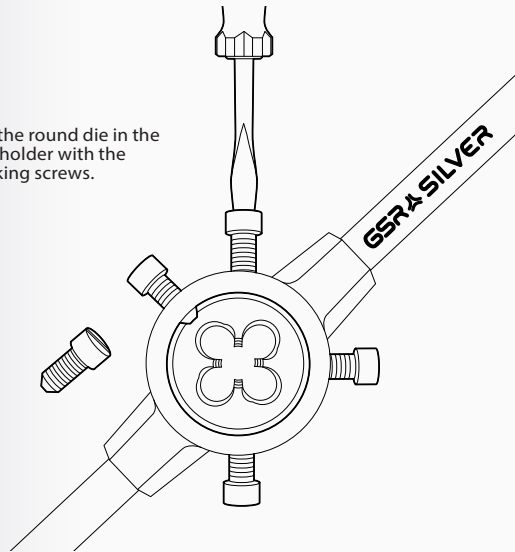


6. Tutorial: External Thread Cutting

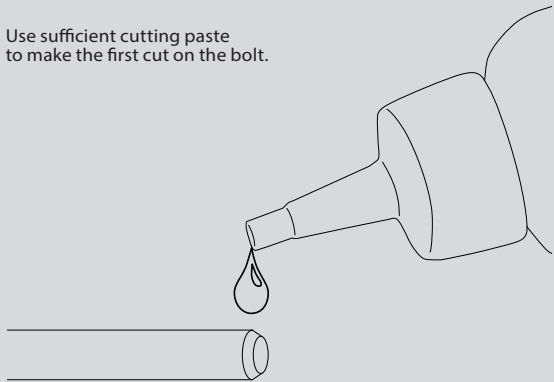
Chamfer the bolt.



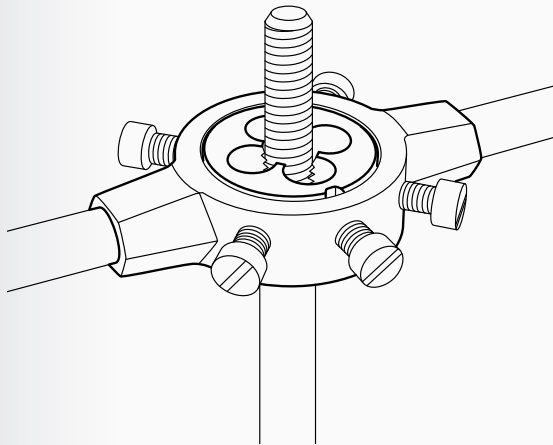
Fix the round die in the die holder with the locking screws.



Use sufficient cutting paste
to make the first cut on the bolt.



Finish cutting the
external thread.



7. Cleaning & Maintenance

Please clean the tool carefully after use and slightly oil the handles!

Please note: sharp-edged chips can be produced during thread cutting.

You should never remove these with your bare hands!

8. Disposal

The packaging is made of environmentally friendly material and can be disposed of via the local recycling centres. The product and packaging materials are recyclable as well.

If the product has reached the end of its useful life, do not simply throw it in the household waste. The individual parts can be properly disposed of and recycled. The components have been selected so that they can be easily recycled.

9. Warranty

For our GSR silver holding tools we offer a warranty according to the legal regulations from the date of purchase (proof is provided by invoice or delivery note). Arising damages will be repaired or replaced. Damages, which are due to improper handling, are excluded from the warranty. Complaints can only be accepted if the device is returned undismantled to our headquarters in Remscheid, Germany. Subject to technical changes. We accept no liability for printing errors.



10. Service

If you have any questions about our product or want to make a complaint, you are welcome to contact us:

Either by e-mail at **info@gsr-germany.de**
or via WhatsApp under the number **+49 163 4189 616**.

We are here for you!

You can find more information about thread cutting on our blog:

<https://threadingtoolsguide.com/>

Suggestions for improving our products and photos of the application of our tools are always welcome.
Please do not hesitate to contact us!

GSR silver products one step ahead
high-performance
Versatile
practical
powerful
solid
reliable
quality
sustainable
robust
innovative
efficient
modern
exclusive
worry-free package
resource-efficient
high-quality sturdy certified
the new generation of tool holders
Can take more!
individual ecological must-have
reliable adaptive
When visions become reality
Zamak 5
100% Fe/Ni
made by GSR



Precision is in the details.
Since 1889.

GSR Gustav Stursberg GmbH

Schmiedestraße 4
42899 Remscheid | Germany

Fon +49 (0) 21 91 - 58 33
Fax +49 (0) 21 91 - 52 769
Mail info@gsr-germany.de
Web www.gsr-germany.de/en/

<https://threadingtoolsguide.com/>

TRADITION MEETS INNOVATION