



Finally, the answer you've been looking for is here

A-TAP SERIES

Volume 8



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Blind Hole

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Finally, the answer you've been looking for is here...

1 Stabilize chip shape
Sharp cutting edge

2 Accelerate chip evacuation
Variable lead flute (PAT.)

3 High wear resistance
V coating

4 High wear resistance
Powder Metallurgy HSS (CPM)



OSG'S NEW PREMIUM BRAND "A-TAP SERIES"

The answer for your troubles lies here

Most of tapping troubles are caused by unstable chip evacuation.

A-TAP Series resolve such troubles and apply to a wide range of work materials and cutting speed.

Tapping Troubles

N°1 breakage and chipping	26 %
N°2 dimensional error	17 %
N°3 galling	14 %
Others	43 %

Main factor is chip packing

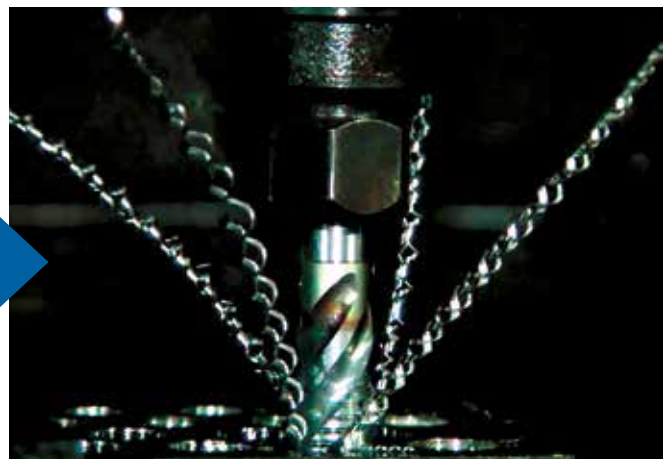


The biggest advantage of A-TAP Series:

THE BEST CHIP EVACUATION



Conventional Tap



A-SFT

KEY FEATURES A-TAP SERIES

Applies to a wide variety of work materials

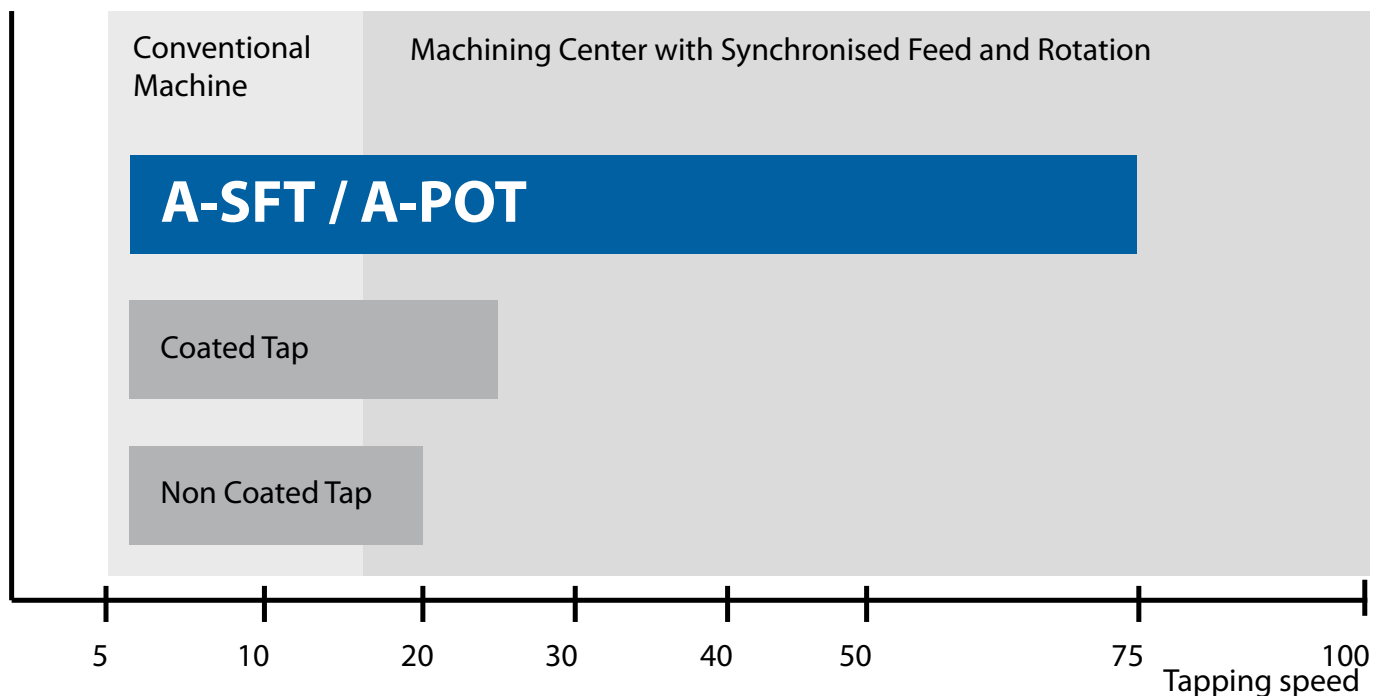
Even to mild steel and stainless steel



High performance in machining center

Applies to a wide cutting range

Long



- It is a image of tapping in medium and high carbon steel with water soluble coolant.
- Machining center with synchronized feed and rotation is recommended for more than 15m/min.
- As the best speed varies by tapping condition, please find it by trials.

SUS304

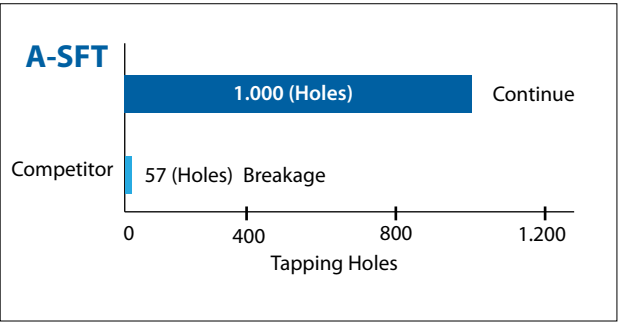
Deep Hole Tapping (2D) in stainless steel

High performance achieved in stainless steel with water soluble oil



■ Cutting edge after 1.000 holes tapping

Tool	A-SFT M8x1,25
Work Material	SUS304
Hole Size	Ø6,8x22mm (Blind)
Tapping Length	16mm (2D)
Tapping Speed	10m/min (398min ⁻¹)
Coolant	Water Soluble Chlorine-Free (10%)
Machine	Vertical Synchronized Machining Center

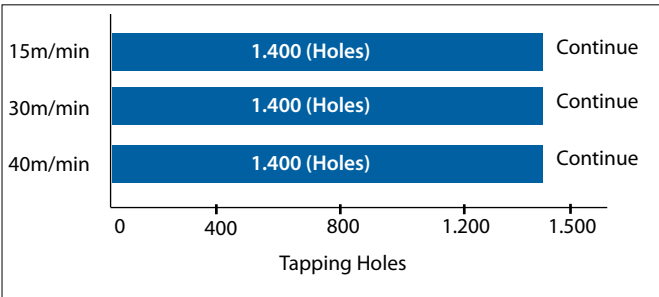


S45C

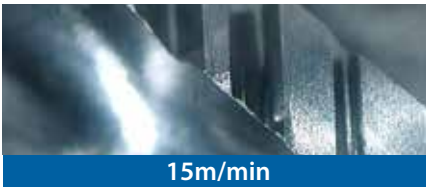
High speed tapping by machining center

Tapping operation in 15,30,40m/min are all stable

Tool	A-SFT M6x1
Work Material	S45C
Hole Size	Ø5x16mm (Blind)
Tapping Length	12mm (2D)
Coolant	Water Soluble Chlorine-Free (10%)
Machine	Vertical Synchronized Machining Center



■ Cutting edge after 1.400 holes Tapping



15m/min

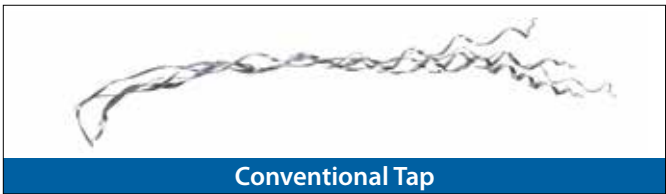


30m/min

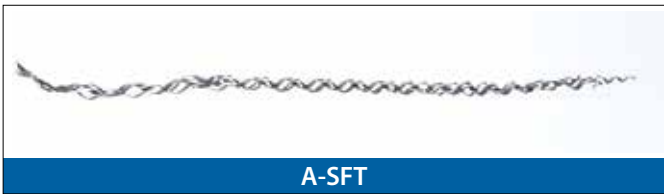


40m/min

■ Chip generated in 40m/min

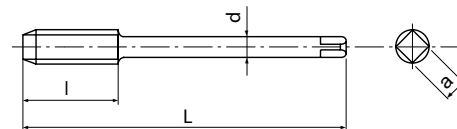
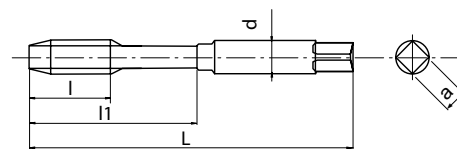


Conventional Tap



A-SFT

Threading | Cutting taps | Metric



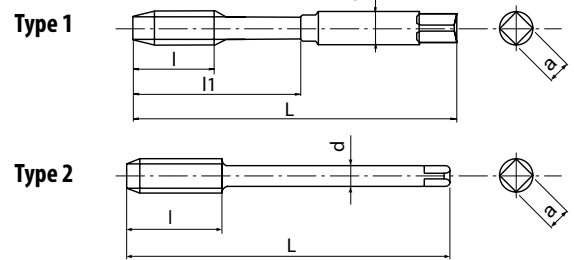
- | | | | | | | | | |
|--|--|--|--|--|--|--|--|--|
| P  | P  | P  | P  | M  | N  | N  | S  | H  |
| C < 0,2% | 0,25 < C < 0,4 | C > 0,45% | SCM | INOX | Al | AC,ADC | Ti | 25-35 HRC |
| 15-60 | 15-60 | 10-60 | 8-30 | 8-20 | 15-35 | 15-35 | 5-10 | 8-20 |
| m/min | | | | | | | | |



Metric

Threading | Cutting taps

Threading | Cutting taps | Metric



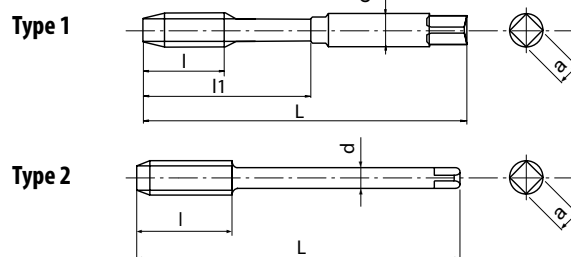
- ## Threading | Cutting taps

Metric

Threading | Cutting taps | Metric



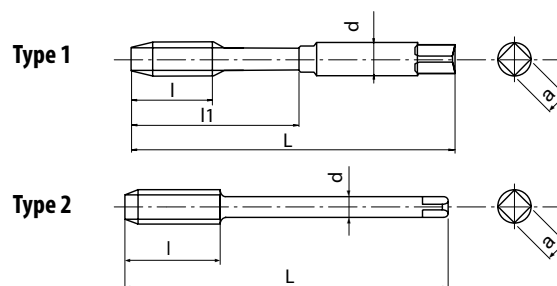
Threading | Cutting taps | Metric



- First choice in quality and performance
- Powder metal spiral-fluted cutting tap for blind holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels
- Form E chamfer

[illegible]

Threading | Cutting taps | Metric



- First choice in quality and performance
- Powder metal spiral-fluted cutting tap for blind holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels
- Oversized tap for 6H +0,1mm thread tolerance

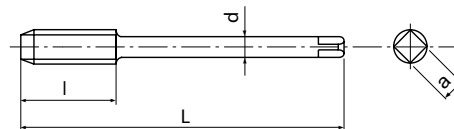
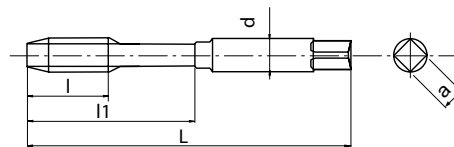
P 	P 	P 	P 	M 	N 	N 	S 	H 
C < 0,2%	0,25 < C < 0,4	C > 0.45%	SCM	INOX	Al	Al ₂ ADC	Ti	25-35 HRC
15-60	15-60	10-60	8-30	8-20	15-35	15-35	5-10	8-20
m/min								

Technical drawing symbols for material, surface, and thread specifications:

- A**: Material symbol (Red letter A)
- M**: Material symbol (Black letter M)
- PM**: Material symbol (Black letters PM)
- V**: Surface texture symbol (Black letter V)
- 45°**: Surface texture symbol (Black text 45°)
- 6H +0.1**: Surface texture symbol (Black text 6H +0.1)
- C/2,5**: Surface texture symbol (Black text C/2,5)
- DIN 371**: Thread symbol (Black text DIN 371)
- DIN 376**: Thread symbol (Black text DIN 376)

[illegible]

Threading | Cutting taps | Metric



- First choice in quality and performance
- Powder metal spiral-fluted cutting tap for blind holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels
- With long shank for long reach threading

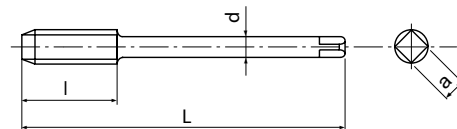
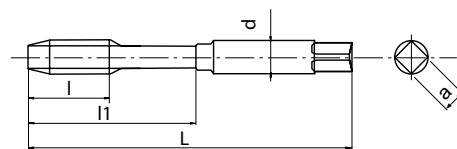
m/min



Threading | Cutting taps

Metric

Threading | Cutting taps | Metric



- P** 
C < 0,2%

15-60



15-60



10-60



8-30



8-20



15-35



15-35



5-10



8-20

m/min

m/min

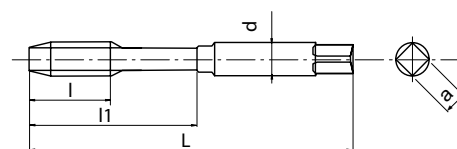


Threading | Cutting taps

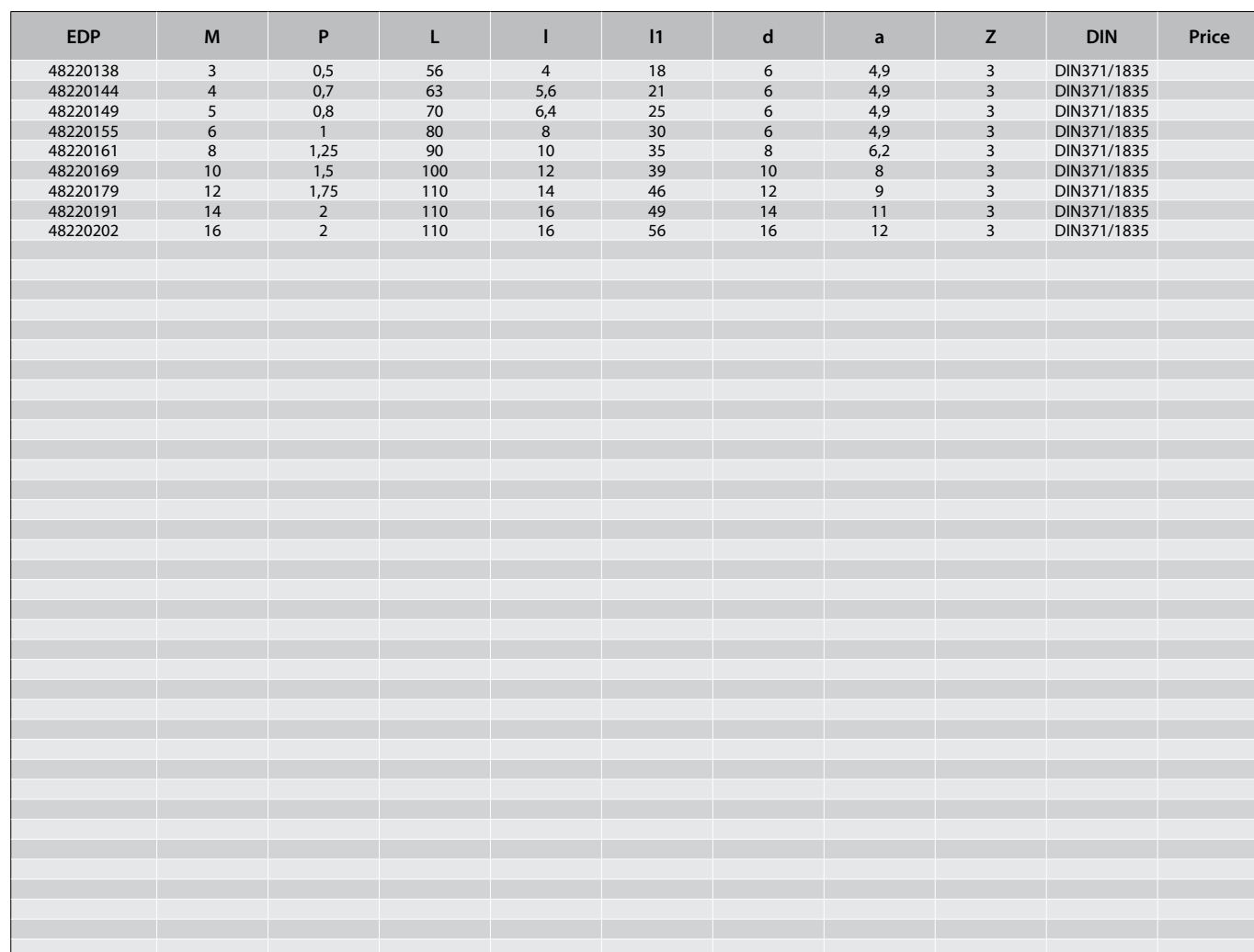


Metric

Threading | Cutting taps | Metric

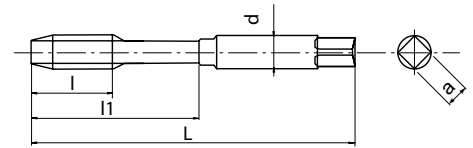


- ## Threading | Cutting taps

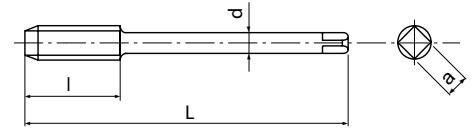




Type 1



Type 2



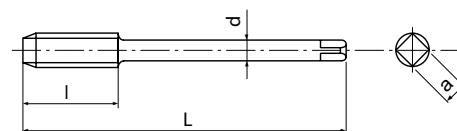
- First choice in quality and performance
- Powder metal spiral-fluted cutting tap for blind holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels

P	P	P	P	M	N	N	S	H	
C < 0,2%	0,25 < C < 0,4	C > 0,45%	SCM	INOX	Al	AC, ADC	Ti	25-35 HRC	
15-60	15-60	10-60	8-30	8-20	15-35	15-35	5-10	8-20	m/min

A	MF	PM	V	45°	ISO 2 6HX	C/2,5		DIN 371	DIN 374
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EDP	MF	P	L	I	l1	d	a	Z	Type	DIN	Price
48139135	2,5	0,35	50	3,6	13	2,8	2,1	2	1	DIN371	
48139137	2,6	0,35	50	3,6	13	2,8	2,1	2	1	DIN371	
48139141	3	0,35	56	4	18	3,5	2,7	3	1	DIN371	
48139143	3,5	0,35	56	4,8	20	4	3	3	1	DIN371	
48139145	4	0,5	63	5,6	21	4,5	3,4	3	1	DIN371	
48139146	4	0,35	63	5,6	21	4,5	3,4	3	1	DIN371	
48139148	4,5	0,5	70	6	25	6	4,9	3	1	DIN371	
48139151	5	0,5	70	6,4	25	6	4,9	3	1	DIN371	
48139601	6	0,75	80	8	30	6	4,9	3	1	DIN371	
48139602	6	0,5	80	8	30	6	4,9	3	1	DIN371	
48139160	7	0,75	80	8	30	7	5,5	3	1	DIN371	
48139603	8	1	90	10	35	8	6,2	3	1	DIN371	
48139604	8	0,75	80	10	35	8	6,2	3	1	DIN371	
48139605	9	1	90	10	35	9	7	3	1	DIN371	
48139606	10	1,25	100	12	39	10	8	3	1	DIN371	
48139607	10	1	90	12	35	10	8	3	1	DIN371	
48139608	10	0,75	90	12	35	10	8	3	1	DIN371	
48139156	6	0,75	80	8	-	4,5	3,4	3	2	DIN374	
48139157	6	0,5	80	8	-	4,5	3,4	3	2	DIN374	
48139162	8	1	90	10	-	6	4,9	3	2	DIN374	
48139163	8	0,75	80	8	-	6	4,9	3	2	DIN374	
48139167	9	1	90	10	-	7	5,5	3	2	DIN374	
48139170	10	1,25	100	12	-	7	5,5	3	2	DIN374	
48139171	10	1	90	10	-	7	5,5	3	2	DIN374	
48139172	10	0,75	90	10	-	7	5,5	3	2	DIN374	
48139176	11	1	90	12	-	8	6,2	3	2	DIN374	
48139180	12	1,5	100	14	-	9	7	3	2	DIN374	
48139181	12	1,25	100	12	-	9	7	3	2	DIN374	
48139182	12	1	100	12	-	9	7	3	2	DIN374	
48139192	14	1,5	100	16	-	11	9	3	2	DIN374	
48139193	14	1,25	100	16	-	11	9	3	2	DIN374	
48139194	14	1	100	16	-	11	9	3	2	DIN374	
48139203	16	1,5	100	16	-	12	9	3	2	DIN374	
48139204	16	1	100	16	-	12	9	3	2	DIN374	
48139216	18	1,5	110	16	-	14	11	4	2	DIN374	
48139218	18	1	110	16	-	14	11	4	2	DIN374	
48139220	20	2	140	25	-	16	12	4	2	DIN374	
48139230	20	1,5	125	16	-	16	12	4	2	DIN374	
48139232	20	1	125	16	-	16	12	4	2	DIN374	
48139239	22	2	140	25	-	18	14,5	4	2	DIN374	
48139240	22	1,5	125	16	-	18	14,5	4	2	DIN374	
48139241	22	1	125	16	-	18	14,5	4	2	DIN374	
48139249	24	2	140	30	-	18	14,5	4	2	DIN374	
48139250	24	1,5	140	16	-	18	14,5	4	2	DIN374	
48139251	24	1	140	16	-	18	14,5	4	2	DIN374	

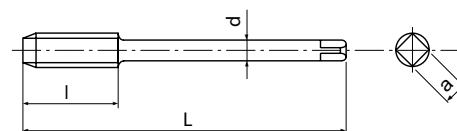
Threading | Cutting taps | Metric Fine



Centre through coolant

[illegible]

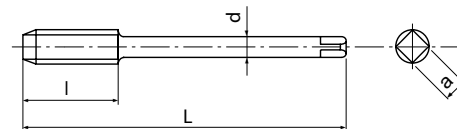
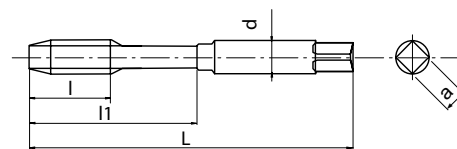
Threading | Cutting taps | Metric Fine



- | | | | | | | | | | |
|--|--|--|--|--|--|--|--|--|-------|
| P  | P  | P  | P  | M  | N  | N  | S  | H  | |
| C < 0,2% | 0,25 < C < 0,4 | C > 0,45% | SCM | INOX | Al | Al ₂ ADC | Ti | 25-35 HRC | |
| 15-60 | 15-60 | 10-60 | 8-30 | 8-20 | 15-35 | 15-35 | 5-10 | 8-20 | m/min |

[illegible]

Threading | Cutting taps | UNC



- First choice in quality and performance
- Powder metal spiral-fluted cutting tap for blind holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels

m/min

m/min



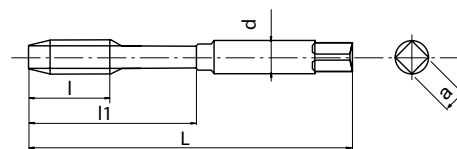
DIN 2184-1

[illegible]

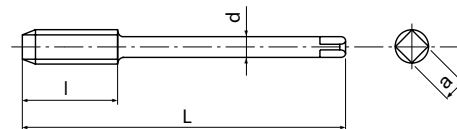
Threading | Cutting taps | UNF



Type 1



Type 2



- First choice in quality and performance
- Powder metal spiral-fluted cutting tap for blind holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels

P 	P 	P 	P 	M 	N 	N 	S 	H 	
C < 0,2%	0,25 < C < 0,4	C > 0,45%	SCM	INOX	Al	Al ₂ ADC	Ti	25-35 HRC	
15-60	15-60	10-60	8-30	8-20	15-35	15-35	5-10	8-20	m/min





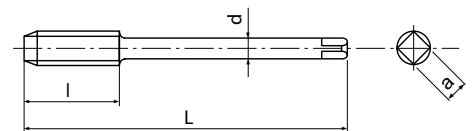






[illegible]

Threading | Cutting taps | G (BSP)

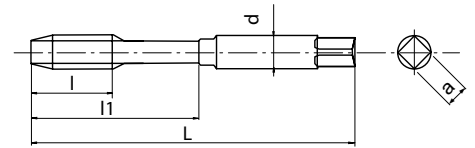


- ## Threading | Cutting taps



G (BSP)

Threading | Cutting taps | BSW



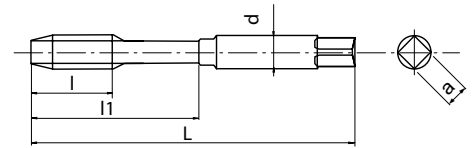
- First choice in quality and performance
- Powder metal spiral-fluted cutting tap for blind holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels

P 	P 	P 	P 	M 	N 	N 	S 	H 	
C < 0,2%	0,25 < C < 0,4	C > 0,45%	SCM	INOX	Al	ACADC	Ti	25-35 HRC	
15-60	15-60	10-60	8-30	8-20	15-35	15-35	5-10	8-20	m/min

	BSW	PM	 V	MED	 C/2,5		 DIN 2184
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[illegible]

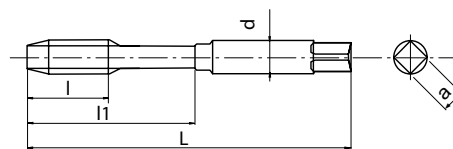
Threading | Cutting taps | BSF



- ## Threading | Cutting taps

BSF 

Threading | Cutting taps | BA

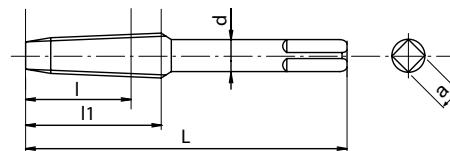


- First choice in quality and performance
- Powder metal spiral-fluted cutting tap for blind holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels

P 	P 	P 	P 	M 	N 	N 	S 	H 	
C <0,2%	0,25<C<0,4	C>0,45%	SCM	INOX	Al	Al ₂ ADC	Ti	25-35 HRC	
15-60	15-60	10-60	8-30	8-20	15-35	15-35	5-10	8-20	m/min

[illegible]

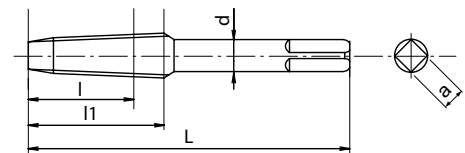
Threading | Cutting taps | RC (BSPT)



- First choice in quality and performance
- Powder metal straight flute cutting tap for through & blind holes
- Multilayer TiCN coating
- High speed tapping in general steels and aluminium
- RC (BSPT) tapered 1:16



Threading | Cutting taps | Rc (ISO)



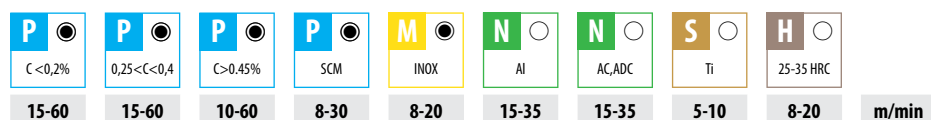
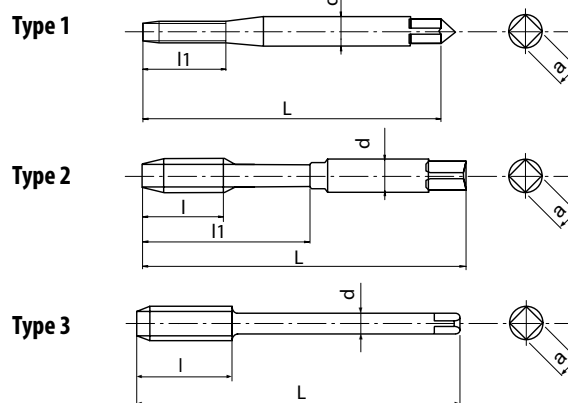
- | | | | | | | |
|--|--|--|--|--|--|-------|
| P  | P  | P  | P  | N  | N  | |
| C < 0,2% | 0,25 < C < 0,4 | C > 0,45% | SCM | AI | AC, ADC | |
| 5-10 | 5-10 | 5-10 | 5-10 | 5-10 | 10-15 | m/min |

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Threading | Cutting taps | Metric



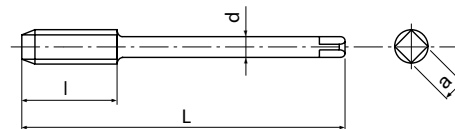
- First choice in quality and performance
- Powder metal spiral-point cutting tap for through holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels



* Tolerance 5HX

[illegible]

Threading | Cutting taps | Metric



- | | | | | | | | | |
|--|--|--|--|--|--|--|--|--|
| P  | P  | P  | P  | M  | N  | N  | S  | H  |
| C <0,2% | 0,25<C<0,4 | C>0.45% | SCM | INOX | Al | Al ₂ ADC | Ti | 25-35 HRC |
| 15-60 | 15-60 | 10-60 | 8-30 | 8-20 | 15-35 | 15-35 | 5-10 | 8-20 |
| m/min | | | | | | | | |

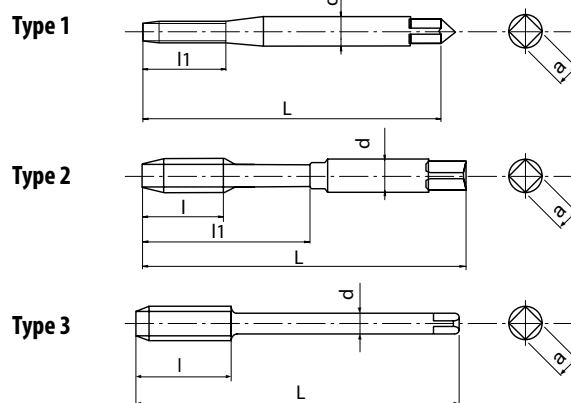


Threading | Cutting taps



Metric

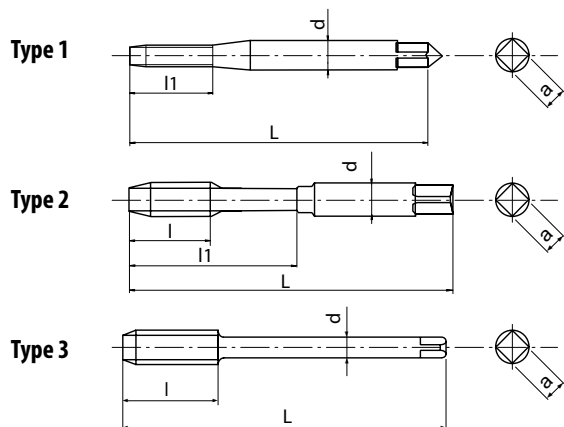
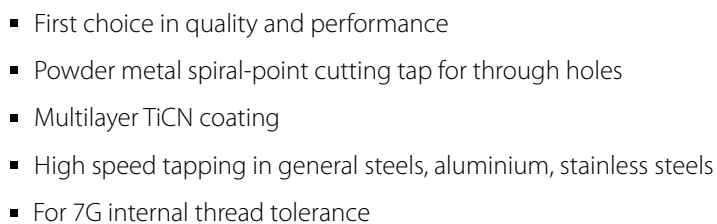
Threading | Cutting taps | Metric



- First choice in quality and performance
- Powder metal spiral-point cutting tap for through holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels
- For 6G internal thread tolerance

[illegible]

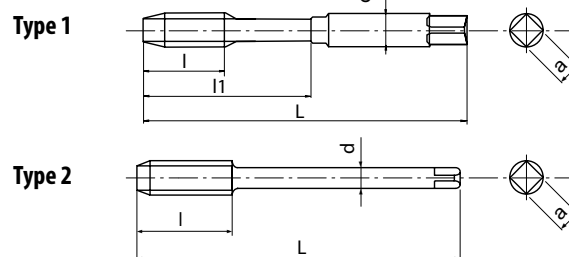
Threading | Cutting taps | Metric



- | | | | | | | | | |
|--|--|--|--|--|--|--|--|--|
| P  | P  | P  | P  | M  | N  | N  | S  | H  |
| C <0,2% | 0,25<C<0,4 | C>0.45% | SCM | INOX | Al | Al ₂ O ₃ | Ti | 25-35 HRC |
| 15-60 | 15-60 | 10-60 | 8-30 | 8-20 | 15-35 | 15-35 | 5-10 | 8-20 |
| m/min | | | | | | | | |

[illegible]

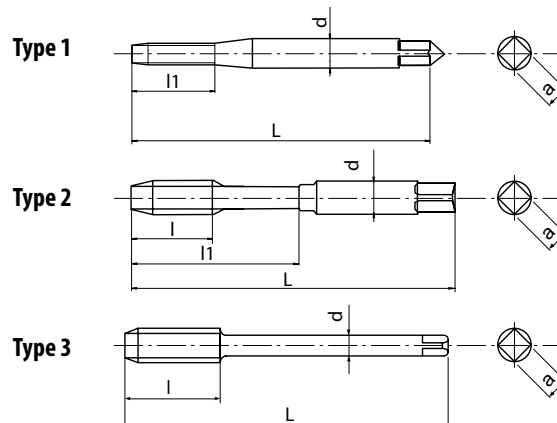
Threading | Cutting taps | Metric



- First choice in quality and performance
- Powder metal spiral-point cutting tap for through holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels
- Oversized tap for 6H +0,1mm thread tolerance

[illegible]

Threading | Cutting taps | Metric

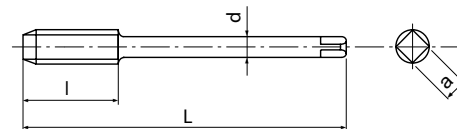


- First choice in quality and performance
- Powder metal spiral-point cutting tap for through holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels
- With long shank for long reach threading

	M	PM		ISO 2 6HX			
			V		B/4	DIN 371	DIN 376

[illegible]

Threading | Cutting taps | Metric



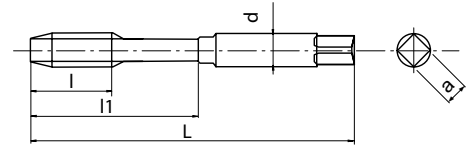
- | | | | | | | | | | |
|--|--|---|---|--|--|--|--|---|--------------|
| P 
C < 0,2% | P 
0,25 < C < 0,4 | P 
C > 0,45% | P 
SCM | M 
INOX | N 
Al | N 
AC,ADC | S 
Ti | H 
25-35 HRC | |
| 15-60 | 15-60 | 10-60 | 8-30 | 8-20 | 15-35 | 15-35 | 5-10 | 8-20 | m/min |



Threading | Cutting taps

Metric

Threading | Cutting taps | Metric



- First choice in quality and performance
- Powder metal spiral-point cutting tap for through holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels
- With Weldon shank

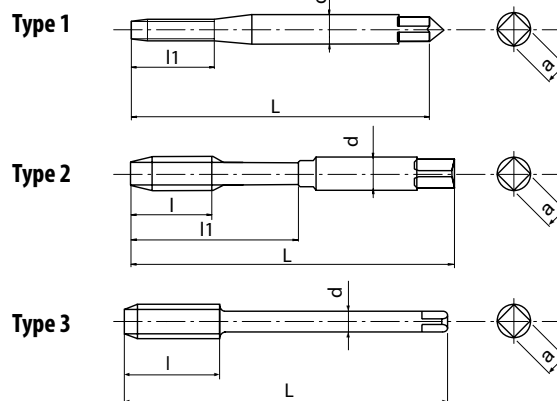
P C <0,2%	P 0,25<C<0,4	P C>0.45%	P SCM	M INOX	N Al	N AC_ADC	S Ti	H 25-35 HRC	
15-60	15-60	10-60	8-30	8-20	15-35	15-35	5-10	8-20	m/min

	M	PM	 V	ISO 2 6HX	 B/4	 DIN 371	 DIN 376	DIN 1835	HB
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[illegible]



- First choice in quality and performance
- Powder metal spiral-point cutting tap for through holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels

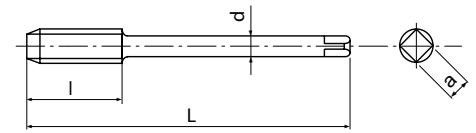


P	P	P	P	M	N	N	S	H	
C < 0,2%	0,25 < C < 0,4	C > 0,45%	SCM	INOX	Al	AC, ADC	Ti	25-35 HRC	
15-60	15-60	10-60	8-30	8-20	15-35	15-35	5-10	8-20	m/min

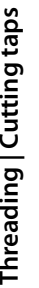
A	MF	PM	V	ISO 2 6HX	B/4	DIN 371	DIN 374
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EDP	MF	P	L	I	I1	d	a	Z	Type	DIN	Price
48145135	2,5	0,35	50	-	9	2,8	2,1	2	1	DIN371	
48145137	2,6	0,35	50	-	9	2,8	2,1	2	1	DIN371	
48145141	3	0,35	56	8	18	3,5	2,7	3	2	DIN371	
48145143	3,5	0,35	56	9	20	4	3	3	2	DIN371	
48145145	4	0,5	63	10	21	4,5	3,4	3	2	DIN371	
48145146	4	0,35	63	10	21	4,5	3,4	3	2	DIN371	
48145148	4,5	0,5	70	12	25	6	4,9	3	2	DIN371	
48145151	5	0,5	70	12	25	6	4,9	3	2	DIN371	
48145601	6	0,75	80	14	30	6	4,9	3	2	DIN371	
48145602	6	0,5	80	14	30	6	4,9	3	2	DIN371	
48145160	7	0,75	80	14	30	7	5,5	3	2	DIN371	
48145603	8	1	90	22	35	8	6,2	3	2	DIN371	
48145604	8	0,75	80	18	30	8	6,2	3	2	DIN371	
48145605	9	1	90	22	35	9	7	3	2	DIN371	
48145606	10	1,25	100	24	39	10	8	3	2	DIN371	
48145607	10	1	90	20	35	10	8	3	2	DIN371	
48145608	10	0,75	90	20	35	10	8	3	2	DIN371	
48145156	6	0,75	80	14	-	4,5	3,4	3	3	DIN374	
48145157	6	0,5	80	14	-	4,5	3,4	3	3	DIN374	
48145162	8	1	90	22	-	6	4,9	3	3	DIN374	
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48145167	9	1	90	22	-	7	5,5	3	3	DIN374	
48145170	10	1,25	100	24	-	7	5,5	3	3	DIN374	
48145171	10	1	90	20	-	7	5,5	3	3	DIN374	
48145172	10	0,75	90	20	-	7	5,5	3	3	DIN374	
48145176	11	1	90	20	-	8	6,2	3	3	DIN374	
48145180	12	1,5	100	22	-	9	7	3	3	DIN374	
48145181	12	1,25	100	22	-	9	7	3	3	DIN374	
48145182	12	1	100	22	-	9	7	3	3	DIN374	
48145192	14	1,5	100	22	-	11	9	4	3	DIN374	
48145193	14	1,25	100	22	-	11	9	4	3	DIN374	
48145194	14	1	100	22	-	11	9	4	3	DIN374	
48145203	16	1,5	100	22	-	12	9	4	3	DIN374	
48145204	16	1	100	22	-	12	9	4	3	DIN374	
48145216	18	1,5	110	25	-	14	11	4	3	DIN374	
48145218	18	1	110	25	-	14	11	4	3	DIN374	
48145220	20	2	140	34	-	16	12	4	3	DIN374	
48145230	20	1,5	125	25	-	16	12	4	3	DIN374	
48145232	20	1	125	25	-	16	12	4	3	DIN374	
48145239	22	2	140	34	-	18	14,5	4	3	DIN374	
48145240	22	1,5	125	25	-	18	14,5	4	3	DIN374	
48145241	22	1	125	25	-	18	14,5	4	3	DIN374	
48145249	24	2	140	28	-	18	14,5	4	3	DIN374	
48145250	24	1,5	140	28	-	18	14,5	4	3	DIN374	
48145251	24	1	140	28	-	18	14,5	4	3	DIN374	

Threading | Cutting taps | Metric Fine

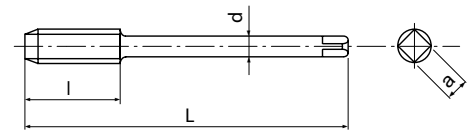


- | | | | | | | | | |
|--|--|--|--|--|--|--|--|--|
| P  | P  | P  | P  | M  | N  | N  | S  | H  |
| C <0,2% | 0,25<C<0,4 | C>0,45% | SCM | INOX | Al | ACADC | Ti | 25-35 HRC |
| 15-60 | 15-60 | 10-60 | 8-30 | 8-20 | 15-35 | 15-35 | 5-10 | 8-20 |
- m/min**



Metric Fine

Threading | Cutting taps | Metric Fine



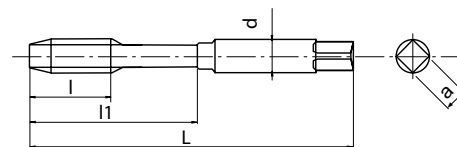
- ## Threading | Cutting taps

38

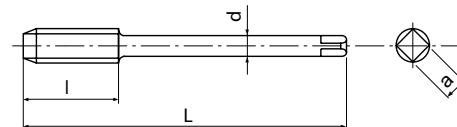
Threading | Cutting taps | UNC



Type 1



Type 2

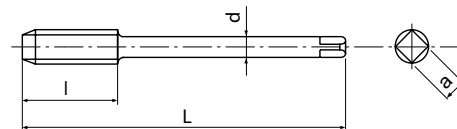
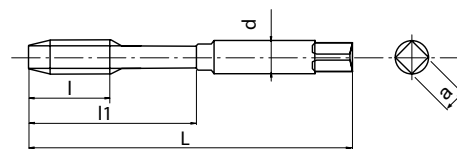


- First choice in quality and performance
- Powder metal spiral-point cutting tap for through holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels

P 	P 	P 	P 	M 	N 	N 	S 	H 	
C < 0,2%	0,25 < C < 0,4	C > 0,45%	SCM	INOX	Al	Al ₂ O ₃	Ti	25-35 HRC	
15-60	15-60	10-60	8-30	8-20	15-35	15-35	5-10	8-20	m/min

[illegible]

Threading | Cutting taps | UNF



- First choice in quality and performance
- Powder metal spiral-point cutting tap for through holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels



15-60



15-60



10-60



8-30



8-20



15-35



15-35



5-10



8-20

m/min



UNF

PM



V

**ANSI
2BX**



B/4



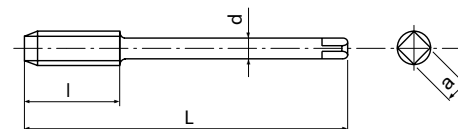
DIN 2184-1



DIN 2184-1

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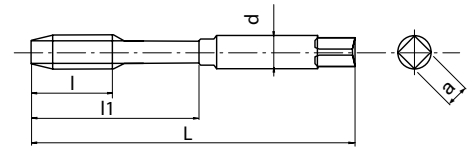
Threading | Cutting taps | G (BSP)



- | | | | | | | | | |
|--|--|--|--|--|--|--|--|--|
| P  | P  | P  | P  | M  | N  | N  | S  | H  |
| C < 0,2% | 0,25 < C < 0,4 | C > 0,45% | SCM | INOX | Al | AC,ADC | Ti | 25-35 HRC |
| 15-60 | 15-60 | 10-60 | 8-30 | 8-20 | 15-35 | 15-35 | 5-10 | 8-20 |
- m/min**

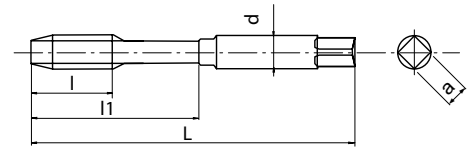
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Threading | Cutting taps | BSW



- ## Threading | Cutting taps

BSW

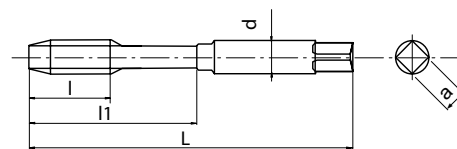


- First choice in quality and performance
- Powder metal spiral-point cutting tap for through holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels

 C < 0,2%	 0,25 < C < 0,4	 C > 0,45%	 SCM	 INOX	 Al	 AC/ADC	 Ti	 25-35 HRC	
15-60	15-60	10-60	8-30	8-20	15-35	15-35	5-10	8-20	m/min

[illegible]

Threading | Cutting taps | BA



- First choice in quality and performance
- Powder metal spiral-point cutting tap for through holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels

Threading | Cutting taps

P 	P 	P 	P 	M 	N 	N 	S 	H 	
C < 0,2%	0,25 < C < 0,4	C > 0,45%	SCM	INOX	Al	AC,ADC	Ti	25-35 HRC	
15-60	15-60	10-60	8-30	8-20	15-35	15-35	5-10	8-20	m/min



BA

[illegible]

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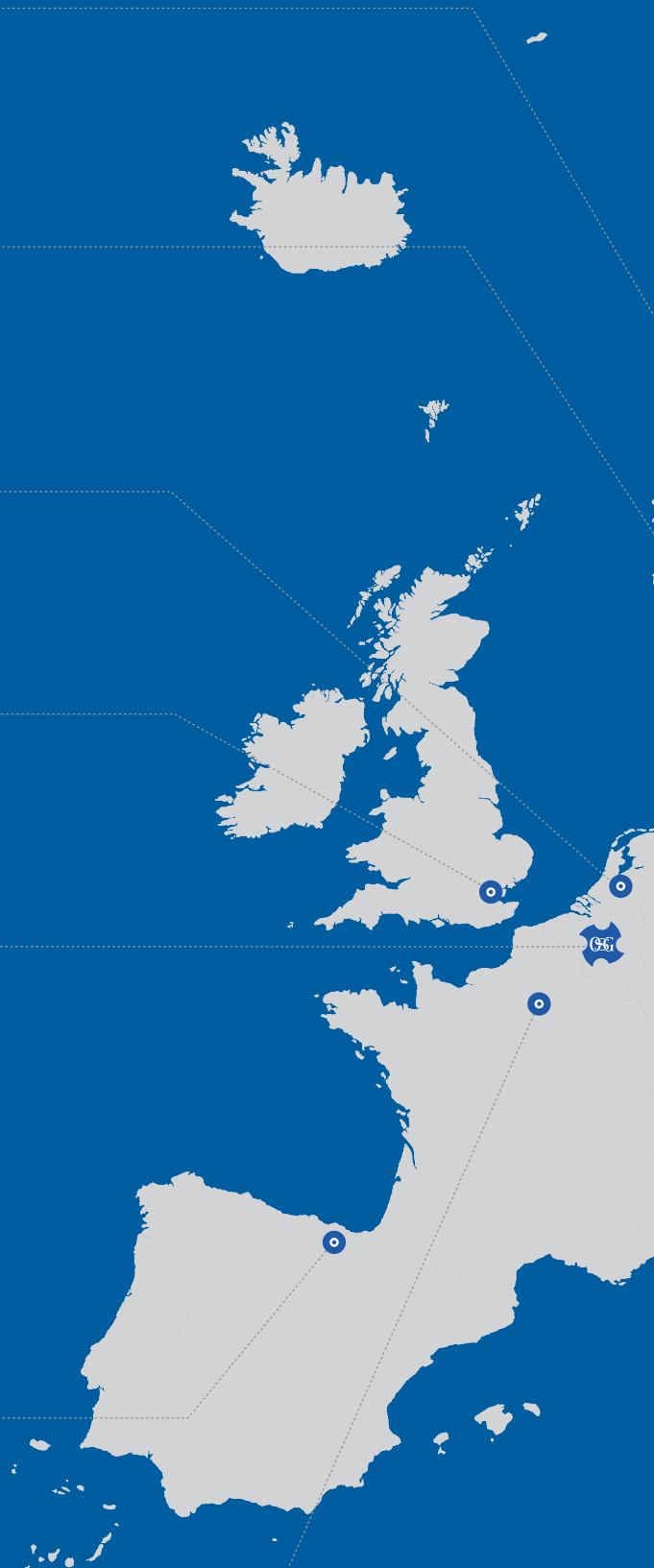
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shaping your dreams

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