



Powder metal straight fluted taps for cast iron and aluminium die cast

VP(O)-DC-MT SERIES

Volume 2



KEY FEATURE: VP(O)-DC-MT SERIES



1 Synchro taps when speed can be > 30 m/min

2 Highly wear resistant powder metal substrate

3 Straight flute, high rigidity

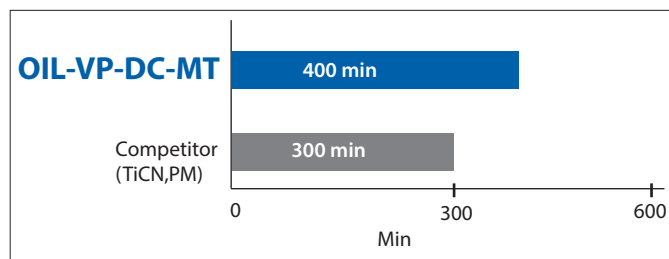
4 Also available with oil hole

PERFORMANCE

■ GGG40 Emulsion

| | |
|----------------|-------------------------------|
| Tool | OIL-VP-DC-MT (M16x1,5) |
| Tapping Length | 26 mm (Blind & Through holes) |
| Tapping Speed | 40 m/min (800U/min) |
| Coolant | Emulsion |
| Machine | Vertical Machining Center |

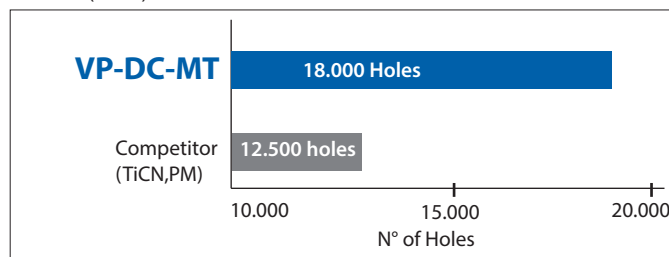
Tool Life



■ GG25 Dry Tapping

| | |
|----------------|---------------------------|
| Tool | VP-DC-MT (M10x1,5) |
| Tapping Length | 18 mm |
| Tapping Speed | 49 m/min (1.560U/min) |
| Coolant | Dry |
| Machine | Vertical Machining Center |

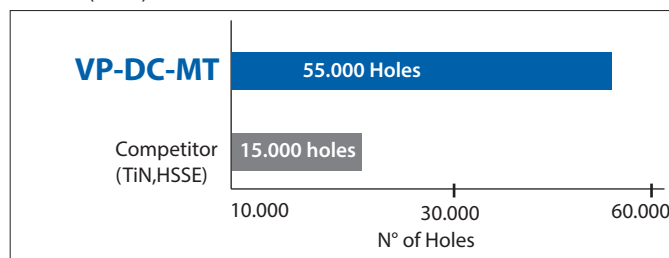
Tool Life (holes)



■ ADC Emulsion

| | |
|----------------|---------------------------|
| Tool | VP-DC-MT (M10x1,5) |
| Tapping Length | 30 mm |
| Tapping Speed | 30 m/min (955U/min) |
| Coolant | Emulsion |
| Machine | Vertical Machining Center |

Tool Life (holes)

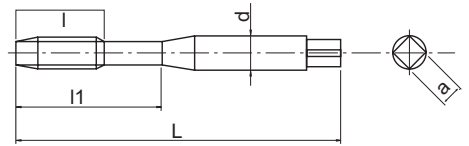


VP-DC-MT NEW SIZES

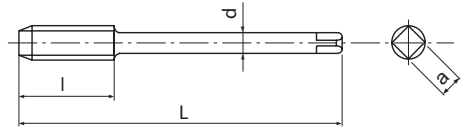
Threading | Cutting taps | Metric



Type 1



Type 2



- Powder metal straight flute cutting tap for through and blind holes
- Multilayer TiCN coating
- For cast iron and cast aluminium
- Synchro taps at cutting speeds > 30 m/min

| | | | | | | | |
|----------|----------|----------|----------|----------|-----------|-----------|-------|
| P | P | K | K | N | H | H | |
| C>0.45% | SCM | GG | GGG | AC,ADC | 25-35 HRC | 35-45 HRC | |
| 10-25 | 10-20 | 15-60 | 15-40 | 25-70 | 8-20 | 8-20 | m/min |

| | | | | | | | | |
|----------|-----------|----------|------------------|--|--|--|----------------|----------------|
| M | PM | V | ISO 2 6HX | | | | DIN 371 | DIN 376 |
|----------|-----------|----------|------------------|--|--|--|----------------|----------------|

| EDP | M | P | L | l | l1 | d | a | Z | Type | DIN | Price |
|-----------------------------|-----|------|-----|----|----|-----|------|---|------|--------|-------|
| 48020125 <small>NEW</small> | 2 | 0,4 | 45 | | | 2,8 | 2,1 | 3 | 1 | DIN371 | |
| 48020133 <small>NEW</small> | 2,5 | 0,45 | 50 | 12 | 30 | 7 | 5,5 | 3 | 1 | DIN371 | |
| 48020138 | 3 | 0,5 | 56 | - | 18 | 3,5 | 2,7 | 3 | 1 | DIN371 | |
| 48020142 <small>NEW</small> | 3,5 | 0,6 | 56 | 18 | - | 8 | 6,2 | 4 | 2 | DIN371 | |
| 48020144 | 4 | 0,7 | 63 | - | 21 | 4,5 | 3,4 | 3 | 1 | DIN371 | |
| 48020149 | 5 | 0,8 | 70 | - | 25 | 6 | 4,9 | 3 | 1 | DIN371 | |
| 48020155 | 6 | 1 | 80 | - | 30 | 6 | 4,9 | 3 | 1 | DIN371 | |
| 48020158 <small>NEW</small> | 7 | 1 | 80 | 30 | - | 18 | 14,5 | 5 | 2 | DIN371 | |
| 48020161 | 8 | 1,25 | 90 | - | 35 | 8 | 6,2 | 4 | 1 | DIN371 | |
| 48020169 | 10 | 1,5 | 100 | - | 39 | 10 | 8 | 4 | 1 | DIN371 | |
| 48020175 <small>NEW</small> | 11 | 1,5 | 100 | 36 | - | 18 | 14,5 | 5 | 1 | DIN371 | |
| 48020179 | 12 | 1,75 | 110 | 21 | - | 9 | 7 | 4 | 2 | DIN376 | |
| 48022191 | 14 | 2 | 110 | 24 | - | 11 | 9 | 4 | 2 | DIN376 | |
| 48022202 | 16 | 2 | 110 | 24 | - | 12 | 9 | 4 | 2 | DIN376 | |
| 48022214 | 18 | 2,5 | 125 | 30 | - | 14 | 11 | 4 | 2 | DIN376 | |
| 48022228 | 20 | 2,5 | 140 | 30 | - | 16 | 12 | 4 | 2 | DIN376 | |
| 48020238 <small>NEW</small> | 22 | 2,5 | 140 | 42 | - | 22 | 18 | 6 | 2 | DIN376 | |
| 48020247 <small>NEW</small> | 24 | 3 | 160 | - | - | - | - | - | 2 | DIN376 | |
| 48020271 <small>NEW</small> | 30 | 3,5 | 180 | - | - | - | - | - | 2 | DIN376 | |

Threading | Cutting taps

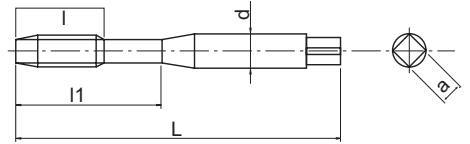
Metric

VP-DC-MT FORM E NEW SIZES

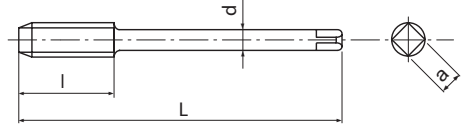
Threading | Cutting taps | Metric



Type 1



Type 2



- Powder metal straight flute cutting tap for through and blind holes
- Multilayer TiCN coating
- For cast iron and cast aluminium
- Synchro taps at cutting speeds > 30 m/min, chamfer Form E

| | | | | | | | |
|---------------------|-----------------|----------------|-----------------|--------------------|-----------------------|-----------------------|-------|
| P C>0.45% | P SCM | K GG | K GGG | N AC,ADC | H 25-35 HRC | H 35-45 HRC | |
| 10-25 | 10-20 | 15-60 | 15-40 | 25-70 | 8-20 | 8-20 | m/min |

| | | | | | | | |
|----------|-----------|----------|------------------|--------------|------------|----------------|----------------|
| M | PM | V | ISO 2 6HX | E/1,5 | ≥2D | DIN 371 | DIN 376 |
|----------|-----------|----------|------------------|--------------|------------|----------------|----------------|

| EDP | M | P | L | l | l1 | d | a | Z | Type | DIN | Price |
|-----------------------------|----|------|-----|----|----|-----|------|---|------|--------|-------|
| 48037138 | 3 | 0,5 | 56 | - | 18 | 3,5 | 2,7 | 3 | 1 | DIN371 | |
| 48037144 | 4 | 0,7 | 63 | - | 21 | 4,5 | 3,4 | 3 | 1 | DIN371 | |
| 48037149 | 5 | 0,8 | 70 | - | 25 | 6 | 4,9 | 3 | 1 | DIN371 | |
| 48037155 | 6 | 1 | 80 | - | 30 | 6 | 4,9 | 3 | 1 | DIN371 | |
| 48037161 | 8 | 1,25 | 90 | - | 35 | 8 | 6,2 | 4 | 1 | DIN371 | |
| 48037169 | 10 | 1,5 | 100 | - | 39 | 10 | 8 | 4 | 1 | DIN371 | |
| 48037179 | 12 | 1,75 | 110 | 21 | - | 9 | 7 | 4 | 2 | DIN376 | |
| 48037191 | 14 | 2 | 110 | 24 | - | 11 | 9 | 4 | 2 | DIN376 | |
| 48037202 | 16 | 2 | 110 | 24 | - | 12 | 9 | 4 | 2 | DIN376 | |
| 48037214 <small>NEW</small> | 18 | 2,5 | 125 | 30 | - | 14 | 11 | 4 | 2 | DIN376 | |
| 48037228 <small>NEW</small> | 20 | 2,5 | 140 | 30 | - | 16 | 12 | 4 | 2 | DIN376 | |
| 48037238 <small>NEW</small> | 22 | 2,5 | 140 | 30 | - | 18 | 14,5 | 5 | 2 | DIN376 | |
| 48037247 <small>NEW</small> | 24 | 3 | 160 | 36 | - | 18 | 14,5 | 5 | 2 | DIN376 | |

Threading | Cutting taps

Metric

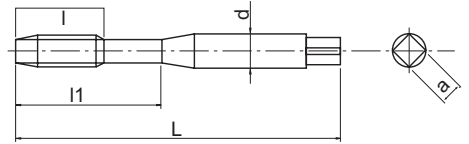


VPO-DC-MT Center NEW SIZES

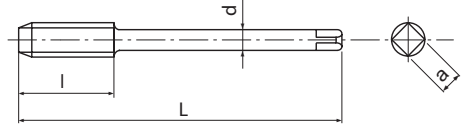
Threading | Cutting taps | Metric



Type 1



Type 2



- Powder metal straight flute cutting tap for blind holes
- Multilayer TiCN coating
- For cast iron and cast aluminium
- Synchro taps at cutting speeds > 30 m/min, with Centre through coolant

Threading | Cutting taps

| | | | | | | | |
|---------------------|-----------------|----------------|-----------------|--------------------|-----------------------|-----------------------|-------|
| P C>0.45% | P SCM | K GG | K GGG | N AC,ADC | H 25-35 HRC | H 35-45 HRC | |
| 10-25 | 10-20 | 15-60 | 15-40 | 25-70 | 8-20 | 8-20 | m/min |

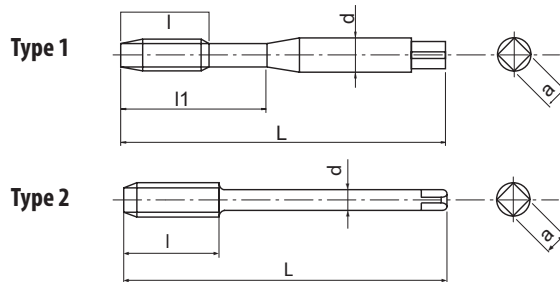
| | | | | | | | |
|----------|-----------|----------|------------------|--------------|------------|----------------|----------------|
| M | PM | V | ISO 2 6HX | C/2,5 | ≥2D | DIN 371 | DIN 376 |
|----------|-----------|----------|------------------|--------------|------------|----------------|----------------|

| EDP | M | P | L | I | I1 | d | a | Z | Type | DIN | Price |
|---------------------|----|------|-----|----|----|----|-----|---|------|--------|-------|
| 48021155 | 6 | 1 | 80 | - | 30 | 6 | 4,9 | 3 | 1 | DIN371 | |
| 48021161 | 8 | 1,25 | 90 | - | 35 | 8 | 6,2 | 4 | 1 | DIN371 | |
| 48021169 | 10 | 1,5 | 100 | - | 39 | 10 | 8 | 4 | 1 | DIN371 | |
| 48300179 NEW | 12 | 1,75 | 110 | 28 | - | 9 | 7 | 3 | 2 | DIN376 | |
| 48300191 NEW | 14 | 2 | 110 | 24 | - | 11 | 9 | 3 | 2 | DIN376 | |
| 48300202 NEW | 16 | 2 | 110 | 24 | - | 12 | 9 | 3 | 2 | DIN376 | |
| 48300214 NEW | 18 | 2,5 | 125 | 30 | - | 14 | 11 | 4 | 2 | DIN376 | |
| 48300228 NEW | 20 | 2,5 | 140 | 30 | - | 16 | 12 | 4 | 2 | DIN376 | |
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Metric

VPO-DC-MT Side NEW SIZES

Threading | Cutting taps | Metric



- Powder metal straight flute cutting tap for through holes
- Multilayer TiCN coating
- For cast iron and cast aluminium
- Synchro taps at cutting speeds > 30 m/min, with side through coolant

| | | | | | | | |
|-----------------------|-------------------|------------------|-------------------|----------------------|-------------------------|-------------------------|--------------|
| P ○ C>0.45% | P ○ SCM | K ● GG | K ● GGG | N ● AC,ADC | H ○ 25-35 HRC | H ○ 35-45 HRC | m/min |
| 10-25 | 10-20 | 15-60 | 15-40 | 25-70 | 8-20 | 8-20 | |

| | | | | | | | | |
|----------|-----------|----------|------------------|--------------|--|--|----------------|----------------|
| M | PM | V | ISO 2 6HX | C/2,5 | | | DIN 371 | DIN 376 |
|----------|-----------|----------|------------------|--------------|--|--|----------------|----------------|

| EDP | M | P | L | l | l1 | d | a | Z | Type | DIN | Price |
|---------------------|----|------|-----|----|----|----|-----|---|------|--------|-------|
| 48299155 NEW | 6 | 1 | 80 | 8 | 30 | 6 | 4,9 | 3 | 1 | DIN371 | |
| 48299161 NEW | 8 | 1.25 | 90 | 10 | 35 | 8 | 6,2 | 4 | 1 | DIN371 | |
| 48299169 NEW | 10 | 1.5 | 100 | 12 | 39 | 10 | 8 | 4 | 1 | DIN371 | |
| 48021179 | 12 | 1,75 | 110 | 21 | - | 9 | 7 | 4 | 2 | DIN376 | |
| 48024191 | 14 | 2 | 110 | 24 | - | 11 | 9 | 4 | 2 | DIN376 | |
| 48024202 | 16 | 2 | 110 | 24 | - | 12 | 9 | 4 | 2 | DIN376 | |
| 48024214 | 18 | 2,5 | 125 | 30 | - | 14 | 11 | 4 | 2 | DIN376 | |
| 48024228 | 20 | 2,5 | 140 | 30 | - | 16 | 12 | 4 | 2 | DIN376 | |

Threading | Cutting taps



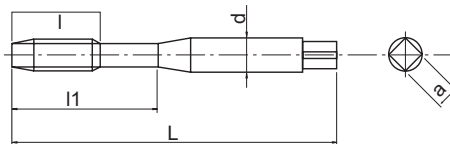
Metric

VPO-DC-MT FORM E NEW SIZES

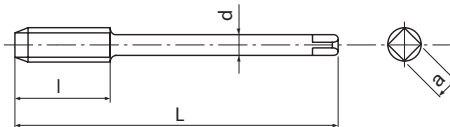
Threading | Cutting taps | Metric



Type 1



Type 2



- Powder metal straight flute cutting tap for blind holes
- Multilayer TiCN coating
- For cast iron and cast aluminium
- Synchro taps at cutting speeds > 30 m/min, with Centre through coolant, chamfer Form E

| | | | | | | | |
|---------------------|-----------------|----------------|-----------------|--------------------|-----------------------|-----------------------|-------|
| P C>0.45% | P SCM | K GG | K GGG | N AC,ADC | H 25-35 HRC | H 35-45 HRC | |
| 10-25 | 10-20 | 15-60 | 15-40 | 25-70 | 8-20 | 8-20 | m/min |

| | | | | | | | |
|----------|-----------|----------|------------------|--------------|------------|----------------|----------------|
| M | PM | V | ISO 2 6HX | E/1,5 | ≥2D | DIN 371 | DIN 376 |
|----------|-----------|----------|------------------|--------------|------------|----------------|----------------|

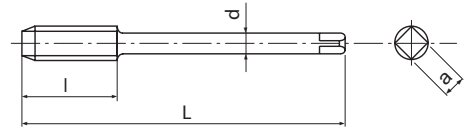
| EDP | M | P | L | l | l1 | d | a | Z | Type | DIN | Price |
|-----------------------------|----|------|-----|----|----|----|------|---|------|--------|-------|
| 48038155 | 6 | 1 | 80 | - | 30 | 6 | 4,9 | 3 | 1 | DIN371 | |
| 48038161 | 8 | 1,25 | 90 | - | 35 | 8 | 6,2 | 4 | 1 | DIN371 | |
| 48038169 | 10 | 1,5 | 100 | - | 39 | 10 | 8 | 4 | 1 | DIN371 | |
| 48038179 | 12 | 1,75 | 110 | 21 | - | 9 | 7 | 4 | 2 | DIN376 | |
| 48038191 | 14 | 2 | 110 | 24 | - | 11 | 9 | 4 | 2 | DIN376 | |
| 48038202 | 16 | 2 | 110 | 24 | - | 12 | 9 | 4 | 2 | DIN376 | |
| 48038214 <small>NEW</small> | 18 | 2,5 | 125 | 30 | - | 14 | 11 | 4 | 2 | DIN376 | |
| 48038228 <small>NEW</small> | 20 | 2,5 | 140 | 30 | - | 16 | 12 | 4 | 2 | DIN376 | |
| 48038238 <small>NEW</small> | 22 | 2,5 | 140 | 30 | - | 18 | 14,5 | 5 | 2 | DIN376 | |
| 48038247 <small>NEW</small> | 24 | 3 | 160 | 36 | - | 18 | 14,5 | 5 | 2 | DIN376 | |

Threading | Cutting taps

Metric

VP-DC-MT

Threading | Cutting taps | Metric Fine



- Powder metal straight flute cutting tap for through and blind holes
- Multilayer TiCN coating
- For cast iron and cast aluminium
- Synchro taps at cutting speeds > 30 m/min

| | | | | | | | |
|---------------------|-----------------|----------------|-----------------|--------------------|-----------------------|-----------------------|-------|
| P C>0.45% | P SCM | K GG | K GGG | N AC,ADC | H 25-35 HRC | H 35-45 HRC | |
| 10-25 | 10-20 | 15-60 | 15-40 | 25-70 | 8-20 | 8-20 | m/min |

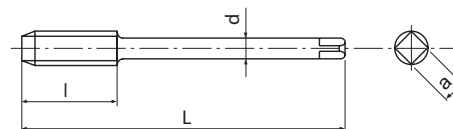
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|-----------|-----------|----------|------------------|--------------|--|--|----------------|
| MF | PM | V | ISO 2 6HX | C/2,5 | | | DIN 374 |
|-----------|-----------|----------|------------------|--------------|--|--|----------------|

| EDP | MF | P | L | l | d | a | Z | DIN | Price |
|----------|----|------|-----|----|-----|------|---|--------|-------|
| 48023140 | 3 | 0,35 | 56 | 8 | 2,2 | - | 3 | DIN374 | |
| 48023145 | 4 | 0,5 | 63 | 9 | 2,8 | 2,1 | 3 | DIN374 | |
| 48023151 | 5 | 0,5 | 70 | 10 | 3,5 | 2,7 | 3 | DIN374 | |
| 48023156 | 6 | 0,75 | 80 | 12 | 4,5 | 3,4 | 3 | DIN374 | |
| 48023157 | 6 | 0,5 | 80 | 12 | 4,5 | 3,4 | 3 | DIN374 | |
| 48023163 | 8 | 0,75 | 80 | 15 | 6 | 4,9 | 4 | DIN374 | |
| 48023162 | 8 | 1 | 90 | 15 | 6 | 4,9 | 4 | DIN374 | |
| 48023171 | 10 | 1 | 90 | 18 | 7 | 5,5 | 4 | DIN374 | |
| 48023170 | 10 | 1,25 | 100 | 18 | 7 | 5,5 | 4 | DIN374 | |
| 48023182 | 12 | 1 | 100 | 21 | 9 | 7 | 4 | DIN374 | |
| 48023181 | 12 | 1,25 | 100 | 21 | 9 | 7 | 4 | DIN374 | |
| 48023180 | 12 | 1,5 | 100 | 21 | 9 | 7 | 4 | DIN374 | |
| 48023192 | 14 | 1,5 | 100 | 24 | 11 | 9 | 4 | DIN374 | |
| 48023203 | 16 | 1,5 | 100 | 24 | 12 | 9 | 4 | DIN374 | |
| 48023216 | 18 | 1,5 | 110 | 30 | 14 | 11 | 4 | DIN374 | |
| 48023230 | 20 | 1,5 | 125 | 30 | 16 | 12 | 4 | DIN374 | |
| 48023240 | 22 | 1,5 | 125 | 20 | 18 | 14,5 | 5 | DIN374 | |
| 48023250 | 24 | 1,5 | 140 | 24 | 18 | 14,5 | 5 | DIN374 | |



VPO-DC-MT Center NEW SIZES

Threading | Cutting taps | Metric Fine



- Powder metal straight flute cutting tap for blind holes
- Multilayer TiCN coating
- For cast iron and cast aluminium
- Synchro taps at cutting speeds > 30 m/min, with Centre through coolant

Threading | Cutting taps

| | | | | | | | |
|----------|----------|----------|----------|----------|-----------|-----------|-------|
| P | P | K | K | N | H | H | |
| C>0.45% | SCM | GG | GGG | AC,ADC | 25-35 HRC | 35-45 HRC | |
| 10-25 | 10-20 | 15-60 | 15-40 | 25-70 | 8-20 | 8-20 | m/min |

| | | | | | | | |
|-----------|-----------|----------|----------------------|--|--|--|----------------|
| MF | PM | V | ISO 2 6HX | | | | DIN 374 |
|-----------|-----------|----------|----------------------|--|--|--|----------------|

| EDP | MF | P | L | I | d | a | Z | DIN | Price |
|---------------------------|----|------|-----|----|----|-----|---|--------|-------|
| 48024162 | 8 | 1 | 90 | 15 | 6 | 4,9 | 4 | DIN374 | |
| 48024171 | 10 | 1 | 90 | 18 | 7 | 5,5 | 4 | DIN374 | |
| 48024170 | 10 | 1,25 | 100 | 18 | 7 | 5,5 | 4 | DIN374 | |
| 48300181 NEW | 12 | 1,25 | 100 | 21 | 9 | 7 | 4 | DIN374 | |
| 48300180 NEW | 12 | 1,5 | 100 | 21 | 9 | 7 | 4 | DIN374 | |
| 48300192 NEW | 14 | 1,5 | 100 | 24 | 11 | 9 | 4 | DIN374 | |
| 48300203 NEW | 16 | 1,5 | 100 | 24 | 12 | 9 | 4 | DIN374 | |
| 48300216 NEW | 18 | 1,5 | 110 | 30 | 14 | 11 | 4 | DIN374 | |
| 48300230 NEW | 20 | 1,5 | 125 | 30 | 16 | 12 | 4 | DIN374 | |



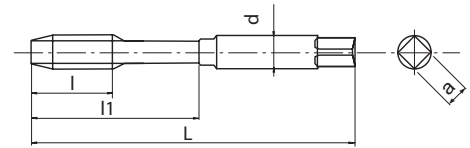
Metric Fine

VP-DC-MT NEW

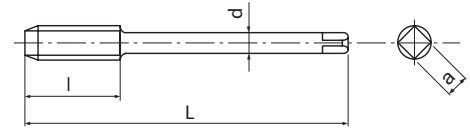
Threading | Cutting taps | UNC



Type 1



Type 2



- Powder metal straight flute cutting tap for through and blind holes
- Multilayer TiCN coating
- For cast iron and cast aluminium
- Synchro taps at cutting speeds > 30 m/min

Threading | Cutting taps

| | | | | | | | |
|-----------------------|-------------------|------------------|-------------------|----------------------|-------------------------|-------------------------|-------|
| P ○ C>0.45% | P ○ SCM | K ● GG | K ● GGG | N ● AC,ADC | H ○ 25-35 HRC | H ○ 35-45 HRC | |
| 10-25 | 10-20 | 15-60 | 15-40 | 25-70 | 8-20 | 8-20 | m/min |

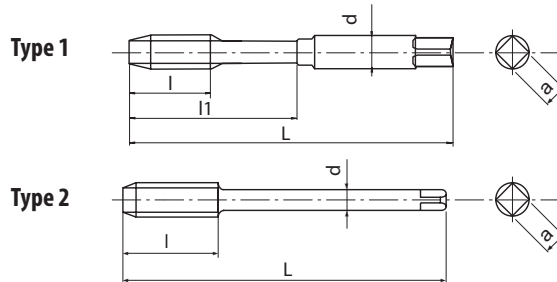


| EDP | UNC | P | L | I | l1 | d | a | Z | Type | DIN | Price |
|----------|------|----|-----|----|----|-----|------|---|------|-----------|-------|
| 48020453 | 2 | 56 | 45 | 9 | | 2,8 | 2,1 | 3 | 1 | DIN2184-1 | |
| 48020455 | 3 | 48 | 50 | 9 | | 2,8 | 2,1 | 3 | 1 | DIN2184-1 | |
| 48020457 | 4 | 40 | 56 | 8 | 18 | 3,5 | 2,7 | 3 | 1 | DIN2184-1 | |
| 48020459 | 5 | 40 | 56 | 8 | 18 | 3,5 | 2,7 | 3 | 1 | DIN2184-1 | |
| 48020461 | 6 | 32 | 56 | 10 | 20 | 4 | 3 | 3 | 1 | DIN2184-1 | |
| 48020464 | 8 | 32 | 63 | 10 | 21 | 4,5 | 3,4 | 3 | 1 | DIN2184-1 | |
| 48020466 | 10 | 24 | 70 | 13 | 25 | 6 | 4,9 | 3 | 1 | DIN2184-1 | |
| 48020468 | 12 | 24 | 80 | 13 | 30 | 6 | 4,9 | 3 | 1 | DIN2184-1 | |
| 48020471 | 1/4 | 20 | 80 | 16 | 30 | 7 | 5,5 | 3 | 1 | DIN2184-1 | |
| 48020474 | 5/16 | 18 | 90 | 17 | 35 | 8 | 6,2 | 4 | 1 | DIN2184-1 | |
| 48020479 | 3/8 | 16 | 100 | 20 | 39 | 10 | 8 | 4 | 1 | DIN2184-1 | |
| 48020484 | 7/16 | 14 | 100 | 22 | - | 8 | 6,2 | 4 | 2 | DIN2184-1 | |
| 48020489 | 1/2 | 13 | 110 | 24 | - | 9 | 7 | 4 | 2 | DIN2184-1 | |
| 48020494 | 9/16 | 12 | 110 | 26 | - | 11 | 9 | 4 | 2 | DIN2184-1 | |
| 48020501 | 5/8 | 11 | 110 | 28 | - | 12 | 9 | 4 | 2 | DIN2184-1 | |
| 48020515 | 3/4 | 10 | 125 | 31 | - | 14 | 11 | 4 | 2 | DIN2184-1 | |
| 48020526 | 7/8 | 9 | 140 | 34 | - | 18 | 14,5 | 5 | 2 | DIN2184-1 | |
| 48020538 | 1 | 8 | 160 | 38 | - | 18 | 14,5 | 5 | 2 | DIN2184-1 | |
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UNC

VP-DC-MT NEW

Threading | Cutting taps | UNF



- Powder metal straight flute cutting tap for through and blind holes
- Multilayer TiCN coating
- For cast iron and cast aluminium
- Synchro taps at cutting speeds > 30 m/min

| | | | | | | | | |
|---------------------|-----------------|----------------|-----------------|--------------------|-----------------------|-----------------------|--|-------|
| P C>0.45% | P SCM | K GG | K GGG | N AC,ADC | H 25-35 HRC | H 35-45 HRC | | |
| 10-25 | 10-20 | 15-60 | 15-40 | 25-70 | 8-20 | 8-20 | | m/min |

| | | | | | | | | | |
|------------|-----------|----------|-----------------|--------------|--|--|--|-------------------|-------------------|
| UNF | PM | V | ANSI 2BX | C/2,5 | | | | DIN 2184-1 | DIN 2184-1 |
|------------|-----------|----------|-----------------|--------------|--|--|--|-------------------|-------------------|

| EDP | UNF | P | L | l | l1 | d | a | Z | Type | DIN | Price |
|----------|------|----|-----|----|----|-----|------|---|------|-----------|-------|
| 48020454 | 2 | 64 | 45 | 9 | - | 2,8 | 2,1 | 3 | 1 | DIN2184-1 | |
| 48020456 | 3 | 56 | 50 | 9 | - | 2,8 | 2,1 | 3 | 1 | DIN2184-1 | |
| 48020458 | 4 | 48 | 56 | 8 | 18 | 3,5 | 2,7 | 3 | 1 | DIN2184-1 | |
| 48020460 | 5 | 44 | 56 | 8 | 18 | 3,5 | 2,7 | 3 | 1 | DIN2184-1 | |
| 48020462 | 6 | 40 | 56 | 10 | 20 | 4 | 3 | 3 | 1 | DIN2184-1 | |
| 48020465 | 8 | 36 | 63 | 10 | 21 | 4,5 | 3,4 | 3 | 1 | DIN2184-1 | |
| 48020467 | 10 | 32 | 70 | 13 | 25 | 6 | 4,9 | 3 | 1 | DIN2184-1 | |
| 48020469 | 12 | 28 | 80 | 13 | 30 | 6 | 4,9 | 3 | 1 | DIN2184-1 | |
| 48020472 | 1/4 | 28 | 80 | 16 | 30 | 7 | 5,5 | 3 | 1 | DIN2184-1 | |
| 48020476 | 5/16 | 24 | 90 | 17 | 35 | 8 | 6,2 | 4 | 1 | DIN2184-1 | |
| 48020481 | 3/8 | 24 | 90 | 20 | 35 | 10 | 8 | 4 | 1 | DIN2184-1 | |
| 48020486 | 7/16 | 20 | 100 | 22 | - | 8 | 6,2 | 4 | 2 | DIN2184-1 | |
| 48020491 | 1/2 | 20 | 100 | 24 | - | 9 | 7 | 4 | 2 | DIN2184-1 | |
| 48020496 | 9/16 | 18 | 100 | 26 | - | 11 | 9 | 4 | 2 | DIN2184-1 | |
| 48020504 | 5/8 | 18 | 100 | 28 | - | 12 | 9 | 4 | 2 | DIN2184-1 | |
| 48020517 | 3/4 | 16 | 110 | 31 | - | 14 | 11 | 4 | 2 | DIN2184-1 | |
| 48020528 | 7/8 | 14 | 125 | 23 | - | 18 | 14,5 | 5 | 2 | DIN2184-1 | |
| 48020539 | 1 | 12 | 140 | 25 | - | 18 | 14,5 | 5 | 2 | DIN2184-1 | |

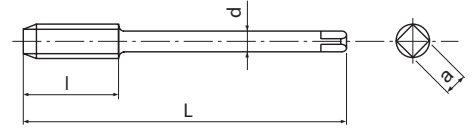
Threading | Cutting taps



UNF

VP-DC-MT NEW

Threading | Cutting taps | G (BSP)



- Powder metal straight flute cutting tap for through and blind holes
- Multilayer TiCN coating
- For cast iron and cast aluminium
- Synchro taps at cutting speeds > 30 m/min

Threading | Cutting taps

| | | | | | | | |
|-----------------------|-------------------|------------------|-------------------|----------------------|-------------------------|-------------------------|-------|
| P ○ C>0.45% | P ○ SCM | K ● GG | K ● GGG | N ● AC,ADC | H ○ 25-35 HRC | H ○ 35-45 HRC | |
| 10-25 | 10-20 | 15-60 | 15-40 | 25-70 | 8-20 | 8-20 | m/min |

| | | | | | | |
|----------|-----------|----------|--------------|--|--|-----------------|
| G | PM | V | C/2,5 | | | DIN 5156 |
|----------|-----------|----------|--------------|--|--|-----------------|

G (BSP)

| EDP | G | P | L | l | d | a | Z | DIN | Price |
|----------|-------|----|-----|----|----|------|---|---------|-------|
| 48020837 | 1/16 | 28 | 90 | 11 | 6 | 4,9 | 4 | DIN5156 | |
| 48020838 | 1/8 | 28 | 90 | 11 | 7 | 5,5 | 4 | DIN5156 | |
| 48020839 | 1/4 | 19 | 100 | 16 | 11 | 9 | 4 | DIN5156 | |
| 48020840 | 3/8 | 19 | 100 | 16 | 12 | 9 | 4 | DIN5156 | |
| 48020841 | 1/2 | 14 | 125 | 22 | 16 | 12 | 5 | DIN5156 | |
| 48020842 | 5/8 | 14 | 125 | 22 | 18 | 14,5 | 5 | DIN5156 | |
| 48020843 | 3/4 | 14 | 140 | 22 | 20 | 16 | 5 | DIN5156 | |
| 48020844 | 7/8 | 14 | 150 | 22 | 22 | 18 | 5 | DIN5156 | |
| 48020845 | 1 | 11 | 160 | 28 | 25 | 20 | 6 | DIN5156 | |
| 48020846 | 1 1/8 | 11 | 170 | 28 | 28 | 22 | 6 | DIN5156 | |
| 48020847 | 1 1/4 | 11 | 170 | 28 | 32 | 24 | 6 | DIN5156 | |
| 48020849 | 1 1/2 | 11 | 190 | 28 | 36 | 29 | 6 | DIN5156 | |
| 48020850 | 1 3/4 | 11 | 190 | 28 | 40 | 32 | 6 | DIN5156 | |
| 48020851 | 2 | 11 | 220 | 28 | 45 | 35 | 6 | DIN5156 | |
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