



# A-TAP SERIES

A-SFT A-OIL-SFT

*Finalmente la risposta che stavate cercando è qui.*



***Stabilita' in maschiatura mai vista prima. Raggiungibile con la nuova serie di maschi "A".***

# A

## 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 %



## The A-TAP can go this far !

Stabilize chip shape  
Sharp cutting edge

Accelerate chip evacuation  
Variable lead flute (PAT.)

### Even to mild steel and stainless steel

1- Applies to a wide variety of work materials

No galling



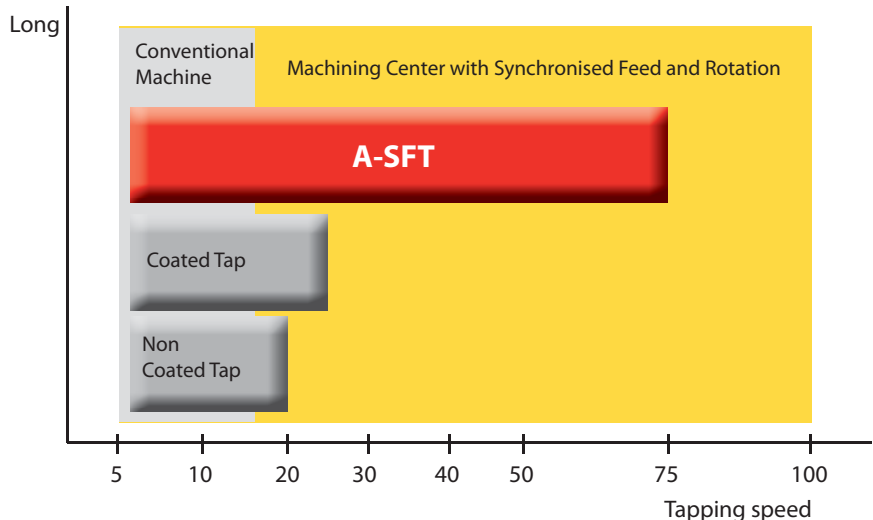
Work Material  
Mild steel



Work Material  
Stainless steel

### High performance in machining center

2- Applies to a wide cutting range



High wear resistance  
V coating

High wear resistance  
Powder Metallurgy HSS (CPM)

- 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.

## The biggest advantage of A-TAP Series

### The Best chip evacuation



Conventional Tap



A-SFT

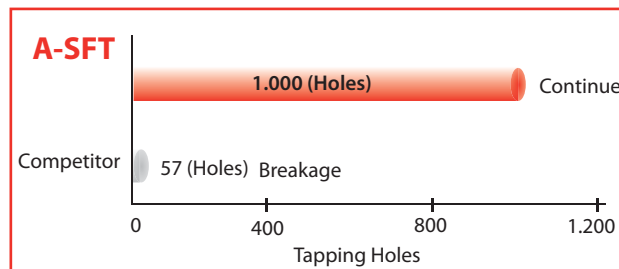
## The A-TAP can go this far !

### ■ SUS304

#### Deep Hole Tapping (2D) in stainless steel

High performance achieved in stainless steel with water soluble oil

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



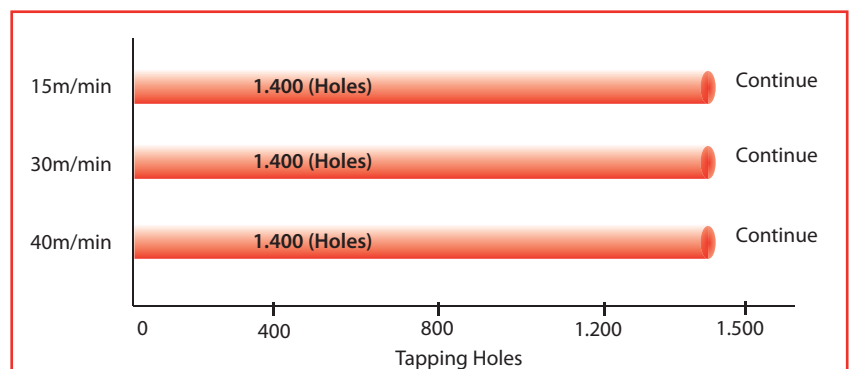
■ Cutting edge after 1.000 holes Tapping

### ■ S45C

#### High speed tapping by machining center

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

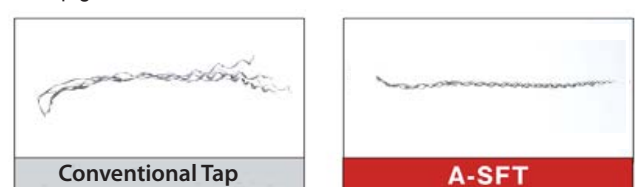
Tool	A-SFT M6x1
Work Material	S45C
Hole Size	Ø5x16mm (Blind)
Tapping Length	12mm (2D)
Coolant	Water Soluble Chlorine-Free (10%)
Machine	Vertical Synchronized Machining Center



■ Cutting edge after 1.400 holes Tapping

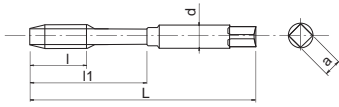
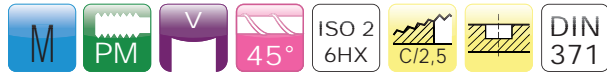


■ Chip generated in 40m/min

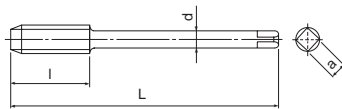


# A A-SFT

Metric



EDP	M	P	L	l	l1	d	a	ZΔ	Stock	Price
48139125	2	0,4	45	3,2	10	2,8	2,1	2	●	
48139133	2,5	0,45	50	3,6	13	2,8	2,1	2	●	
48139138	3	0,5	56	4	18	3,5	2,7	3	●	
48139144	4	0,7	63	5,6	21	4,5	3,4	3	●	
48139149	5	0,8	70	6,4	25	6	4,9	3	●	
48139155	6	1	80	8	30	6	4,9	3	●	
48139161	8	1,25	90	10	35	8	6,2	3	●	
48139169	10	1,5	100	12	39	10	8	3	●	



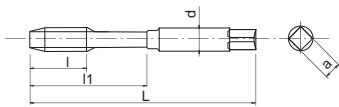
DIN 376



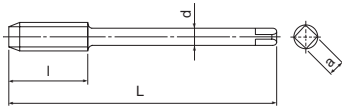
EDP	M	P	L	l	d	a	ZΔ	Stock	Price
48139179	12	1,75	110	14	9	7	3	●	
48139191	14	2	110	16	11	9	3	●	
48139202	16	2	110	16	12	9	3	●	
48139214	18	2,5	125	25	14	11	4	●	
48139228	20	2,5	140	25	16	12	4	●	
48139238	22	2,5	140	25	18	14,5	4	●	
48139247	24	3	160	30	18	14,5	4	●	

# A A-OIL-SFT

Metric



EDP	M	P	L	l	l1	d	a	ZΔ	Stock	Price
48140155	6	1	80	8	30	6	4,9	3	●	
48140161	8	1,25	90	10	35	8	6,2	3	●	
48140169	10	1,5	100	12	39	10	8	3	●	



DIN 376



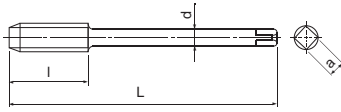
EDP	M	P	L	l	d	a	ZΔ	Stock	Price	
48140179	12	1,75	110	14	9	7	3	●		
48140191	14	2	110	16	11	9	3	●		
48140202	16	2	110	16	12	9	3	●		

Applications - Anwendungen - Applicazioni - Applications - Applikation - Applikation - Aplicaciones - Применение - Uygulama - Zastosowania												
C≤0.2%	0.25<C≤0.4%	C≥0.45%	SCM	25-35 HRC	35-45 HRC	45-52 HRC	52-62 HRC	SUS	SKD	SC	GG	GGG
⊙ 15-60 m/min	⊙ 15-60 m/min	⊙ 10-60 m/min	⊙ 8-30 m/min	○ 8-20 m/min				⊙ 8-20 m/min				
Cu	BS	BsC	PB	Al	AC,ADC	MC	ZDC	Ti	Ni	Plast.	Vinyl	
○ 15-35 m/min		○ 15-30 m/min		○ 15-35 m/min	○ 15-35 m/min	○ 15-35 m/min	○ 15-35 m/min	○ 5-10 m/min			○ 15-20 m/min	

● Delivery from stock  
○ Available on short notice

# A

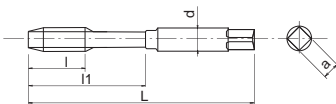
## A-SFT Metric Fine



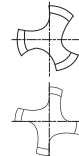
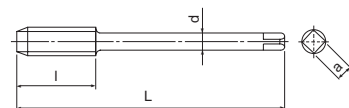
EDP	MF	P	L	l	d	a	ZΔ	Stock	Price
48139156	6	0,75	80	8	4,5	3,4	3	●	
48139163	8	0,75	80	8	6	4,9	3	●	
48139162	8	1	90	10	6	4,9	3	●	
48139171	10	1	90	10	7	5,5	3	●	
48139170	10	1,25	100	12	7	5,5	3	●	
48139182	12	1	100	12	9	7	3	●	
48139181	12	1,25	100	12	9	7	3	●	
48139180	12	1,5	100	14	9	7	3	●	
48139192	14	1,5	100	16	11	9	3	●	
48139203	16	1,5	100	16	12	9	3	●	
48139216	18	1,5	110	16	14	11	4	●	
48139230	20	1,5	125	16	16	12	4	●	
48139240	22	1,5	125	16	18	14,5	4	●	
48139250	24	1,5	140	16	18	14,5	4	●	

# A

## A-SFT UNC



EDP	UNC	P	L	l	l1	d	a	ZΔ	Stock	Price
48139457	4	40	56	5,1	18	3,5	2,7	2	●	
48139459	5	40	56	5,1	18	3,5	2,7	2	●	
48139461	6	32	56	6,4	20	4	3	2	●	
48139464	8	32	63	6,4	21	4,5	3,4	2	●	
48139466	10	24	70	8,5	25	6	4,9	2	●	
48139471	1/4	20	80	10,2	30	7	5,5	2	●	
48139474	5/16	18	90	11,3	35	8	6,2	3	●	
48139479	3/8	16	100	12,7	39	10	8	3	●	



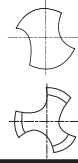
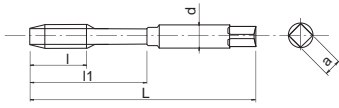
EDP	UNC	P	L	l	d	a	ZΔ	Stock	Price
48139484	7/16	14	100	14,5	8	6,2	3	●	
48139489	1/2	13	110	15,6	9	7	3	●	
48139501	5/8	11	110	18,5	12	9	3	●	
48139515	3/4	10	125	25,4	14	11	4	●	
48139526	7/8	9	140	28,2	18	14,5	4	●	
48139538	1	8	160	31,8	18	14,5	4	●	

Applications - Anwendungen - Applicazioni - Applications - Applikation - Aplicaciones - Применения - Uygulama - Zastosowania												
C≤0.2%	0.25<C≤0.4%	C≥0.45%	SCM	25-35 HRC	35-45 HRC	45-52 HRC	52-62 HRC	SUS	SKD	SC	GG	GGG
⊙ 15-60 m/min	⊙ 15-60 m/min	⊙ 10-60 m/min	⊙ 8-30 m/min	○ 8-20 m/min				⊙ 8-20 m/min				
Cu	BS	BsC	PB	Al	AC,ADC	MC	ZDC	Ti	Ni	Plast.	Vinyl	
○ 15-35 m/min		○ 15-30 m/min		○ 15-35 m/min	○ 15-35 m/min	○ 15-35 m/min	○ 15-35 m/min	○ 5-10 m/min			○ 15-20 m/min	

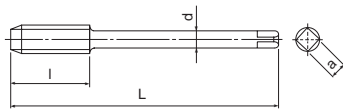
● Delivery from stock  
○ Available on short notice

# A A-SFT

## UNF



EDP	UNF	P	L	l	l1	d	a	ZΔ	Stock	Price
48139462	6	40	56	6,4	20	4	3	2	●	
48139467	10	32	70	8,5	25	6	4,9	2	●	
48139472	1/4	28	80	10,2	30	7	5,5	2	●	
48139476	5/16	24	90	11,3	35	8	6,2	3	●	
48139481	3/8	24	90	12,7	35	10	8	3	●	



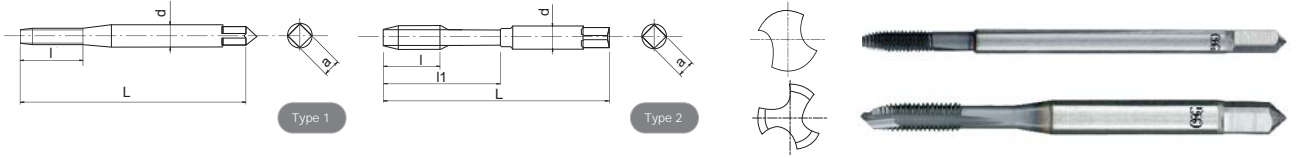
EDP	UNF	P	L	l	d	a	ZΔ	Stock	Price
48139486	7/16	20	100	14,5	8	6,2	3	●	
48139491	1/2	20	100	15,6	9	7	3	●	
48139496	9/16	18	100	16,9	11	9	3	●	
48139504	5/8	18	100	18,5	12	9	3	●	
48139517	3/4	16	110	25,4	14	11	4	●	
48139528	7/8	14	125	28,2	18	14,5	4	●	
48139539	1	12	140	31,8	18	14,5	4	●	

Applications - Anwendungen - Applicazioni - Applications - Applikation - Aplicaciones - Применение - Uygulama - Zastosowania												
C≤0.2%	0.25<C≤0.4%	C≥0.45%	SCM	25-35 HRC	35-45 HRC	45-52 HRC	52-62 HRC	SUS	SKD	SC	GG	GGG
⊙ 15-60 m/min	⊙ 15-60 m/min	⊙ 10-60 m/min	⊙ 8-30 m/min	○ 8-20 m/min				⊙ 8-20 m/min				
Cu	BS	BsC	PB	Al	AC,ADC	MC	ZDC	Ti	Ni	Plast.	Vinyl	
○ 15-35 m/min		○ 15-30 m/min		○ 15-35 m/min	○ 15-35 m/min	○ 15-35 m/min	○ 15-35 m/min	○ 5-10 m/min			○ 15-20 m/min	

● Delivery from stock  
○ Available on short notice

# A A-POT

## Metric



EDP	M	P	L	l	l1	d	a	ZΔ	Type	Stock	Price
48145125	2	0,4	45	8	-	2,8	2,1	2	1	●	
48145133	2,5	0,45	50	9	-	2,8	2,1	2	1	●	
48145138	3	0,5	56	11	18	3,5	2,7	3	2	●	
48145144	4	0,7	63	13	21	4,5	3,4	3	2	●	
48145149	5	0,8	70	16	25	6	4,9	3	2	●	
48145155	6	1	80	19	30	6	4,9	3	2	●	
48145161	8	1,25	90	22	35	8	6,2	3	2	●	
48145169	10	1,5	100	24	39	10	8	3	2	●	



EDP	M	P	L	l	d	a	ZΔ	Stock	Price
48145179	12	1,75	110	29	9	7	3	●	
48145191	14	2	110	30	11	9	3	●	
48145202	16	2	110	32	12	9	3	●	
48145214	18	2,5	125	34	14	11	3	●	
48145228	20	2,5	140	34	16	12	3	●	
48145238	22	2,5	140	34	18	14,5	3	●	
48145247	24	3	160	38	18	14,5	3	●	

# A A-POT

## Metric Fine

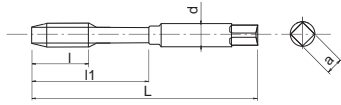


EDP	MF	P	L	l	d	a	ZΔ	Stock	Price
48145156	6	0,75	80	13	4,5	3,4	3	●	
48145163	8	0,75	80	19	6	4,9	3	●	
48145162	8	1	90	22	6	4,9	3	●	
48145171	10	1	90	20	7	5,5	3	●	
48145170	10	1,25	100	24	7	5,5	3	●	
48145182	12	1	100	22	9	7	3	●	
48145181	12	1,25	100	22	9	7	3	●	
48145180	12	1,5	100	22	9	7	3	●	
48145192	14	1,5	100	22	11	9	4	●	
48145203	16	1,5	100	22	12	9	4	●	
48145216	18	1,5	110	25	14	11	4	●	
48145230	20	1,5	125	25	16	12	4	●	
48145240	22	1,5	125	25	18	14,5	4	●	
48145250	24	1,5	140	28	18	14,5	4	●	

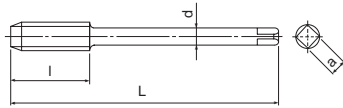
Applications - Anwendungen - Applicazioni - Applications - Applikation - Aplicaciones - Применение - Uygulama - Zastosowania												
C≤0.2%	0.25<C≤0.4%	C≥0.45%	SCM	25-35 HRC	35-45 HRC	45-52 HRC	52-62 HRC	SUS	SKD	SC	GG	GGG
⊙ 15-60 m/min	⊙ 15-60 m/min	⊙ 10-60 m/min	⊙ 8-30 m/min	○ 8-20 m/min				⊙ 8-20 m/min				
Cu	BS	BsC	PB	Al	AC,ADC	MC	ZDC	Ti	Ni	Plast.	Vinyl	
○ 15-35 m/min		○ 15-30 m/min		○ 15-35 m/min	○ 15-35 m/min	○ 15-35 m/min	○ 15-35 m/min	○ 5-10 m/min			○ 15-20 m/min	

● Delivery from stock  
○ Available on short notice

# A-POT UNC

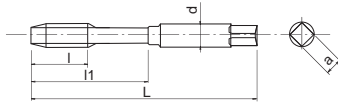


EDP	UNC	P	L	l	l1	d	a	ZΔ	Stock	Price
48145457	4	40	56	11	18	3,5	2,7	2	●	
48145459	5	40	56	11	18	3,5	2,7	3	●	
48145461	6	32	56	12	20	4	3	3	●	
48145464	8	32	63	13	21	4,5	3,4	3	●	
48145466	10	24	70	16	25	6	4,9	3	●	
48145471	1/4	20	80	19	30	7	5,5	3	●	
48145474	5/16	18	90	22	35	8	6,2	3	●	
48145479	3/8	16	100	24	39	10	8	3	●	

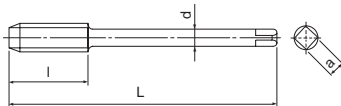


EDP	UNC	P	L	l	d	a	ZΔ	Stock	Price
48145484	7/16	14	100	24	8	6,2	3	●	
48145489	1/2	13	110	28	9	7	3	●	
48145494	9/16	12	110	30	11	9	3	●	
48145501	5/8	11	110	32	12	9	3	●	
48145515	3/4	10	125	34	14	11	3	●	
48145526	7/8	9	140	34	18	14,5	3	●	
48145538	1	8	160	38	18	14,5	3	●	

# A-POT UNF



EDP	UNF	P	L	l	l1	d	a	ZΔ	Stock	Price
48145462	6	40	56	12	20	4	3	3	●	
48145467	10	32	70	16	25	6	4,9	3	●	
48145472	1/4	28	80	19	30	7	5,5	3	●	
48145476	5/16	24	90	22	35	8	6,2	3	●	
48145481	3/8	24	90	20	35	10	8	3	●	



EDP	UNF	P	L	l	d	a	ZΔ	Stock	Price
48145486	7/16	20	100	24	8	6,2	3	●	
48145491	1/2	20	100	22	9	7	3	●	
48145496	9/16	18	100	22	11	9	3	●	
48145504	5/8	18	100	22	12	9	3	●	
48145517	3/4	16	110	25	14	11	3	●	
48145528	7/8	14	125	25	18	14,5	3	●	
48145539	1	12	140	28	18	14,5	3	●	

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