



Powder Metal Cutting Taps  
Suitable for Super Duplex stainless steel

# M-SFT-DUPLEX

Volume 5.1



50 new standard sizes available:  
Metric & metric fine,  
also with oil hole  
New UN-8 sizes available

## KEY FEATURES: M-SFT-DUPLEX

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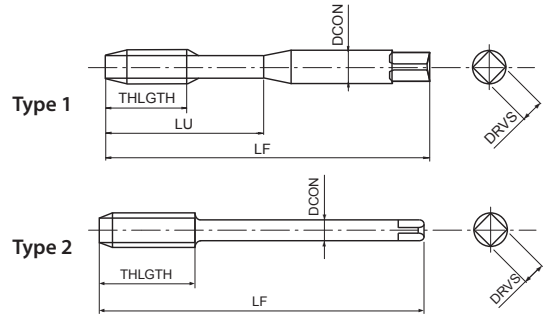
**1** Improved rigidity:  
optimized core diameter  
more flutes than conventional item

**2** Improved chip evacuation:  
optimized high helix angle,  
also with oil hole

**3** Improved welding resistance:  
TiN-coating is ideal for  
SuperDuplex due to higher heat  
resistance.

# M-SFT-DUPLEX NEW SIZE

Threading | Cutting taps | Metric



- Powder metal spiral-fluted cutting tap for blind holes
- TIN-coating
- For stainless steels, Duplex, Super Duplex

<b>P</b> ○ C < 0,2%	<b>P</b> ○ 0,25 < C < 0,4	<b>P</b> ○ C ≥ 0,45%	<b>P</b> ○ SCM	<b>M</b> ● INOX	<b>S</b> ● Inconel 625	<b>S</b> ● Ti Gr.2	
				3-15 Super Duplex	2-3 15-5 PH	3-6 17-4 PH	m/min
<b>M</b>	<b>PM</b>	<b>TiN</b>	<b>50°</b>	<b>ISO 2 6HX</b>	<b>C/2,5</b>	<b>DIN 371</b>	<b>DIN 376</b>

EDP	TD	TP	LF	THLGTH	LU	DCON	DRVS	NOF	Type	DIN
48336125	2	0,4	45	3,2	10	2,8	2,1	2	1	371
48336133 <small>NEW</small>	2,5	0,45	50	3,6	13	2,8	2,1	2	1	371
48336138	3	0,5	56	4	18	3,5	2,7	3	1	371
48336144	4	0,7	63	5,6	21	4,5	3,4	3	1	371
48336149	5	0,8	70	6,4	25	6	4,9	3	1	371
48336155	6	1	80	8	30	6	4,9	3	1	371
48336161	8	1,25	90	10	35	8	6,2	3	1	371
48336169	10	1,5	100	12	39	10	8	4	1	371
48336179	12	1,75	110	14	-	9	7	4	2	376
48336191	14	2	110	16	-	11	9	4	2	376
48336202	16	2	110	16	-	12	9	4	2	376
48336214	18	2,5	125	25	-	14	11	4	2	376
48336228	20	2,5	140	25	-	16	12	4	2	376
48336238	22	2,5	140	25	-	18	14,5	4	2	376
48336247	24	3	160	30	-	18	14,5	4	2	376

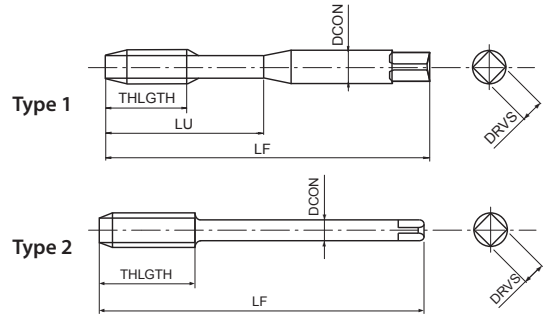
Threading | Cutting taps

Metric



# M-OIL-SFT-DUPLEX NEW

Threading | Cutting taps | Metric



- Powder metal spiral-fluted cutting tap for blind holes
- TiN-coating
- For stainless steels, Duplex, Super Duplex
- Centre through coolant

Threading | Cutting taps

**P** ○

C < 0,2%

**P** ○

0,25 < C < 0,4

**P** ○

C ≥ 0,45%

**P** ○

SCM

**M** ●

INOX

**S** ●

Inconel 625

**S** ●

Ti Gr.2

3-15

2-3

3-6

m/min

Super Duplex    15-5 PH    17-4 PH

**M**

**PM**

**TiN**

50°

**ISO 2  
6HX**

C/2,5

DIN 371

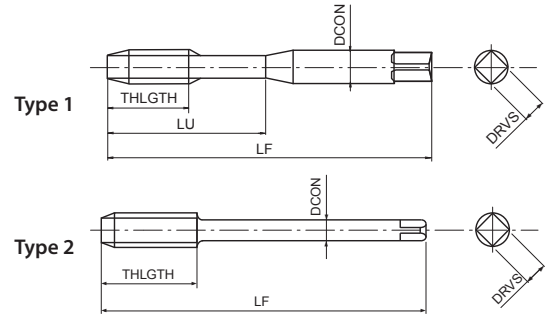
DIN 376

EDP	TD	TP	LF	THLGTH	LU	DCON	DRVS	NOF	Type	DIN
48380155	6	1	80	8	30	6	4,9	3	1	371
48380161	8	1,25	90	10	35	8	6,2	3	1	371
48380169	10	1,5	100	12	39	10	8	4	1	371
48380179	12	1,75	110	14	-	9	7	4	2	376
48380191	14	2	110	16	-	11	9	4	2	376
48380202	16	2	110	16	-	12	9	4	2	376
48380214	18	2,5	125	20	-	14	11	4	2	376
48380228	20	2,5	140	20	-	16	12	4	2	376
48380238	22	2,5	140	20	-	18	14,5	4	2	376
48380247	24	3	160	24	-	18	14,5	4	2	376

Metric

# M-LT-SFT-DUPLEX NEW

Threading | Cutting taps | Metric



- Powder metal spiral-fluted cutting tap for blind holes
- TIN-coating
- For stainless steels, Duplex, Super Duplex
- With long shank for deep reach threading, up to 3D

<b>P</b> ○ C < 0,2%	<b>P</b> ○ 0,25 < C < 0,4	<b>P</b> ○ C ≥ 0,45%	<b>P</b> ○ SCM	<b>M</b> ● INOX	<b>S</b> ● Inconel 625	<b>S</b> ● Ti Gr.2	
				3-15 Super Duplex	2-3 15-5 PH	3-6 17-4 PH	m/min
<b>M</b>	<b>PM</b>	<b>TiN</b>	<b>50°</b>	<b>ISO 2 6HX</b>	<b>C/2,5</b>		

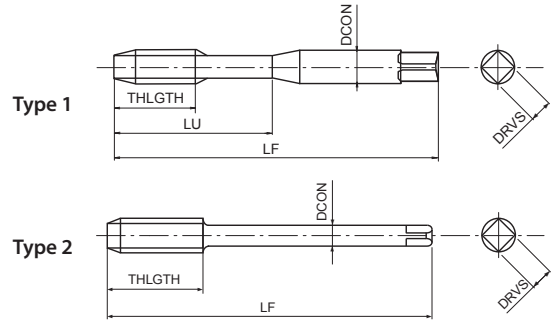
EDP	TD	TP	LF	THLGTH	LU	DCON	DRVS	NOF	Type
48381125	2	0,4	80	3,2	12	2,8	2,1	2	1
48381133	2,5	0,45	100	3,6	15,5	2,8	2,1	2	1
48381138	3	0,5	100	4	21	3,5	2,7	3	1
48381144	4	0,7	125	5,6	25	4,5	3,4	3	1
48381149	5	0,8	160	6,4	30	6	4,9	3	1
48381155	6	1	160	8	36	6	4,9	3	1
48381187	6	1	160	8	-	4,5	3,4	3	2
48381161	8	1,25	180	10	43	8	6,2	3	1
48381188	8	1,25	180	10	-	6	4,9	3	2
48381169	10	1,5	200	12	49	10	8	4	1
48381189	10	1,5	200	12	-	7	5,5	4	2
48381179	12	1,75	200	14	-	9	7	4	2
48381191	14	2	200	16	-	11	9	4	2
48381202	16	2	200	16	-	12	9	4	2
48381214	18	2,5	200	20	-	14	11	4	2
48381228	20	2,5	200	20	-	16	12	4	2





# M-SFT-DUPLEX NEW SIZES

Threading | Cutting taps | UNC, UN



- Powder metal spiral-fluted cutting tap for blind holes
- TIN-coating
- For stainless steels, Duplex, Super Duplex

Threading | Cutting taps

<b>P</b> ○ C < 0,2%	<b>P</b> ○ 0,25 < C < 0,4	<b>P</b> ○ C ≥ 0,45%	<b>P</b> ○ SCM	<b>M</b> ● INOX	<b>S</b> ● Inconel 625	<b>S</b> ● Ti Gr.2	
				3-15 Super Duplex	2-3 15-5 PH	3-6 17-4 PH	m/min
<b>UNC</b>	<b>PM</b>	<b>TiN</b>	<b>50°</b>	<b>ANSI 2BX</b>	<b>C/2,5</b>	<b>DIN 2184-1</b>	<b>DIN 2184-1</b>

EDP	TD	TP	LF	THLGTH	LU	DCON	DRVS	NOF	Type	DIN
48336453	2	56	45	3,6	11	2,8	2,1	2	1	2184-1
48336455	3	48	50	3,6	13	2,8	2,1	2	1	2184-1
48336457	4	40	56	5,1	18	3,5	2,7	2	1	2184-1
48336459	5	40	56	5,1	18	3,5	2,7	2	1	2184-1
48336461	6	32	56	6,4	20	4	3	2	1	2184-1
48336464	8	32	63	6,4	21	4,5	3,4	2	1	2184-1
48336466	10	24	70	8,5	25	6	4,9	2	1	2184-1
48336468	12	24	80	8,5	30	6	4,9	2	1	2184-1
48336471	1/4	20	80	10,2	30	7	5,5	3	1	2184-1
48336474	5/16	18	90	11,3	35	8	6,2	3	1	2184-1
48336479	3/8	16	100	12,7	39	10	8	4	1	2184-1
48336484	7/16	14	100	14,5	-	8	6,2	4	2	2184-1
48336489	1/2	13	110	15,6	-	9	7	4	2	2184-1
48336494	9/16	12	110	16,9	-	11	9	4	2	2184-1
48336501	5/8	11	110	18,5	-	12	9	4	2	2184-1
48336515	3/4	10	125	25,4	-	14	11	4	2	2184-1
48336526	7/8	9	140	28,2	-	18	14,5	4	2	2184-1
48336538	1	8	160	31,8	-	18	14,5	4	2	2184-1
48336552 <small>NEW</small>	1 1/8	8	180	29	-	22	18	5	2	2184-1
48336565 <small>NEW</small>	1 1/4	8	180	29	-	22	18	5	2	2184-1
48336578 <small>NEW</small>	1 3/8	8	200	33,9	-	28	22	5	2	2184-1
48336592 <small>NEW</small>	1 1/2	8	200	34	-	28	22	5	2	2184-1
48336605 <small>NEW</small>	1 5/8	8	200	33,9	-	32	24	5	2	2184-1
48336618 <small>NEW</small>	1 3/4	8	200	40,6	-	36	29	5	2	2184-1
48336628 <small>NEW</small>	1 7/8	8	225	40,6	-	36	29	5	2	2184-1
48336639 <small>NEW</small>	2	8	225	45,2	-	40	32	5	2	2184-1

UNC, UN













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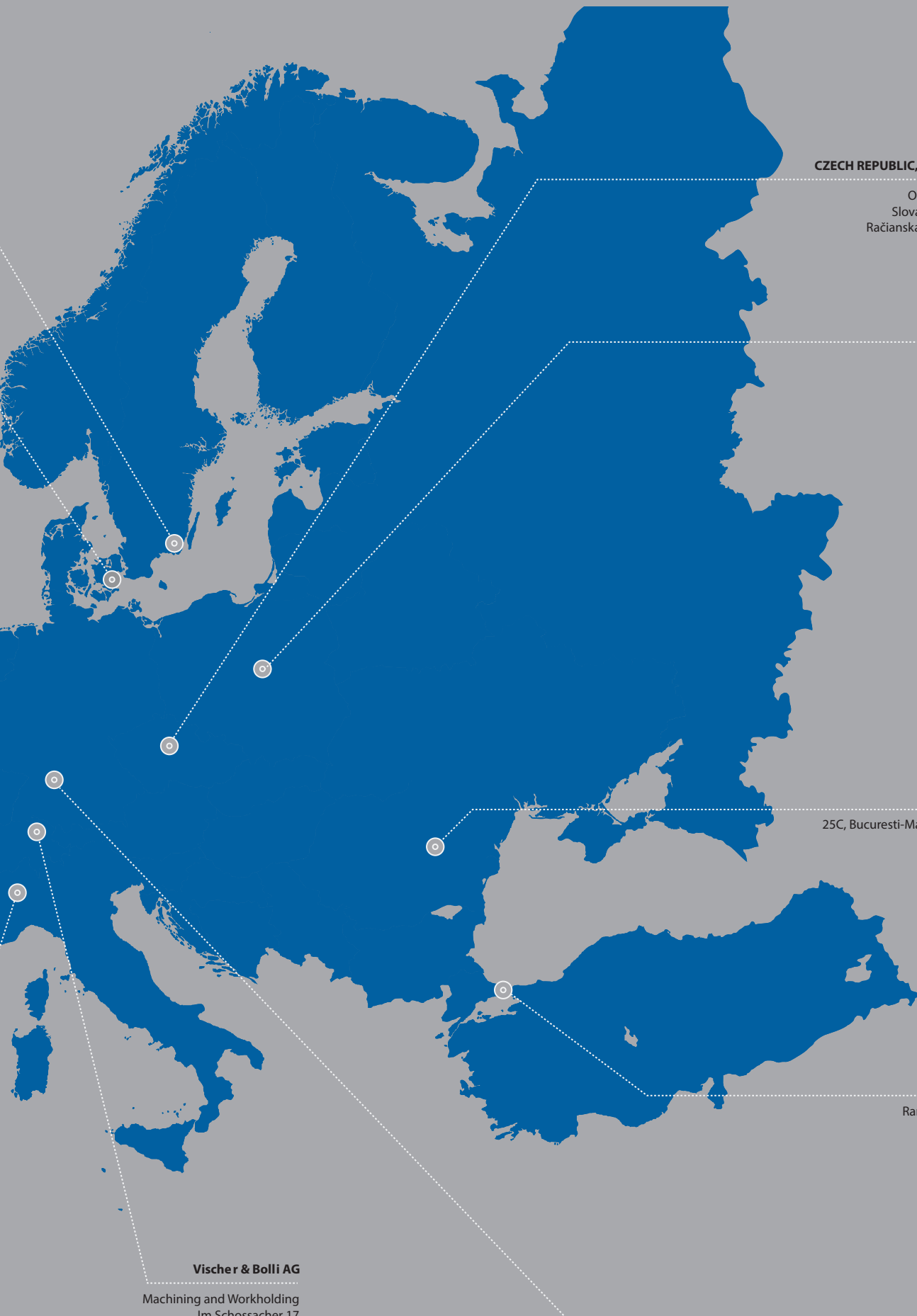
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