



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

VP(O)-DC-MT SERIES

Volume 3



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

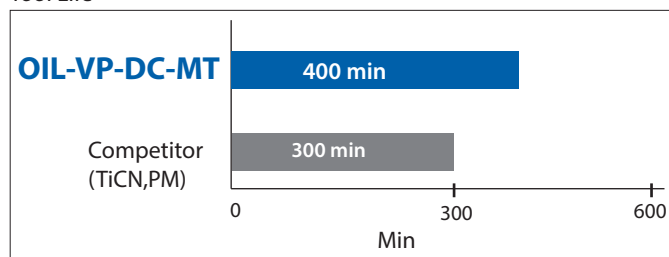
4 Also available with oil hole

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

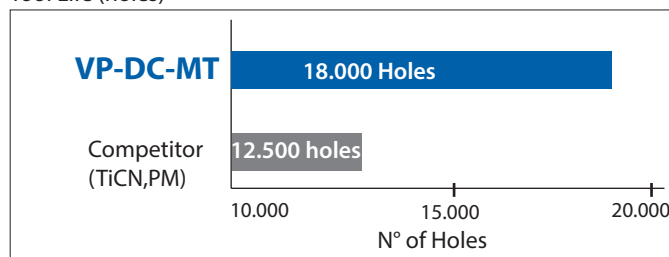
Tool Life



■ 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

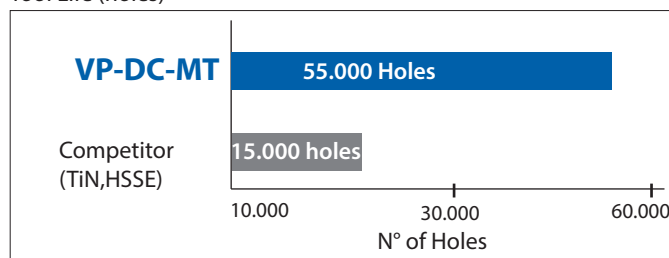
Tool Life (holes)



■ ADC Emulsion

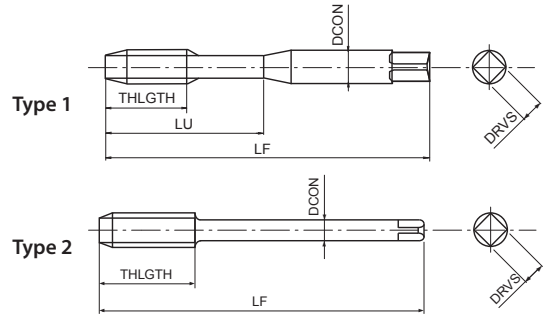
Tool	VP-DC-MT (M10x1,5)
Tapping Length	30 mm
Tapping Speed	30 m/min (955U/min)
Coolant	Emulsion
Machine	Vertical Machining Center

Tool Life (holes)



VP-DC-MT

Threading | Cutting taps | Metric



- Powder metal straight flute cutting tap for through and blind holes
- Multilayer TiCN coating
- For cast iron and aluminium cast
- 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

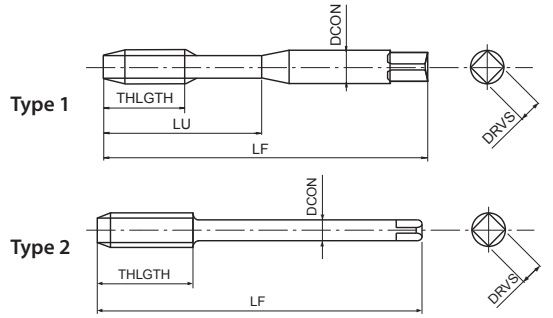
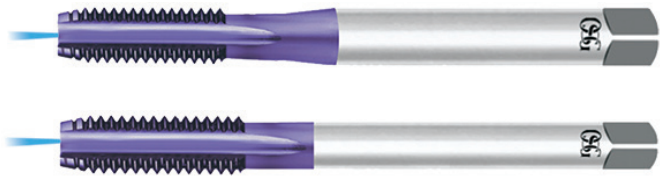
M	PM	V	ISO 2 6HX	C/2,5				DIN 371	DIN 376
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EDP	TD	TP	LF	THLGTH	LU	DCON	DRVS	NOF	Type	DIN
48020125	2	0,4	45	8	10	2,8	2,1	3	1	371
48020133	2,5	0,45	50	9	14	2,8	2,1	3	1	371
48020138	3	0,5	56	6	18	3,5	2,7	3	1	371
48020142	3,5	0,6	56	7	20	4	3	3	1	371
48020144	4	0,7	63	9	21	4,5	3,4	3	1	371
48020149	5	0,8	70	10	25	6	4,9	3	1	371
48020155	6	1	80	12	30	6	4,9	3	1	371
48020158	7	1	80	12	30	7	5,5	4	1	371
48020161	8	1,25	90	15	35	8	6,2	4	1	371
48020169	10	1,5	100	18	39	10	8	4	1	371
48020175	11	1,5	100	18	-	8	6,2	4	2	376
48020179	12	1,75	110	21	-	9	7	4	2	376
48022191	14	2	110	24	-	11	9	4	2	376
48022202	16	2	110	24	-	12	9	4	2	376
48022214	18	2,5	125	30	-	14	11	4	2	376
48022228	20	2,5	140	30	-	16	12	4	2	376
48020238	22	2,5	140	30	-	18	14,5	5	2	376
48020247	24	3	160	36	-	18	14,5	5	2	376
48020271	30	3,5	180	42	-	22	18	6	2	376

Metric

VPO-DC-MT Centre

Threading | Cutting taps | Metric



- Powder metal straight flute cutting tap for blind holes
- Multilayer TiCN coating
- For cast iron and aluminium cast
- 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

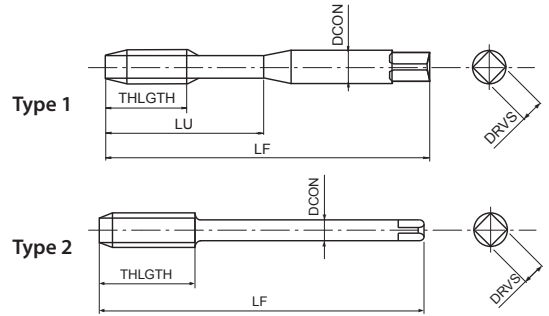
M	PM	V	ISO 2 6HX	C/2,5	≥2D		DIN 371	DIN 376
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EDP	TD	TP	LF	THLGTH	LU	DCON	DRVS	NOF	Type	DIN
48021155	6	1	80	12	30	6	4,9	3	1	371
48021161	8	1,25	90	15	35	8	6,2	4	1	371
48021169	10	1,5	100	18	39	10	8	4	1	371
48300179	12	1,75	110	21	-	9	7	4	2	376
48300191	14	2	110	24	-	11	9	4	2	376
48300202	16	2	110	24	-	12	9	4	2	376
48300214	18	2,5	125	30	-	14	11	4	2	376
48300228	20	2,5	140	30	-	16	12	4	2	376

Metric

VPO-DC-MT Side

Threading | Cutting taps | Metric



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

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	C/2,5			DIN 371	DIN 376
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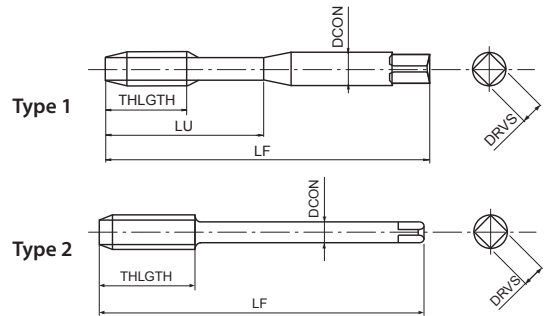
EDP	TD	TP	LF	THLGTH	LU	DCON	DRVS	NOF	Type	DIN
48299155	6	1	80	8	30	6	4,9	3	1	371
48299161	8	1,25	90	10	35	8	6,2	4	1	371
48299169	10	1,5	100	12	39	10	8	4	1	371
48021179	12	1,75	110	21	-	9	7	4	2	376
48024191	14	2	110	24	-	11	9	4	2	376
48024202	16	2	110	24	-	12	9	4	2	376
48024214	18	2,5	125	30	-	14	11	4	2	376
48024228	20	2,5	140	30	-	16	12	4	2	376

Threading | Cutting taps

Metric

VPO-DC-MT FORM E

Threading | Cutting taps | Metric



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

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

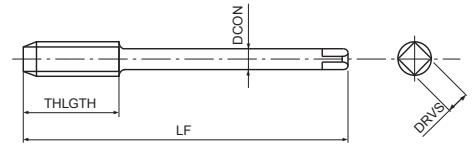
M	PM	V	ISO 2 6HX	E/1,5	≥2D	DIN 371	DIN 376
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EDP	TD	TP	LF	THLGTH	LU	DCON	DRVS	NOF	Type	DIN
48038155	6	1	80	12	30	6	4,9	3	1	371
48038161	8	1,25	90	15	35	8	6,2	4	1	371
48038169	10	1,5	100	18	39	10	8	4	1	371
48038179	12	1,75	110	21	-	9	7	4	2	376
48038191	14	2	110	24	-	11	9	4	2	376
48038202	16	2	110	24	-	12	9	4	2	376
48038214	18	2,5	125	30	-	14	11	4	2	376
48038228	20	2,5	140	30	-	16	12	4	2	376
48038238	22	2,5	140	30	-	18	14,5	5	2	376
48038247	24	3	160	36	-	18	14,5	5	2	376

Metric

VPO-DC-MT Centre

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

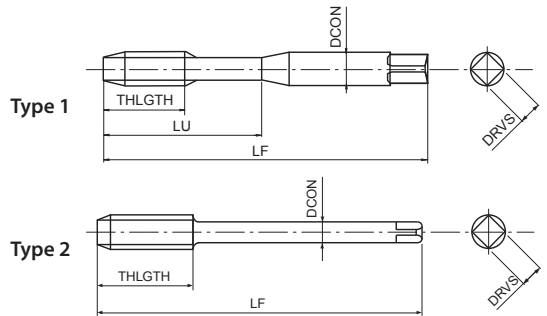
P C ≥ 0,45%	P SCM	K GG	K GGG	N AC, ADC	H 25-35 HRC	H 35-45 HRC	
10-25	10-20	15-60	15-40	25-70	8-20	8-20	m/min
MF	PM	V	ISO 2 6HX	C/2,5	≥2D	DRVS	DIN 374

EDP	TD	TP	LF	THLGTH	DCON	DRVS	NOF	DIN
48024162	8	1	90	15	6	4,9	4	374
48024171	10	1	90	18	7	5,5	4	374
48024170	10	1,25	100	18	7	5,5	4	374
48300181	12	1,25	100	21	9	7	4	374
48300180	12	1,5	100	21	9	7	4	374
48300192	14	1,5	100	24	11	9	4	374
48300203	16	1,5	100	24	12	9	4	374
48300216	18	1,5	110	30	14	11	4	374
48300230	20	1,5	125	30	16	12	4	374

Metric Fine

VP-DC-MT

Threading | Cutting taps | UNC



- 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

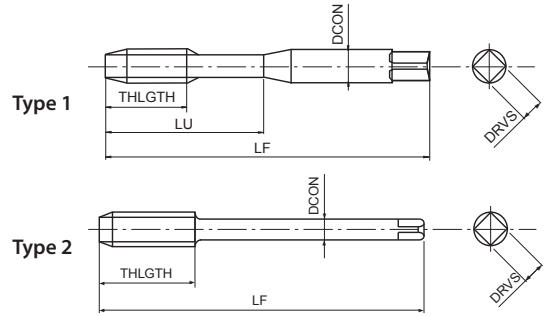
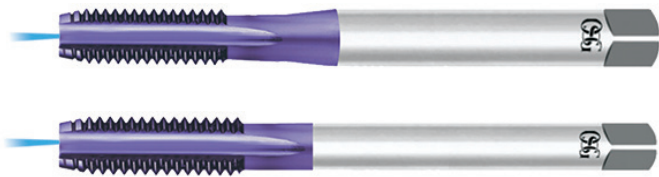
P ○ C ≥ 0,45%	P ○ SCM	K ● GG	K ● GGG	N ● AC, ADC	H ○ 25-35 HRC	H ○ 35-45 HRC		
10-25	10-20	15-60	15-40	25-70	8-20	8-20	m/min	
UNC	PM	V	ANSI 2BX	C/2,5	DIN 2184-1	DIN 2184-1		

EDP	TD	TP	LF	THLGTH	LU	DCON	DRVS	NOF	Type	DIN
48020453	2	56	45	9	14	2,8	2,1	3	1	2184-1
48020455	3	48	50	9	14	2,8	2,1	3	1	2184-1
48020457	4	40	56	8	18	3,5	2,7	3	1	2184-1
48020459	5	40	56	8	18	3,5	2,7	3	1	2184-1
48020461	6	32	56	10	20	4	3	3	1	2184-1
48020464	8	32	63	10	21	4,5	3,4	3	1	2184-1
48020466	10	24	70	13	25	6	4,9	3	1	2184-1
48020468	12	24	80	13	30	6	4,9	3	1	2184-1
48020471	1/4	20	80	16	30	7	5,5	3	1	2184-1
48020474	5/16	18	90	17	35	8	6,2	4	1	2184-1
48020479	3/8	16	100	20	39	10	8	4	1	2184-1
48020484	7/16	14	100	22	-	8	6,2	4	2	2184-1
48020489	1/2	13	110	24	-	9	7	4	2	2184-1
48020494	9/16	12	110	26	-	11	9	4	2	2184-1
48020501	5/8	11	110	28	-	12	9	4	2	2184-1
48020515	3/4	10	125	31	-	14	11	4	2	2184-1
48020526	7/8	9	140	34	-	18	14,5	5	2	2184-1
48020538	1	8	160	38	-	18	14,5	5	2	2184-1

UNC

VPO-DC-MT FORM E NEW

Threading | Cutting taps | UNC



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

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

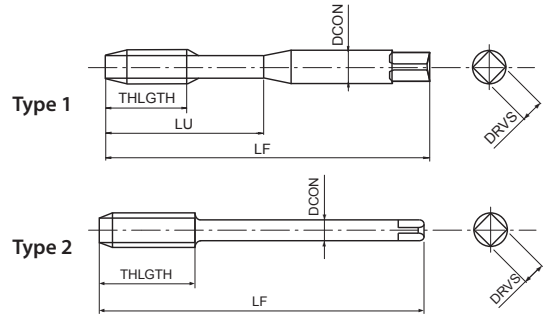
UNC	PM	V	ANSI 2BX				DIN 2184-1	DIN 2184-1
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EDP	TD	TP	LF	THLGTH	LU	DCON	DRVS	NOF	Type	DIN
48379471	1/4	20	80	16	30	7	5,5	3	1	DIN2184-1
48379474	5/16	18	90	17	35	8	6,2	4	1	DIN2184-1
48379479	3/8	16	100	20	39	10	8	4	1	DIN2184-1
48379484	7/16	14	100	22	-	8	6,2	4	2	DIN2184-1
48379489	1/2	13	110	24	-	9	7	4	2	DIN2184-1
48379494	9/16	12	110	26	-	11	9	4	2	DIN2184-1
48379501	5/8	11	110	28	-	12	9	4	2	DIN2184-1
48379515	3/4	10	125	31	-	14	11	4	2	DIN2184-1
48379526	7/8	9	140	34	-	18	14,5	5	2	DIN2184-1
48379538	1	8	160	38	-	18	14,5	5	2	DIN2184-1



VP-DC-MT

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

Threading | Cutting taps

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		

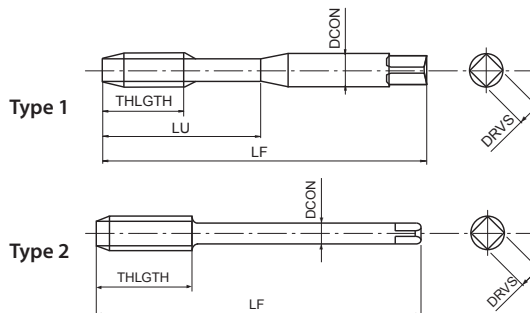
UNF	PM	V	ANSI 2BX	C/2,5			DIN 2184-1	DIN 2184-1
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UNF

EDP	TD	TP	LF	THLGTH	LU	DCON	DRVS	NOF	Type	DIN
48020454	2	64	45	9	14	2,8	2,1	3	1	2184-1
48020456	3	56	50	9	14	2,8	2,1	3	1	2184-1
48020458	4	48	56	8	18	3,5	2,7	3	1	2184-1
48020460	5	44	56	8	18	3,5	2,7	3	1	2184-1
48020462	6	40	56	10	20	4	3	3	1	2184-1
48020465	8	36	63	10	21	4,5	3,4	3	1	2184-1
48020467	10	32	70	13	25	6	4,9	3	1	2184-1
48020469	12	28	80	13	30	6	4,9	3	1	2184-1
48020472	1/4	28	80	16	30	7	5,5	3	1	2184-1
48020476	5/16	24	90	17	35	8	6,2	4	1	2184-1
48020481	3/8	24	90	20	35	10	8	4	1	2184-1
48020486	7/16	20	100	22	-	8	6,2	4	2	2184-1
48020491	1/2	20	100	22	-	9	7	4	2	2184-1
48020496	9/16	18	100	22	-	11	9	4	2	2184-1
48020504	5/8	18	100	22	-	12	9	4	2	2184-1
48020517	3/4	16	110	25	-	14	11	4	2	2184-1
48020528	7/8	14	125	25	-	18	14,5	5	2	2184-1
48020539	1	12	140	28	-	18	14,5	5	2	2184-1

VPO-DC-MT FORM E NEW

Threading | Cutting taps | UNF



- Powder metal straight flute cutting tap for blind holes
- Multilayer TiCN coating
- For cast iron and aluminium cast
- 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	m/min
10-25	10-20	15-60	15-40	25-70	8-20	8-20	

UNF	PM	V	ANSI 2BX	E/1,5	≥2D	DIN 2184-1	DIN 2184-1
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EDP	TD	TP	LF	THLGTH	LU	DCON	DRVS	NOF	Type	DIN
48379472	1/4	28	80	16	30	7	5,5	3	1	DIN2184-1
48379476	5/16	24	90	17	35	8	6,2	4	1	DIN2184-1
48379481	3/8	24	90	20	35	10	8	4	1	DIN2184-1
48379486	7/16	20	100	22	-	8	6,2	4	2	DIN2184-1
48379491	1/2	20	100	22	-	9	7	4	2	DIN2184-1
48379496	9/16	18	100	22	-	11	9	4	2	DIN2184-1
48379504	5/8	18	100	22	-	12	9	4	2	DIN2184-1
48379517	3/4	16	110	25	-	14	11	4	2	DIN2184-1
48379528	7/8	14	125	25	-	18	14,5	5	2	DIN2184-1
48379539	1	12	140	28	-	18	14,5	5	2	DIN2184-1

Threading | Cutting taps

UNF





www.osgeurope.com



SWEDEN

Branch office of OSG SCANDINAVIA
Singelgatan 7
212 28 Malmö
Sweden
Tel: +46 40 41 22 55
osg@osg-scandinavia.com

OSG SCANDINAVIA

(For Scandinavian countries)
Langebjergvaenget 16
4000 Roskilde
Denmark
Tel: +45 46 75 65 55
osg@osg-scandinavia.com

OSG NETHERLANDS

Bedrijfsweg 5
3481 MG Harmelen
The Netherlands
Tel: +31 348 44 2764
info@osg-nl.com

OSG UK

Kelsey Close, Attleborough Fields Ind Est,
CV11 6RS, Nuneaton
United Kingdom
Tel: +44 (0) 1827 720 013
uk_sales@osg-uk.com

OSG EUROPE LOGISTICS

Avenue Lavoisier 1
B-1300 Z.I. Wavre - Nord
Belgium
Tel: +32 10 23 05 07
info@osgeurope.com

OSG BELUX

Avenue Lavoisier 1
B-1300 Z.I. Wavre - Nord
Belgium
Tel: +32 10 23 05 11
info@osg-belgium.com

OSG IBÉRICA

Bekolarra 4
E - 01010 Vitoria-Gasteiz
Spain
Tel: +34 945 242 400
osg.iberica@osg-ib.com

OSG FRANCE

Parc Icade, Paris Nord 2
Immeuble "Le Rimbaud"
22 Avenue des Nations
CS66191 - 93420 Villepinte
France
Tel: +33 1 49 90 10 10
sales@osg-france.com

OSG ITALY

Via Ferrero, 65 A/B
I - 10098 Rivoli
Italy
Tel: +39 0117705211
info@osg-italia.it



OSG IN EUROPE

CZECH REPUBLIC, SLOVAKIA, HUNGARY

OSG Europe Logistics S.A.
Slovakia, organizačná zložka
Račianska 22/A, Bratislava 831 02
Slovakia
Tel.: +421 24 32 91 295
info@osgeurope.com

OSG POLAND

ul. Spółdzielcza 57
05-074 Halinów
Polska
Tel: +22 760 82 71
Mob. +48 570 677 711
osg@osg-poland.com

OSG ROMANIA SRL

25C, Bucuresti-Magurele Street (Sector 5)
051431 Bucuresti
România
Tel: +40 21 322 07 47
info@osgromania.ro

OSG TURKEY

Rami Kişla Cad.No:56 Eyüp
Istanbul 34056
Turkey
Tel: +90 212 565 24 00
Fax: +90 212 565 44 00
info@osg-turkey.com

Vischer & Bolli AG

Machining and Workholding
Im Schossacher 17
CH-8600 Dübendorf
Switzerland
Tel.: +41 44 802 15 15
info@vb-tools.com

OSG GERMANY

Karl-Ehmann-Str. 25
D - 73037 Göppingen
Germany
Tel: +49 7161 6064 - 0
Fax: +49 7161 6064 - 444
info@osg-germany.de



shaping your dreams

OSG EUROPE LOGISTICS

Avenue Lavoisier 1
B-1300 Z.I. Wavre - Nord - Belgium
Tel: +32 10 23 05 07
info@osgeurope.com

OSG POLAND Sp. z o.o.

Spółdzielcza 57
05-074 Halinów - Poland
Tel: +22 760 82 71
osg@osg-poland.com

OSG ROMANIA SRL

25C, Bucuresti-Magurele Street (Sector 5)
051431 Bucuresti - România
Tel: +40 21 322 07 47
info@osgromania.ro

OSG BELUX

Avenue Lavoisier 1
B-1300 Z.I. Wavre - Nord - Belgium
Tel: +32 10 23 05 11
info@osg-belgium.com

OSG GERMANY

Karl-Ehmann-Str. 25
D - 73037 Göppingen - Germany
Tel: +49 7161 6064 - 0
Fax: +49 7161 6064 - 444
info@osg-germany.de

AUSTRIA

Branch office of OSG GERMANY
Messestraße 11
A-6850 Dornbirn
Tel: +49 7161 6064-0
info@osg-germany.de

OSG FRANCE

Parc Icade, Paris Nord 2
Immeuble "Le Rimbaud"
22 Avenue des Nations
CS66191 - 93420 Villepinte - France
Tel: +33 1 49 90 10 10
sales@osg-france.com

OSG SCANDINAVIA

(For Scandinavian countries)
Langebjergvaenget 16
4000 Roskilde - Denmark
Tel: +45 46 75 65 55
osg@osg-scandinavia.com

OSG ITALIA

Via Ferrero, 65 A/B3
I - 10098 Rivoli - Italy
Tel: +39 0117705211
info@osg-italia.it

OSG NETHERLANDS

Bedrijfsweg 5 - 3481 MG Harmelen
Tel: +31 348 44 2764
info@osg-nl.com

SWEDEN

Branch office of OSG SCANDINAVIA
Singelgatan 7
212 28 Malmö - Sweden
Tel: +46 40 41 22 55
osg@osg-scandinavia.com

Vischer & Bolli AG

Machining and Workholding
Im Schossacher 17
CH-8600 Dübendorf
T +41 44 802 15 15
info@vb-tools.com

OSG UK

Kelsey Close, Attleborough Fields Ind Est,
CV11 6RS, Nuneaton, United Kingdom.
Tel: +44 1827 720 013
uk_sales@osg-uk.com

OSG IBERICA

Bekolarra 4
E - 01010 Vitoria-Gasteiz - Spain
Tel: +34 945 242 400
osg.iberica@osg-ib.com

CZECH, SLOVAKIA, HUNGARY

OSG Europe Logistics S.A.
Slovakia organizacna zlozka
Racianská 22/A, SK-83102 Bratislava
Slovakia
Tel. +421 24 32 91 295
Orders-osgsvk@osgeurope.com

OSG TURKEY

Rami Kışla Cad.No:56 Eyüp
Istanbul 34056 - Turkey
Tel+90 212 565 24 00
Fax: +90 212 565 44 00
info@osg-turkey.com

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