



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

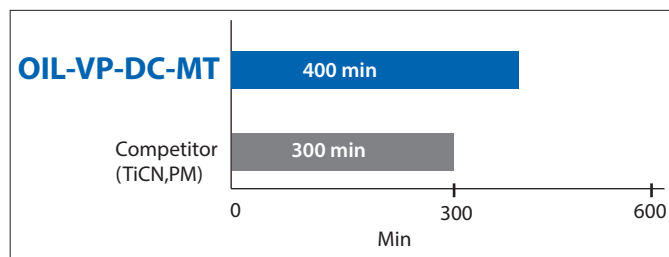
**4** Also available with oil hole

# 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

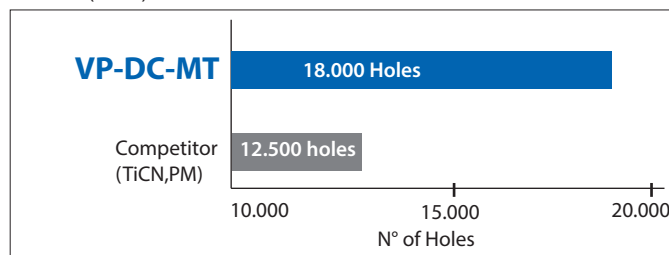
Tool Life



## ■ 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

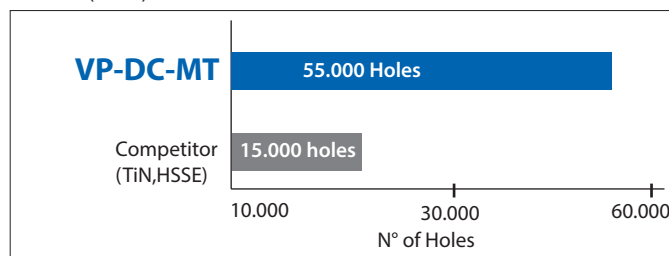
Tool Life (holes)



## ■ 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)



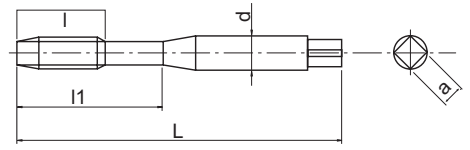
# VP-DC-MT NEW SIZES

New sizes available from December 2017

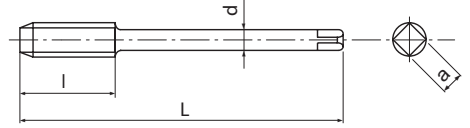
Threading | Cutting taps | Metric



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

Threading | Cutting taps

<b>P</b> ○	<b>P</b> ○	<b>K</b> ○	<b>K</b> ○	<b>N</b> ○	<b>H</b> ○	<b>H</b> ○	
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

<b>M</b>	<b>PM</b>	<b>V</b>	<b>ISO 2 6HX</b>	<b>C/2,5</b>			<b>DIN 371</b>	<b>DIN 376</b>
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Metric

EDP	M	P	L	l	l1	d	a	Z	Type	DIN
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

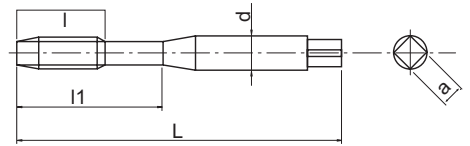
# VP-DC-MT FORM E NEW SIZES

New sizes available from December 2017

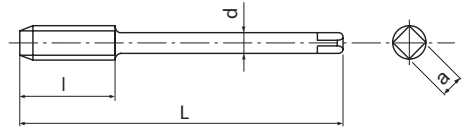
Threading | Cutting taps | Metric



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

<b>P</b>	<b>P</b>	<b>K</b>	<b>K</b>	<b>N</b>	<b>H</b>	<b>H</b>	
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

<b>M</b>	<b>PM</b>	<b>V</b>	<b>ISO 2 6HX</b>				
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EDP	M	P	L	l	l1	d	a	Z	Type	DIN
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





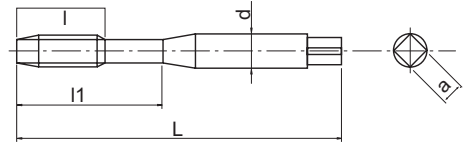
# VPO-DC-MT Side NEW SIZES

New sizes available from December 2017

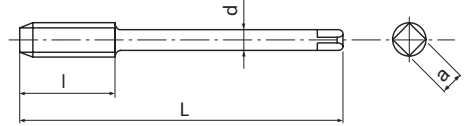
Threading | Cutting taps | Metric



Type 1



Type 2



- 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

<b>P</b>	<b>P</b>	<b>K</b>	<b>K</b>	<b>N</b>	<b>H</b>	<b>H</b>	
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

<b>M</b>	<b>PM</b>	<b>V</b>	<b>ISO 2 6HX</b>	<b>C/2,5</b>			<b>DIN 371</b>	<b>DIN 376</b>
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EDP	M	P	L	l	l1	d	a	Z	Type	DIN
48299155 <small>NEW</small>	6	1	80	8	30	6	4,9	3	1	DIN371
48299161 <small>NEW</small>	8	1.25	90	10	35	8	6,2	3	1	DIN371
48299169 <small>NEW</small>	10	1.5	100	12	39	10	8	3	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

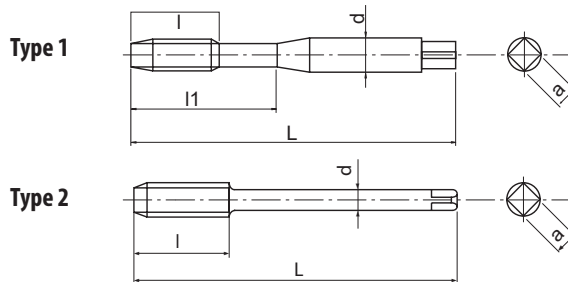
Threading | Cutting taps

Metric

# VPO-DC-MT FORM E NEW SIZES

New sizes available from January 2018

Threading | Cutting taps | Metric



- 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

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

<b>M</b>	<b>PM</b>	<b>V</b>	<b>ISO 2 6HX</b>	<b>E/1,5</b>	<b>≥2D</b>	<b>DIN 371</b>	<b>DIN 376</b>
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EDP	M	P	L	l	l1	d	a	Z	Type	DIN
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

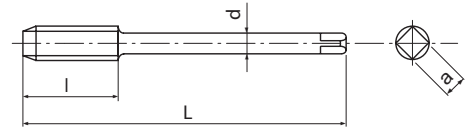
Threading | Cutting taps

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

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

<b>MF</b>	<b>PM</b>	<b>V</b>	<b>ISO 2 6HX</b>	<b>C/2,5</b>			<b>DIN 374</b>
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EDP	MF	P	L	l	d	a	Z	DIN
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

Threading | Cutting taps

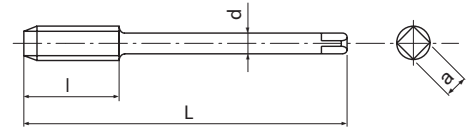


Metric Fine

# VPO-DC-MT Center NEW SIZES












New sizes  
available from January 2018

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

<b>P</b>  >0.45%	<b>P</b>  SCM	<b>K</b>  GG	<b>K</b>  GGG	<b>N</b>  AC,ADC	<b>H</b>  25-35 HRC	<b>H</b>  35-45 HRC		
10-25	10-20	15-60	15-40	25-70	8-20	8-20	m/min	
<b>MF</b>	<b>PM</b>	<b>V</b>	<b>ISO 2 6HX</b>	 C/2,5	 ≥2D		 DIN 374	

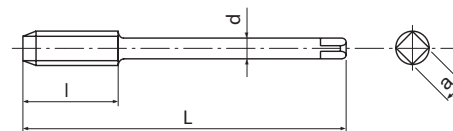
EDP	MF	P	L	l	d	a	Z	DIN
48024162	8	1	90	15	6	4,9	4	DIN374
48024171	10	1	90	18	7	5,5	4	DIN374
48024170	10	1,25	100	18	7	5,5	4	DIN374
48300181 <small>NEW</small>	12	1,25	100	21	9	7	4	DIN374
48300180 <small>NEW</small>	12	1,5	100	21	9	7	4	DIN374
48300192 <small>NEW</small>	14	1,5	100	24	11	9	4	DIN374
48300203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

Metric Fine

# VPO-DC-MT Side NEW SIZES

New sizes available from January 2018

Threading | Cutting taps | Metric Fine



- 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

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

<b>MF</b>	<b>PM</b>	<b>V</b>	<b>ISO 2 6HX</b>	<b>C/2,5</b>			<b>DIN 374</b>
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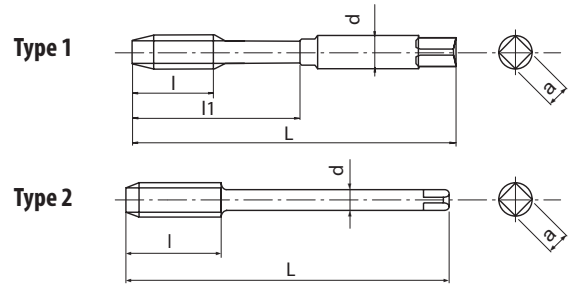
EDP	MF	P	L	l	d	a	Z	DIN
48299162 <small>NEW</small>	8	1	90	15	6	4,9	4	DIN374
48299171 <small>NEW</small>	10	1	90	18	7	5,5	4	DIN374
48299170 <small>NEW</small>	10	1,25	100	18	7	5,5	4	DIN374
48024181	12	1.25	100	21	9	7	4	DIN374
48024180	12	1.5	100	21	9	7	4	DIN374
48024192	14	1.5	100	24	11	9	4	DIN374
48024203	16	1.5	100	24	12	9	4	DIN374
48024216	18	1.5	110	30	14	11	4	DIN374
48024230	20	1.5	125	30	16	12	4	DIN374

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

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

<b>UNF</b>	<b>PM</b>	<b>V</b>	<b>ANSI 2BX</b>	<b>C/2,5</b>			<b>DIN 2184-1</b>	<b>DIN 2184-1</b>
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EDP	UNF	P	L	l	l1	d	a	Z	Type	DIN
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







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shaping your dreams

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