



the answer is

A

SERIES



OSG's new premium brand "A-Series Taps"

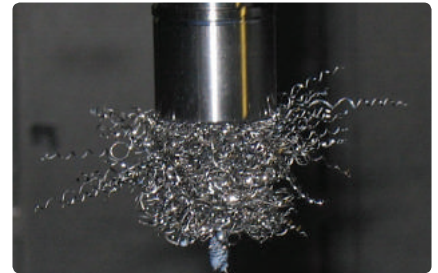
Tapping problems are now a thing of the past



Most tapping problems are caused by unstable chip evacuation.

A-Series taps resolve such issues and can be applied to a wide range of work materials and cutting speeds.

TAPPING PROBLEMS		
N°1	BREAKAGE & CHIPPING	26 %
N°2	DIMENSIONAL ERROR	17 %
N°3	GALLING	14 %
	Others	43 %



Stable chip shape,
Sharp cutting edge

Faster chip evacuation,
Variable lead flute (PAT.)

High wear resistance
V coating

High wear resistance
Powder Metallurgy
HSS (CPM)

The A-TAP advantage !

From mild steel to stainless steel

No galling

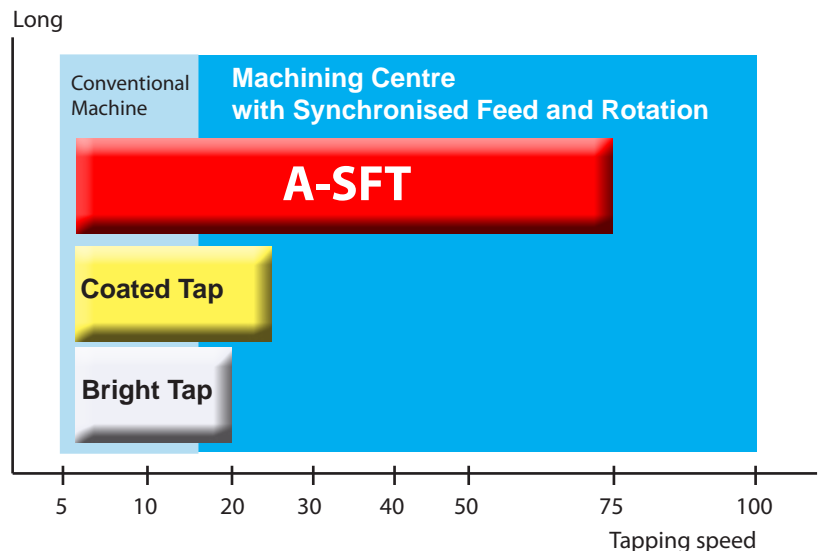


Work Material
Mild steel



Work Material
Stainless steel

Stable machining over a wide cutting range



- Tapping in medium and high carbon steel with water soluble coolant.

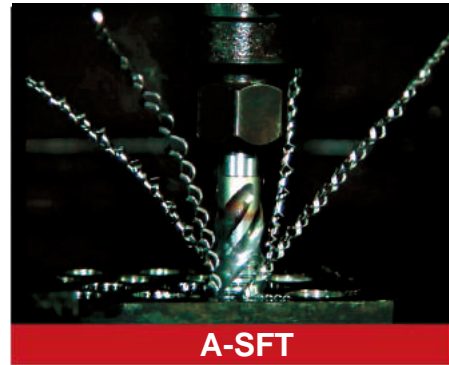
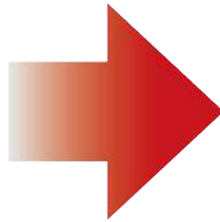
- A machining centre with synchronised feed and rotation is recommended for more than 15m/min.

A-TAP Series for....

Better chip evacuation & longer tool life



Conventional Tap



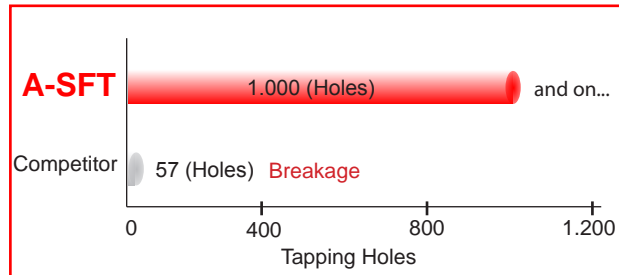
A-SFT

The A-TAP advantage !

■ 304 Stainless

Deep Hole Tapping (2D) 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 ⁻¹)
Coolant	Water Soluble Chlorine-Free (10%)
Machine	Vertical Synchronised Machining Centre



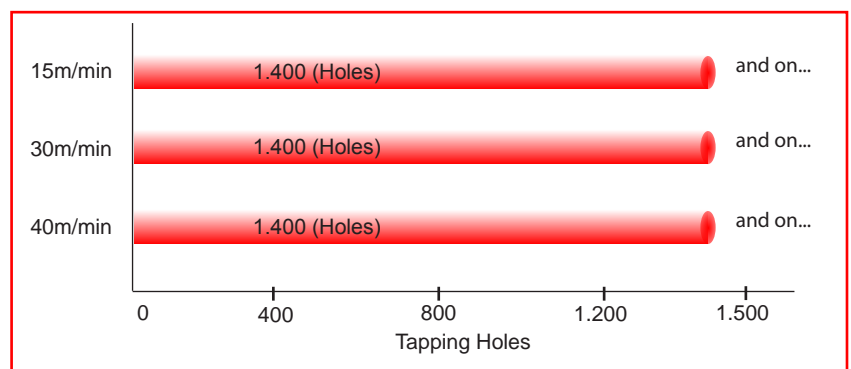
■ Cutting edge after 1.000 holes Tapping

■ S45C (Medium Strength Mild Steel)

High speed tapping by machining centre

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

Stable tapping achieved at 15, 30 & 40m/min



■ Cutting edge after 1.400 holes Tapping



15m/min

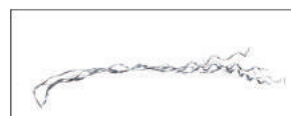


30m/min

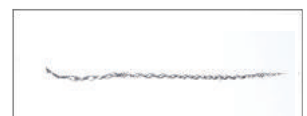


40m/min

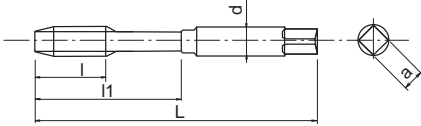
■ Chip generated at 40m/min



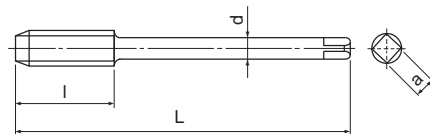
Conventional Tap



A-SFT



EDP	Dimensions								Price
	D	P	L	l	l1	d	a	No.Flutes	
48139125	2	0,4	45	3,2	10	2,8	2,1	2	£21.61
48139133	2,5	0,45	50	3,6	13	2,8	2,1	2	£21.45
48139138	3	0,5	56	4	18	3,5	2,7	3	£18.83
48139144	4	0,7	63	5,6	21	4,5	3,4	3	£19.40
48139149	5	0,8	70	6,4	25	6	4,9	3	£19.81
48139155	6	1	80	8	30	6	4,9	3	£19.98
48139161	8	1,25	90	10	35	8	6,2	3	£23.99
48139169	10	1,5	100	12	39	10	8	3	£29.23



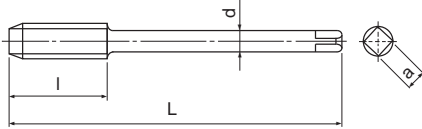
EDP	Dimensions								Price
	D	P	L	l	d	a	No.Flutes		
48139179	12	1,75	110	14	9	7	3	£36.68	
48139191	14	2	110	16	11	9	3	£43.47	
48139202	16	2	110	16	12	9	3	£51.09	
48139214	18	2,5	125	25	14	11	4	£69.26	
48139228	20	2,5	140	25	16	12	4	£81.87	
48139238	22	2,5	140	25	18	14,5	4	£89.57	
48139247	24	3	160	30	18	14,5	4	£109.96	

⊙ EXCELLENT ○ GOOD

Work Material												
C<0,2%	0,25<C<0,4%	C>0,45%	Alloy Steels	25~35 HRC	35~45 HRC	45~52 HRC	52~62 HRC	Stainless	Tool Steel	SC	Cast Iron	Ductile
⊙ 15-60 m/min	⊙ 15-60 m/min	⊙ 10-60 m/min	⊙ 8-30 m/min	○ 8-20 m/min				⊙ 8-20 m/min				
Copper	Brass	BsC	PB	Aluminium	Cast Al	MC	Zinc Alloy	Titanium	Ni Alloys	Plastic	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	



METRIC FINE



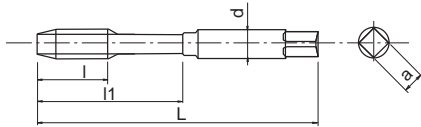
EDP	Dimensions							Price
	D	P	L	l	d	a	No.Flutes	
48139156	6	0,75	80	8	4,5	3,4	3	£28.08
48139163	8	0,75	80	8	6	4,9	3	£29.72
48139162	8	1	90	10	6	4,9	3	£31.28
48139171	10	1	90	10	7	5,5	3	£32.99
48139170	10	1,25	100	12	7	5,5	3	£32.34
48139182	12	1	100	12	9	7	3	£37.91
48139181	12	1,25	100	12	9	7	3	£37.91
48139180	12	1,5	100	14	9	7	3	£39.46
48139192	14	1,5	100	16	11	9	3	£48.80
48139203	16	1,5	100	16	12	9	3	£56.57
48139216	18	1,5	110	16	14	11	4	£65.17
48139230	20	1,5	125	16	16	12	4	£81.71
48139240	22	1,5	125	16	18	14,5	4	£84.66
48139250	24	1,5	140	16	18	14,5	4	£111.18

⊙ EXCELLENT ○ GOOD

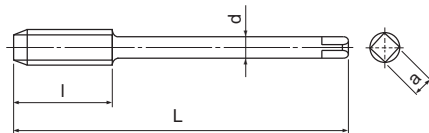
Work Material												
C<0,2%	0,25<C<0,4%	C>0,45%	Alloy Steels	25~35 HRC	35~45 HRC	45~52 HRC	52~62 HRC	Stainless	Tool Steel	SC	Cast Iron	Ductile
⊙ 15-60 m/min	⊙ 15-60 m/min	⊙ 10-60 m/min	⊙ 8-30 m/min	○ 8-20 m/min				⊙ 8-20 m/min				
Copper	Brass	BsC	PB	Aluminium	Cast Al	MC	Zinc Alloy	Titanium	Ni Alloys	Plastic	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	

A OIL-SFT

METRIC



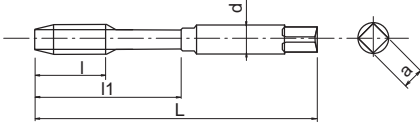
EDP	Dimensions								Price
	D	P	L	l	l1	d	a	No.Flutes	
48140155	6	1	80	8	30	6	4,9	3	£32.75
48140161	8	1,25	90	10	35	8	6,2	3	£37.01
48140169	10	1,5	100	12	39	10	8	3	£41.18



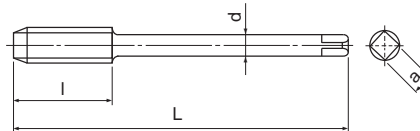
EDP	Dimensions								Price
	D	P	L	l	d	a	No.Flutes		
48140179	12	1,75	110	14	9	7	3	£52.48	
48140191	14	2	110	16	11	9	3	£58.70	
48140202	16	2	110	16	12	9	3	£66.73	

⊙ EXCELLENT ○ GOOD

Work Material												
C<0,2%	0,25<C<0,4%	C>0,45%	Alloy Steels	25~35 HRC	35~45 HRC	45~52 HRC	52~62 HRC	Stainless	Tool Steel	SC	Cast Iron	Ductile
⊙ 15-60 m/min	⊙ 15-60 m/min	⊙ 10-60 m/min	⊙ 8-30 m/min	○ 8-20 m/min				⊙ 8-20 m/min				
Copper	Brass	BsC	PB	Aluminium	Cast Al	MC	Zinc Alloy	Titanium	Ni Alloys	Plastic	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	



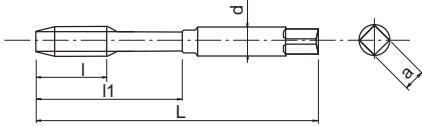
EDP	Dimensions								Price
	UNC	P	L	l	l1	d	a	No.Flutes	
48139457	4	40	56	5,1	18	3,5	2,7	2	£25.46
48139459	5	40	56	5,1	18	3,5	2,7	2	£25.46
48139461	6	32	56	6,4	20	4	3	2	£24.15
48139464	8	32	63	6,4	21	4,5	3,4	2	£24.15
48139466	10	24	70	8,5	25	6	4,9	2	£25.46
48139471	1/4	20	80	10,2	30	7	5,5	2	£28.08
48139474	5/16	18	90	11,3	35	8	6,2	3	£29.47
48139479	3/8	16	100	12,7	39	10	8	3	£32.50



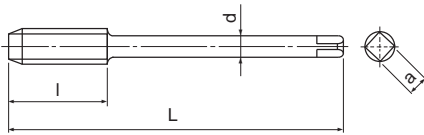
EDP	Dimensions								Price
	UNC	P	L	l	d	a	No.Flutes		
48139484	7/16	14	100	14,5	8	6,2	3	£42.90	
48139489	1/2	13	110	15,6	9	7	3	£44.29	
48139501	5/8	11	110	18,5	12	9	3	£59.28	
48139515	3/4	10	125	25,4	14	11	4	£73.44	
48139526	7/8	9	140	28,2	18	14,5	4	£93.01	
48139538	1	8	160	31,8	18	14,5	4	£123.38	

⊙ EXCELLENT ○ GOOD

Work Material												
C<0,2%	0,25<C<0,4%	C>0,45%	Alloy Steels	25~35 HRC	35~45 HRC	45~52 HRC	52~62 HRC	Stainless	Tool Steel	SC	Cast Iron	Ductile
⊙ 15-60 m/min	⊙ 15-60 m/min	⊙ 10-60 m/min	⊙ 8-30 m/min	○ 8-20 m/min				⊙ 8-20 m/min				
Copper	Brass	BsC	PB	Aluminium	Cast Al	MC	Zinc Alloy	Titanium	Ni Alloys	Plastic	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	



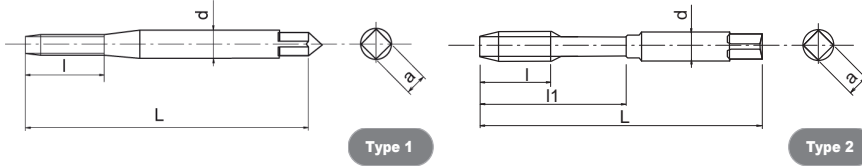
EDP	Dimensions								Price
	UNF	P	L	l	l1	d	a	No.Flutes	
48139462	6	40	56	6,4	20	4	3	2	£33.98
48139467	10	32	70	8,5	25	6	4,9	2	£35.21
48139472	1/4	28	80	10,2	30	7	5,5	2	£39.71
48139476	5/16	24	90	11,3	35	8	6,2	3	£41.76
48139481	3/8	24	90	12,7	35	10	8	3	£42.74



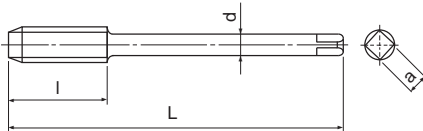
EDP	Dimensions								Price
	UNF	P	L	l	d	a	No.Flutes		
48139486	7/16	20	100	14,5	8	6,2	3	£46.09	
48139491	1/2	20	100	15,6	9	7	3	£45.60	
48139496	9/16	18	100	16,9	11	9	3	£53.05	
48139504	5/8	18	100	18,5	12	9	3	£60.50	
48139517	3/4	16	110	25,4	14	11	4	£78.02	
48139528	7/8	14	125	28,2	18	14,5	4	£95.79	
48139539	1	12	140	31,8	18	14,5	4	£133.21	

⊙ EXCELLENT ○ GOOD

Work Material												
C<0,2%	0,25<C<0,4%	C>0,45%	Alloy Steels	25~35 HRC	35~45 HRC	45~52 HRC	52~62 HRC	Stainless	Tool Steel	SC	Cast Iron	Ductile
⊙ 15-60 m/min	⊙ 15-60 m/min	⊙ 10-60 m/min	⊙ 8-30 m/min	○ 8-20 m/min				⊙ 8-20 m/min				
Copper	Brass	BsC	PB	Aluminium	Cast Al	MC	Zinc Alloy	Titanium	Ni Alloys	Plastic	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	



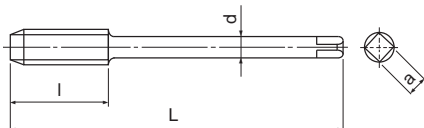
EDP	Dimensions									Price
	D	P	L	l	l1	d	a	No.Flutes	Type	
48145125	2	0,4	45	8	n/a	2,8	2,1	2	1	£21.12
48145133	2,5	0,45	50	9	n/a	2,8	2,1	2	1	£20.88
48145138	3	0,5	56	11	18	3,5	2,7	3	2	£18.26
48145144	4	0,7	63	13	21	4,5	3,4	3	2	£18.75
48145149	5	0,8	70	16	25	6	4,9	3	2	£19.24
48145155	6	1	80	19	30	6	4,9	3	2	£19.49
48145161	8	1,25	90	22	35	8	6,2	3	2	£23.33
48145169	10	1,5	100	24	39	10	8	3	2	£28.49



EDP	Dimensions							Price
	D	P	L	l	d	a	No.Flutes	
48145179	12	1,75	110	29	9	7	3	£35.86
48145191	14	2	110	30	11	9	3	£42.74
48145202	16	2	110	32	12	9	3	£50.27
48145214	18	2,5	125	34	14	11	3	£67.95
48145228	20	2,5	140	34	16	12	3	£80.48
48145238	22	2,5	140	34	18	14,5	3	£87.77
48145247	24	3	160	38	18	14,5	3	£107.83

⊙ EXCELLENT ○ GOOD

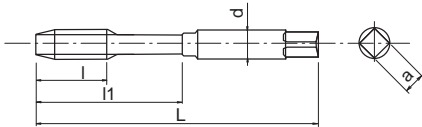
Work Material												
C<0,2%	0,25<C<0,4%	C>0,45%	Alloy Steels	25~35 HRC	35~45 HRC	45~52 HRC	52~62 HRC	Stainless	Tool Steel	SC	Cast Iron	Ductile
⊙ 15~60 m/min	⊙ 15~60 m/min	⊙ 10~60 m/min	⊙ 8~30 m/min	○ 8~20 m/min				⊙ 8~20 m/min				
Copper	Brass	BsC	PB	Aluminium	Cast Al	MC	Zinc Alloy	Titanium	Ni Alloys	Plastic	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	



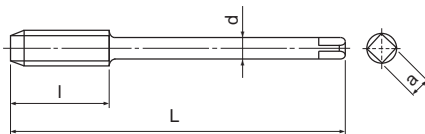
EDP	Dimensions							Price
	D	P	L	l	d	a	No.Flutes	
48145156	6	0,75	80	13	4,5	3,4	3	£27.26
48145163	8	0,75	80	19	6	4,9	3	£28.82
48145162	8	1	90	22	6	4,9	3	£30.37
48145171	10	1	90	20	7	5,5	3	£31.93
48145170	10	1,25	100	24	7	5,5	3	£31.36
48145182	12	1	100	22	9	7	3	£36.76
48145181	12	1,25	100	22	9	7	3	£36.76
48145180	12	1,5	100	22	9	7	3	£38.32
48145192	14	1,5	100	22	11	9	4	£47.40
48145203	16	1,5	100	22	12	9	4	£54.85
48145216	18	1,5	110	25	14	11	4	£63.29
48145230	20	1,5	125	25	16	12	4	£79.33
48145240	22	1,5	125	25	18	14,5	4	£82.04
48145250	24	1,5	140	28	18	14,5	4	£107.83

⊙ EXCELLENT ○ GOOD

Work Material												
C<0,2%	0,25<C<0,4%	C>0,45%	Alloy Steels	25~35 HRC	35~45 HRC	45~52 HRC	52~62 HRC	Stainless	Tool Steel	SC	Cast Iron	Ductile
⊙ 15-60 m/min	⊙ 15-60 m/min	⊙ 10-60 m/min	⊙ 8-30 m/min	○ 8-20 m/min				⊙ 8-20 m/min				
Copper	Brass	BsC	PB	Aluminium	Cast Al	MC	Zinc Alloy	Titanium	Ni Alloys	Plastic	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	



EDP	Dimensions								Price
	UNC	P	L	l	l1	d	a	No.Flutes	
48145457	4	40	56	11	18	3,5	2,7	2	£20.96
48145459	5	40	56	11	18	3,5	2,7	3	£20.96
48145461	6	32	56	12	20	4	3	3	£19.90
48145464	8	32	63	13	21	4,5	3,4	3	£19.90
48145466	10	24	70	16	25	6	4,9	3	£20.96
48145471	1/4	20	80	19	30	7	5,5	3	£22.35
48145474	5/16	18	90	22	35	8	6,2	3	£25.13
48145479	3/8	16	100	24	39	10	8	3	£28.16



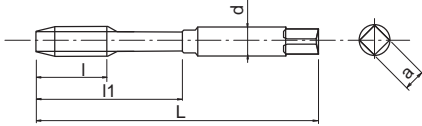
EDP	Dimensions								Price
	UNC	P	L	l	d	a	No.Flutes		
48145484	7/16	14	100	24	8	6,2	3	£34.22	
48145489	1/2	13	110	28	9	7	3	£37.50	
48145494	9/16	12	110	30	11	9	3	£41.92	
48145501	5/8	11	110	32	12	9	3	£46.09	
48145515	3/4	10	125	34	14	11	3	£62.31	
48145526	7/8	9	140	34	18	14,5	3	£75.57	
48145538	1	8	160	38	18	14,5	3	£98.90	

⊙ EXCELLENT ○ GOOD

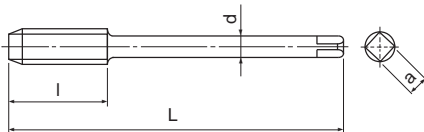
Work Material												
C<0,2%	0,25<C<0,4%	C>0,45%	Alloy Steels	25~35 HRC	35~45 HRC	45~52 HRC	52~62 HRC	Stainless	Tool Steel	SC	Cast Iron	Ductile
⊙ 15-60 m/min	⊙ 15-60 m/min	⊙ 10-60 m/min	⊙ 8-30 m/min	○ 8-20 m/min				⊙ 8-20 m/min				
Copper	Brass	BsC	PB	Aluminium	Cast Al	MC	Zinc Alloy	Titanium	Ni Alloys	Plastic	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	



UNF



EDP	Dimensions								Price
	UNF	P	L	l	l1	d	a	No.Flutes	
48145462	6	40	56	12	20	4	3	3	£27.75
48145467	10	32	70	16	25	6	4,9	3	£28.25
48145472	1/4	28	80	19	30	7	5,5	3	£30.70
48145476	5/16	24	90	22	35	8	6,2	3	£32.83
48145481	3/8	24	90	20	35	10	8	3	£35.53



EDP	Dimensions							Price
	UNF	P	L	l	d	a	No.Flutes	
48145486	7/16	20	100	24	8	6,2	3	£44.78
48145491	1/2	20	100	22	9	7	3	£42.49
48145496	9/16	18	100	22	11	9	3	£50.27
48145504	5/8	18	100	22	12	9	3	£58.13
48145517	3/4	16	110	25	14	11	3	£74.75
48145528	7/8	14	125	25	18	14,5	3	£94.56
48145539	1	12	140	28	18	14,5	3	£125.43

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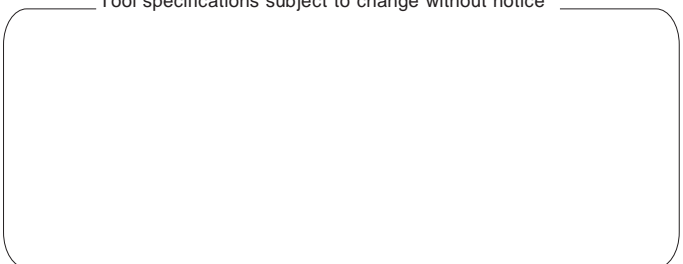
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