



OSG's A Brand Tap Lineup

Vol 4

A-TAPS

AT-1 • AT-2 • AT-2 R-Spec • A-XPF • A-LT-XPF • A-XPF-STI • A-CSF • A-CHT • A-SFT
A-OIL-SFT • A-LT-SFT • A-POT • A-OIL-POT • A-LT-POT • A-NPT • A-LT-NPT
A-BSPP-RP A-BSPP-G • A-BSPT • A-NPS • A-NPTF



NEW Form Taps!
A-XPF, A-LT-XPF & A-XPF-STI



A-Taps

Taps Designed with A Brand Values in Mind

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A Brand AT-1

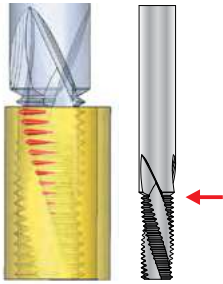
Features & Benefits

1-Pass Cutting

Left Hand Helix Reduces Deflection for 1-Pass Cutting

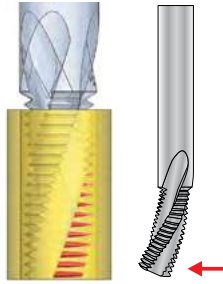
The AT-1 is designed with a left hand helix and starts cutting from the shank side, reducing deflection, preventing bending, thus allowing for 1-pass cutting and reducing overall cutting time.

AT-1 Left Hand Helix



Starts cutting from the shank side
Result: Reduced deflection
Note: Climb milling recommended

Conventional Right Hand Helix



Starts cutting from the tip
Result: Big deflection

**Unequal Spacing/
Variable Lead Flute**
for reduced vibration

**Right-Hand Cut &
Left-Hand Helix
Geometry**
increases tool stability

EgiAs Coating
for exceptional wear
resistance

**Ultra-Fine Grain
Carbide**
for high wear resistance and
toughness

Superior Internal Threads

Superior Threads Made in Just 1-Pass

Tool	AT-1 (List 16620)	Conventional
Size	Ø19.7mm • 54mm Length of Cut	
Thread Size	M24 x 3	
Work Material	304 Stainless Steel	
Tapping Depth	45mm (full depth)	
Cutting Speed	131 SFM (646 RPM)	
Feed	5.9 IPM (0.0016 IPT)	
Number of Passes	1	2
Coolant	Water-Soluble	
Machine	Horizontal Machining Center	



AT-1
1-Pass



Conventional
2-Pass



Effects of Left-Hand Helix

Alloy Steel (4140)

The AT-1 threadmill is designed with a left-hand helix for a small pitch diameter difference between the hole entry and the bottom of the hole, allowing a delay in gauge-out failure. Longer tool life can be achieved with elimination of "zero cutting" for correcting bending.

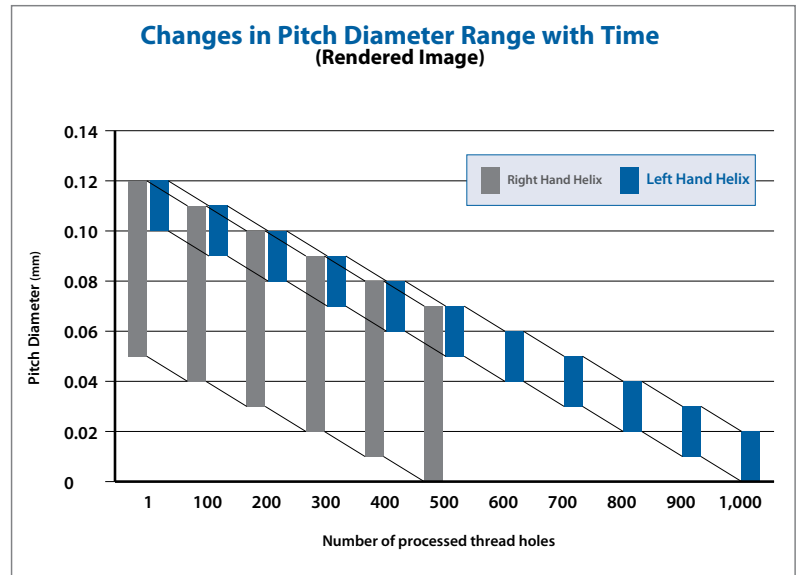
Tool	AT-1 (List 16620)	Conventional
Size	Ø7.7mm • 22mm Length of Cut	
Thread Size	M10 x 1	
Work Material	4140 Alloy Steel	
Tapping Depth	15mm (Blind)	
Cutting Speed	328 SFM (4,136 RPM)	
Feed	15 IPM (0.0009 IPT)	
Number of Passes	1	
Coolant	Water-Soluble	
Machine	Vertical Machining Center	

Right & Left-Hand Helix Comparison Internal Thread Pitch Dia. at Initial Cutting Stage

Unit: mm

	Hole Entry	Inner Hole Area	Dia. Difference
Right-Hand Helix	+0.120 ~ +0.140	+0.040 ~ +0.060	0.060 ~ 0.100
Left-Hand Helix	+0.120 ~ +0.140	+0.120 ~ +0.140	0 ~ 0.020

Pitch Diameter Measurement Method: Step Gauge

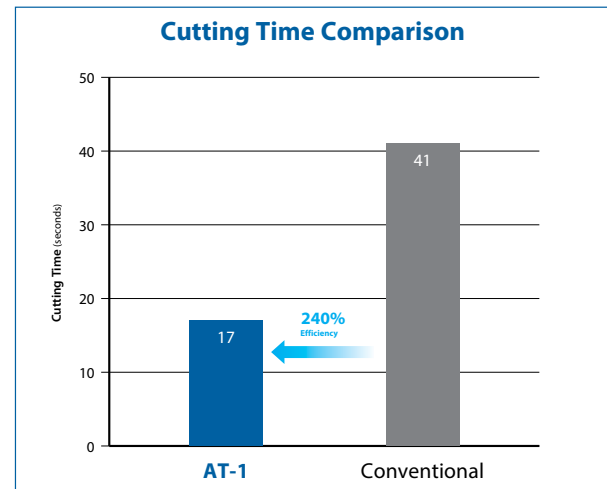


Twice as Fast as Conventional Threadmills

304 Stainless Steel

When processing the same number of thread holes, the AT-1 completed the job in less than half the time of the conventional tool.

Tool	AT-1 (List 16620)	Conventional
Size	Ø9.7mm • 27mm Length of Cut	
Thread Size	M12 x 1.5	
Work Material	304 Stainless Steel	
Tapping Depth	22.5 mm (Through Hole)	
Cutting Speed	328 SFM (3,283 RPM)	393 SFM (4,021 RPM)
Feed	0.49 IPM (0.0004 IPT)	1.65 IPM (0.0004 IPT)
Number of Passes	1	2
Coolant	Water-Soluble	
Machine	Vertical Machining Center	

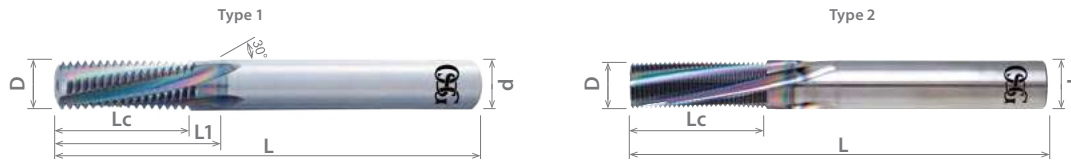


A Brand AT-1

Advanced Performance One Pass Thread Mill

List 16625

A BRAND AT-1

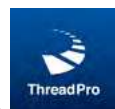


EDP Number		Thread Size	Diameter	Overall Length	Length of Cut	Neck Length	Shank Diameter	Number of Flutes	Type
			D (Inch)	L (Inch)	Lc (Inch)	L1 (Inch)	d (Inch)		
1662500217	●	1/4 - 32 UNEF	0.179	3.000	0.563	0.625	0.250	4	1
1662500017	●	1/4 - 20 UNC	0.179	3.000	0.600	0.700	0.250	4	1
1662500117	●	1/4 - 28 UNF	0.179	3.000	0.607	0.680	0.250	4	1
1662500517	●	5/16 - 32 UNEF	0.224	3.000	0.688	0.750	0.250	4	1
1662500417	●	5/16 - 24 UNC	0.224	3.000	0.750	0.833	0.250	4	1
1662500317	●	5/16 - 18 UNC	0.224	3.000	0.778	0.889	0.250	4	1
1662500817	●	3/8 - 32 UNEF	0.264	3.500	0.813	0.875	0.313	4	1
1662500617	●	3/8 - 16 UNC	0.264	3.500	0.875	1.000	0.313	4	1
1662500717	●	3/8 - 24 UNF	0.264	3.500	0.875	0.958	0.313	4	1
1662501117	●	7/16 - 28 UNEF	0.303	3.500	0.964	-	0.313	4	2
1662501017	●	7/16 - 20 UNF	0.303	3.500	1.000	-	0.313	4	2
1662500917	●	7/16 - 14 UNC	0.303	3.500	1.071	-	0.313	4	2
1662501317	●	1/2 - 20 UNF	0.343	3.500	1.100	1.200	0.375	5	1
1662501417	●	1/2 - 28 UNEF	0.343	3.500	1.107	1.178	0.375	5	1
1662501217	●	1/2 - 13 UNC	0.343	3.500	1.154	1.308	0.375	5	1
1662501717	●	9/16 - 24 UNEF	0.382	5.000	1.250	1.333	0.500	5	1
1662501617	●	9/16 - 18 UNF	0.382	5.000	1.278	1.389	0.500	5	1
1662501517	●	9/16 - 12 UNC	0.382	5.000	1.333	1.500	0.500	5	1
1662502017	●	5/8 - 24 UNEF	0.421	5.000	1.374	1.458	0.500	5	1
1662501917	●	5/8 - 18 UNF	0.421	5.000	1.389	1.500	0.500	5	1
1662501817	●	5/8 - 11 UNC	0.421	5.000	1.454	1.636	0.500	5	1
1662502317	●	3/4 - 20 UNEF	0.461	5.000	1.600	1.700	0.500	5	1
1662502217	●	3/4 - 16 UNF	0.461	5.000	1.626	1.750	0.500	5	1
1662502117	●	3/4 - 10 UNC	0.461	5.000	1.700	1.900	0.500	5	1
1662502617	●	7/8 - 20 UNEF	0.539	5.500	1.850	1.950	0.625	5	1
1662502517	●	7/8 - 14 UNF	0.539	5.500	1.928	2.071	0.625	5	1
1662502417	●	7/8 - 9 UNC	0.539	5.500	2.000	2.222	0.625	5	1
1662502917	●	1 - 20 UNEF	0.736	6.000	2.100	2.200	0.750	6	1
1662502817	●	1 - 12 UNF	0.736	6.000	2.167	2.334	0.750	6	1
1662502717	●	1 - 8 UNC	0.736	6.000	2.250	2.500	0.750	6	1

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details
Note: For internal threads only.



For more information on thread mill applications, including ThreadPro software, visit: osgtool.com/ThreadPro.



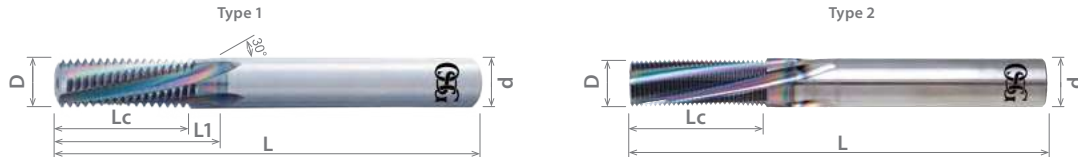
P					M			K	N		S		H			
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel			
Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium				
Low	Medium	High			1010	1035	1065		4140	4340			6061	7075	Casting	Inconel
1010	1035	1065	4140	4340	300	400	17-4 PH	6061	7075	Casting	Inconel	6Al4V (30 HRC)	~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC
○	○	○	○		○	○	○	○	○	○			○	○		

○ Good ○ Best



List 16620

A BRAND AT-1

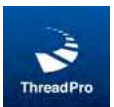


EDP Number		Thread Size	Diameter	Overall Length	Length of Cut	Neck Length	Shank Diameter	Number of Flutes	Type
			D (mm)	L (mm)	Lc (mm)	L1 (mm)	d (mm)		
8331000	●	M6 x 0.75	4.50	75.00	13.50	16.00	6.00	4	1
8331001	●	M6 x 1	4.50	75.00	14.00	16.00	6.00	4	1
8331003	●	M8 x 1	5.70	75.00	18.00	-	6.00	4	2
8331004	●	M8 x 1.25	5.70	75.00	18.75	-	6.00	4	2
8331005	●	M10 x 1	7.70	85.00	22.00	-	8.00	4	2
8331006	●	M10 x 1.25	7.70	85.00	22.50	-	8.00	4	2
8331007	●	M10 x 1.5	7.70	85.00	24.00	-	8.00	4	2
8331008	●	M12 x 1	9.70	100.00	26.00	-	10.00	5	2
8331009	●	M12 x 1.25	9.70	100.00	27.50	-	10.00	5	2
8331010	●	M12 x 1.5	9.70	100.00	27.00	-	10.00	5	2
8331011	●	M12 x 1.75	9.70	100.00	28.00	-	10.00	5	2
8331015	●	M14 x 1.5	10.70	120.00	31.50	34.50	12.00	5	1
8331016	●	M14 x 2	9.70	100.00	32.00	-	10.00	5	2
8331018	●	M16 x 1.5	13.70	135.00	36.00	39.00	16.00	5	1
8331019	●	M16 x 2	11.70	120.00	36.00	-	12.00	5	2
8331020	●	M18 x 2.5	11.70	120.00	42.50	-	12.00	5	2
8331021	●	M20 x 1.5	15.70	135.00	43.50	-	16.00	5	2
8331022	●	M20 x 2.5	13.70	135.00	45.00	50.00	16.00	5	1
8331024	●	M24 x 2	19.70	150.00	52.00	-	20.00	6	2
8331025	●	M24 x 3	19.70	150.00	54.00	-	20.00	6	2

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details
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P					M			K	N		S		H			
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel			
Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium				
Low	Medium	High							6061	Casting						
1010	1035	1065	4140	Die Steel	300	400	17-4 PH		6061	Casting	Inconel	6Al4V	~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC
1018	1045		4340						7075			(30 HRC)				
○	○	○	○		○	○	○	○	○	○		○	○			

○ Good ○ Best



A Brand AT-1

Advanced Performance One Pass Thread Mill

List 16630

A BRAND AT-1, NPT

A



THREAD
MILL

SPEED
FEED
11

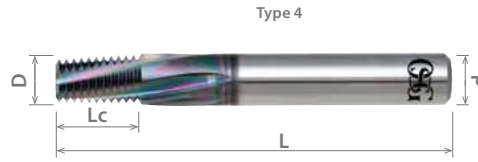
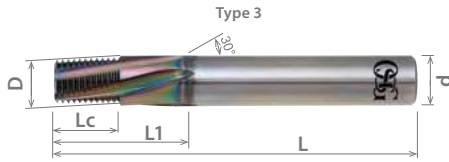
CARBIDE

EgiAs

11°

SHANK
h6

PACKED
1 PIECE

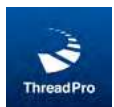


EDP Number		Thread Size	Diameter	Overall Length	Length of Cut	Neck Length	Shank Diameter	Number of Flutes	Type
			D (Inch)	L (Inch)	Lc (Inch)	L1 (Inch)	d (Inch)		
1663000017	●	1/16 - 27 NPT	0.223	3.000	0.407	0.480	0.250	4	3
1663000117	●	1/8 - 27 NPT	0.302	3.500	0.407	-	0.313	4	4
1663000217	●	1/4 - 18 NPT	0.381	3.500	0.611	0.720	0.500	5	3
1663000317	●	3/8 - 18 NPT	0.461	3.500	0.611	0.720	0.500	5	3
1663000417	●	1/2 - 14 NPT	0.617	4.000	0.786	-	0.625	5	4
1663000517	●	1 - 11.5 NPT	0.737	4.000	0.957	-	0.750	6	4

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details
Note: For internal threads only.

ATP

For more information on thread mill applications, including ThreadPro software, visit: osgtool.com/ThreadPro.



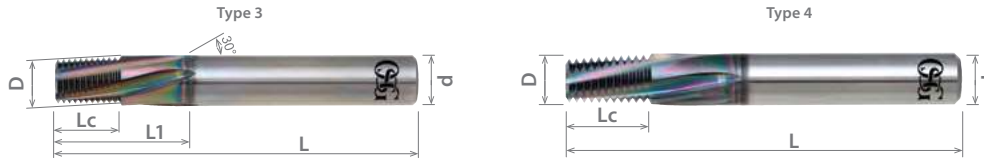
P					M			K	N		S		H			
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel			
Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium				
Low	Medium	High														
1010	1035	1065	4140	Die Steel	300	400	17-4 PH	6061	Casting	Inconel	6Al4V	~35	35-45	45-50	50-70	
1018	1045	1065	4340					7075			(30 HRC)	HRC	HRC	HRC	HRC	
																

○ Good ○ Best



List 16631

A BRAND AT-1, NPTF



EDP Number		Thread Size	Diameter	Overall Length	Length of Cut	Neck Length	Shank Diameter	Number of Flutes	Type
			D (Inch)	L (Inch)	Lc (Inch)	L1 (Inch)	d (Inch)		
1663100017	●	1/16 - 27 NPTF	0.223	3.000	0.407	0.480	0.250	4	3
1663100117	●	1/8 - 27 NPTF	0.302	3.500	0.407	-	0.313	4	4
1663100217	●	1/4 - 18 NPTF	0.381	3.500	0.611	0.720	0.500	5	3
1663100317	●	3/8 - 18 NPTF	0.459	3.500	0.611	0.720	0.500	5	3
1663100417	●	1/2 - 14 NPTF	0.617	4.000	0.786	-	0.625	5	4
1663100517	●	1 - 11.5 NPTF	0.737	4.000	0.957	-	0.750	6	4

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details
Note: For internal threads only.



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P					M			K	N		S		H			
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel			
Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium				
Low	Medium	High							6061	Casting	Inconel	6Al4V (30 HRC)				
1010	1035	1065	4140	Die Steel	300	400	17-4 PH	6061 7075	Casting	Inconel	6Al4V (30 HRC)	~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC	
1018	1045		4340													
⊙	⊙	⊙	⊙		⊙	○	○	⊙	⊙	⊙		⊙	⊙			

○ Good ○ Best

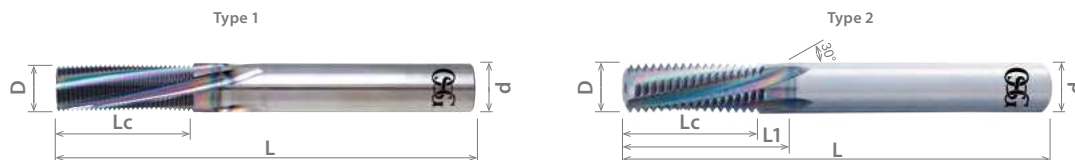


A Brand AT-1

Advanced Performance One Pass Thread Mill

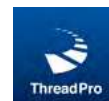
List 16632

A BRAND AT-1, NPS



EDP Number		Thread Size	Diameter	Overall Length	Length of Cut	Neck Length	Shank Diameter	Number of Flutes	Type
			D (Inch)	L (Inch)	Lc (Inch)	L1 (Inch)	d (Inch)		
1663200017	●	1/16 - 27 NPS	0.223	3.000	0.593	0.667	0.250	4	2
1663200117	●	1/8 - 27 NPS	0.302	3.500	0.593	-	0.313	4	1
1663200217	●	1/4 - 18 NPS	0.381	3.750	0.889	1.000	0.500	5	2
1663200317	●	3/8 - 18 NPS	0.459	3.750	0.889	1.000	0.500	5	2
1663200417	●	1/2 - 14 NPS	0.617	4.000	1.143	-	0.625	5	1
1663200517	●	1 - 11.5 NPS	0.737	4.500	1.391	-	0.750	6	1

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details



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P					M			K	N		S		H			
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel			
Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium				
Low	Medium	High							6061	Casting						
1010	1035	1065	4140	4340	300	400	17-4 PH	6061	7075	Casting	Inconel	6Al4V (30 HRC)	~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC
1018	1045	1065	4340													
○	○	○	○		○	○	○	○	○	○			○	○		

○ Good ○ Best



List 16620/16625 - A Brand AT-1

List 16630/16631/16632 - A Brand AT-1 NPT/NPTF/NPS

Work Material		Cutting Speed (SFM)	Feed Rate (in/t)
Low Carbon Steel	~C0.25%	260 - 790	0.0004 - 0.002
Medium Carbon Steel	C0.25%~0.45%	260 - 790	0.0004 - 0.002
High Carbon Steel	C0.45%~	260 - 790	0.0004 - 0.002
Alloy Steel	4140, 4340, 8620	200 - 650	0.0004 - 0.002
Hardened Steel	25-45 HRC	260 - 650	0.0004 - 0.002
	45-55 HRC	-	-
	50-60 HRC	-	-
Stainless Steel	300-series, 400-series	200 - 790	0.0004 - 0.002
Tool Steel	D2, H13, A6	-	-
Cast Steel	-	200 - 790	0.0004 - 0.002
Cast Iron	-	260 - 790	0.0004 - 0.002
Ductile Cast Iron	-	200 - 790	0.0004 - 0.002
Copper	-	260 - 790	0.001 - 0.004
Brass	B21, B36	260 - 790	0.001 - 0.004
Brass Casting	B62	260 - 790	0.001 - 0.004
Bronze	B124, B103, B159	260 - 790	0.001 - 0.004
Aluminum	6061, 7075, 2014	260 - 790	0.001 - 0.004
Aluminum Alloy Casting	-	330 - 1000	0.002 - 0.008
Magnesium Alloy Casting	-	330 - 1000	0.002 - 0.008
Zinc Alloy Casting	-	330 - 1000	0.002 - 0.008
Titanium Alloy	Ti-6Al-4V	-	-
Nickel Alloy	Inconel	-	-
Thermosetting Plastic	-	260 - 650	0.001 - 0.004
Thermo Plastic	-	260 - 650	0.001 - 0.004

1. The indicated speeds and feeds are for water-soluble coolant.

2. Water-soluble coolant is not suitable for threading magnesium alloy.

3. Please adjust the cutting conditions depending on the rigidity of the machine, tool holders, and workpiece clamping.

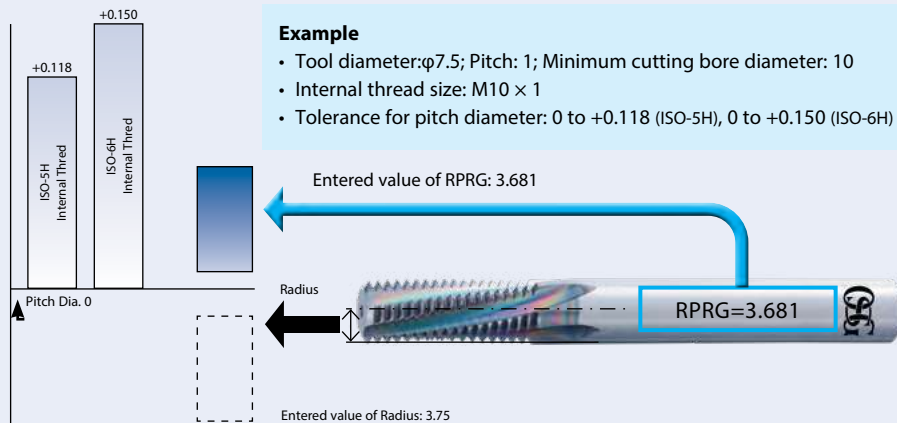
4. If the threading length is long, or when machining a large-pitch thread, reduce the feed rate and take multiple passes.

5. If a machined parallel internal thread is tapered and prevents the go-gauge from going through, add a zero cut/spring pass.

Radius Offset (RPRG)

RPRG is the reference value of tool radius offset.

Conventionally, the tool radius was entered during setup as a parameter of the NC system, which was corrected by checking the thread with a gauge. However, it has become possible to reduce the checking and correction simply by entering the RPRG value indicated on the tool shank.



NOTES:

1. RPRG are reference values. Determine optimal values after trial cutting as values depend on machining environment.
2. RPRG values are optimally established to achieve ISO:5H (formerly Grade 1) internal thread limits for metric threads and ANSI:3B internal thread limits for unified threads. RPRG values established for taper pipes (R/Rc) are effective when using the thread milling NC code generator software ThreadPro available on our website.
3. For diameters of thread mills, RPRG values are calculated based on the minimum cutting bore diameter (the minimum cutting internal thread size of the tool diameter). To cut other diameters, it is necessary to use a smaller value than RPRG.

ThreadPro (Thread Milling NC Code Generator Software)

www.osgtool.com/threadpro



- Available in 12 different languages
- Supports 8 NC programming languages
- Incorporates RPRG* value to further simplify process



* RPRG = reference value of tool radius offset

Powered by
AUTODESK

2 Processes with 1 Tool

Helical Drilling & Threading Done Simultaneously!

Helical drilling and threading are performed simultaneously, which reduces the risk of potential machining problems in the processing of high hardness steels.

The risk of sudden tool breakage is minimized as the chips are broken into small, manageable pieces and evacuated smoothly. Since no pilot hole is required, AT-2 integrates two processes while avoiding part scrap.



Unique Cutting Edge Shape

controls tool deflection.

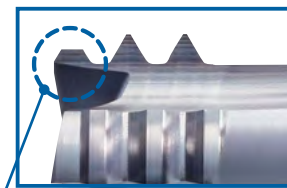
Left-Hand Cut

Results in long tool life by climb milling.

*Counterclockwise Spindle Rotation

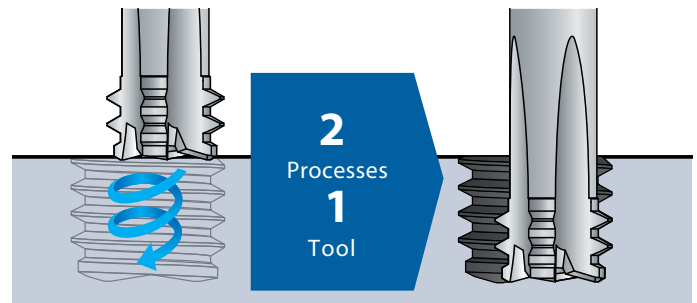
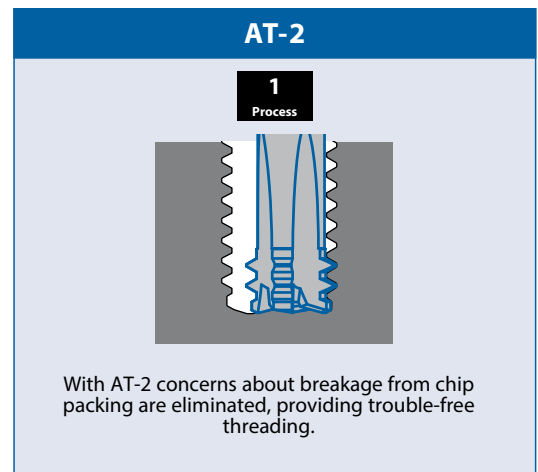
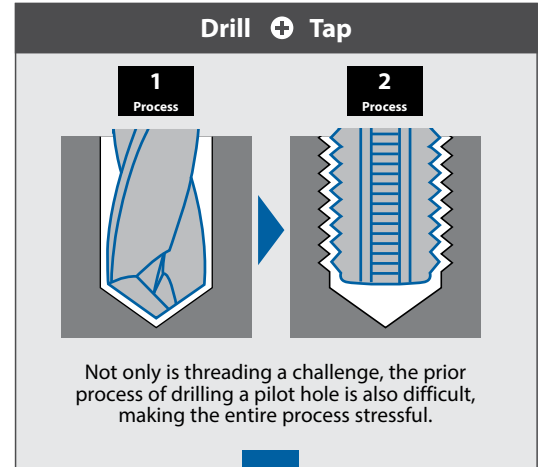
DUROREY Coating

for high-hardness steel.



Roughing Teeth

added to distribute the load.



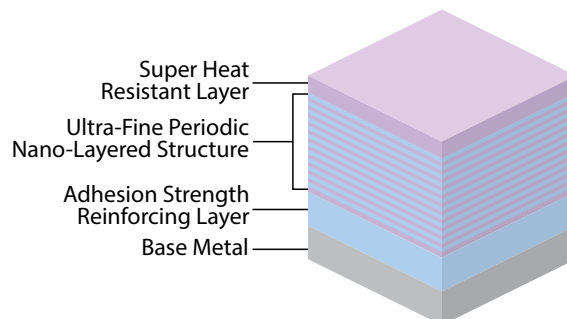
DUROREY Coating (PAT. P)

Superior Heat Resistance and Toughness

OSG's newly developed DUROREY coating, with its unique coating structure, provides superior heat resistance and toughness for high-hardness steel milling. DUROREY coating also suppresses chipping and achieves longer tool life.



Coating Structure



Coating Color	Coating Structure	Hardness (GPa)	Oxidation Temperature (°C)	Heat Resistance	Adhesion Strength	Surface Roughness	Wear Resistance	Welding Resistance	Toughness
Black Gray	Ultra-Fine Periodic Nano-Layered	41	1,300	◎	○	Fair	◎	○	○

DUROREY is a registered trademark of OSG Corporation.

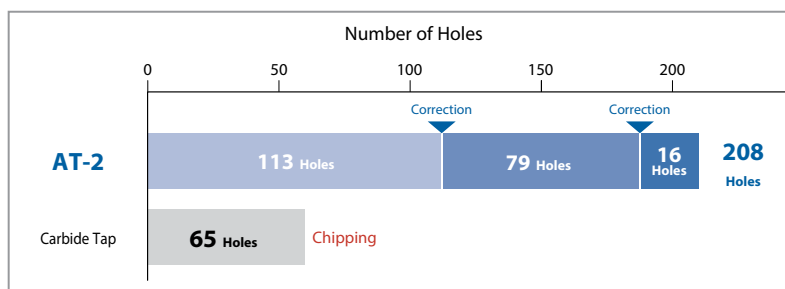
○ good ◎ best

Long Tool Life with Exceptional Thread Quality

D2 Tool Steel (60 HRC)

AT-2 demonstrates long and stable tool life with higher thread quality compared to cutting taps.

Tool	AT-2	Carbide Tap
Size	Ø6.2 x 16 P1.25	M8x1.25
Material	D2 Tool Steel (60 HRC)	
Speed	150 SFM (2,310 RPM)	6.6 SFM (80 RPM)
Feed	3.26 IPM (0.0016 IPT)	3.937 IPM
Drill Size	None	Ø 6.8 x 23.5 (blind)
Thread Size	M8 x 1.25	
Thread Length	16mm (2D)	
Coolant	Air blow	Oil
Machine	HMC (BT40)	VMC (BT40)

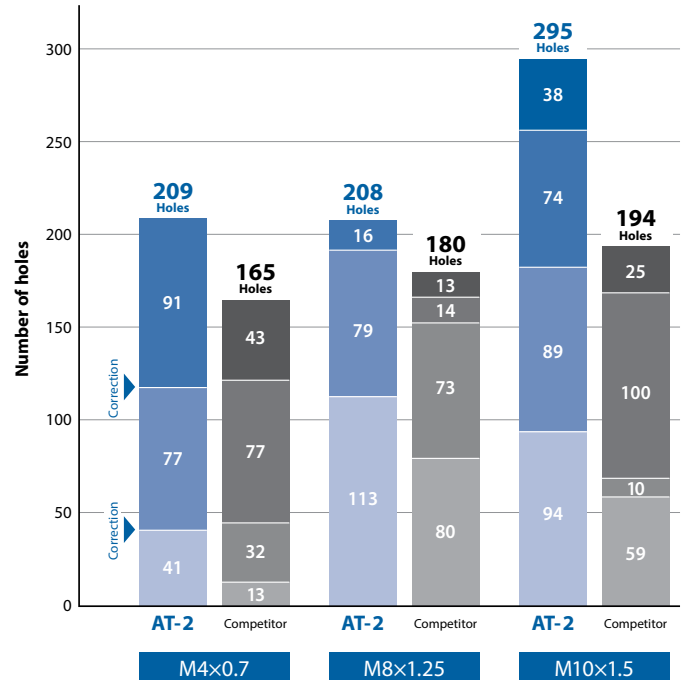


Outstanding Durability with Air-Blow

D2 Tool Steel (60 HRC)

AT-2 demonstrates outstanding durability by cutting with air-blow.

Size	Ø 3.1 x 8 P0.7	Ø 6.2 x 16 P1.25	Ø 7.5 x 20 P1.5
Material	D2 Tool Steel (60 HRC)		
Speed	150 SFM (4,620 RPM)	150 SFM (2,310 RPM)	115 SFM (1,485 RPM)
Feed	1.81 IPM (0.0004 IPT)	3.27 IPM (0.0016 IPT)	2.20 IPM (0.0015 IPT)
Thread Size	M4 x 0.7	M8 x 1.25	M10 x 1.5
Thread Length	7mm (1.75D)	14.8mm (1.85D)	18.5mm (1.85D)
Coolant	Air-Blow		
Machine	HMC (BT40)	VMC (HSK63)	

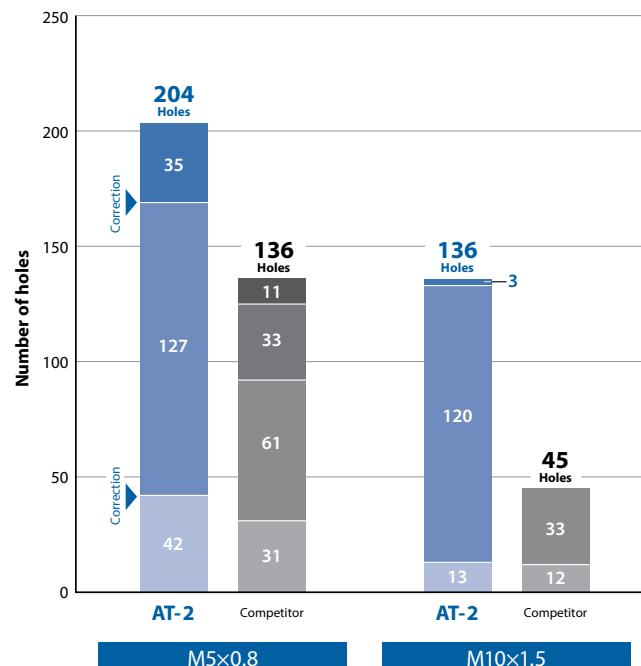


Stable Durability with Water-Soluble Coolant

D2 Tool Steel (60 HRC)

Unlike threading with a tap, which often involves the use of cutting oils, AT-2 can be used with water-soluble coolant, reducing setup time while machining.

Size	Ø 4 x 10 P0.8	Ø 7.5 x 20 P1.5
Material	D2 Tool Steel (60 HRC)	
Speed	150 SFM (3,581 RPM)	150 SFM (1,910 RPM)
Feed	2.60 IPM (0.0009 IPT)	2.87 IPM (0.0015 IPT)
Thread Size	M5 x 0.8	M10 x 1.5
Depth	9.2mm (1.85D)	18.5mm (1.85D)
Coolant	Water soluble	
Machine	HMC (BT40)	VMC (HSK63)

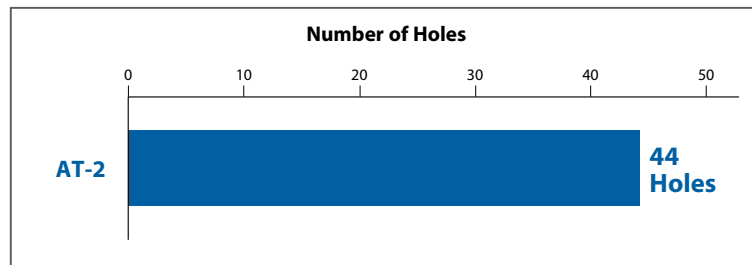


Remarkable Durability in 65 HRC Material

M2 High Speed Steel (65 HRC)

AT-2 demonstrates outstanding durability by cutting with air-blow.

Size	Ø 4 x 10 P0.8
Material	M2 High Speed Steel (65 HRC)
Speed	150 SFM (3581 RPM)
Feed	1.14 IPM (0.0004 IPT)
Thread Size	M5 x 0.8
Depth	8mm (2D)
Coolant	Air blow
Machine	HMC

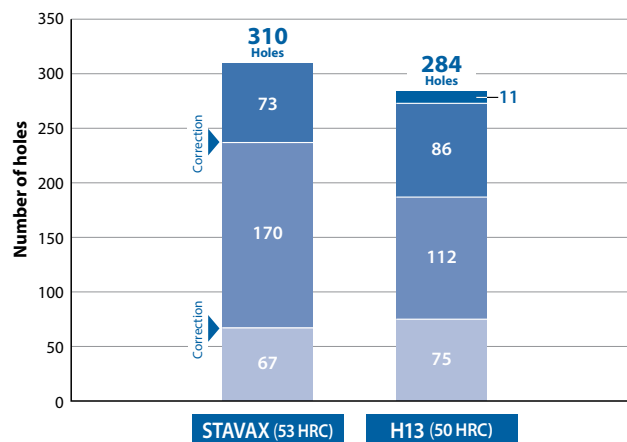


Excellent Durability in STAVAX

STAVAX (53 HRC) and H13 (50 HRC)

Even in difficult stainless steels AT-2 provides excellent tool life.

Size	Ø 7.5 x 20 P1.5	
Material	STAVAX (53 HRC)	H13 (50 HRC)
Speed	180 SFM (2,331 RPM)	
Feed	3.50 IPM (0.0015 IPT)	
Thread Size	M10 x 1.5	
Depth	18mm (1.8D)	
Coolant	Air Blow	
Machine	HMC (BT40)	

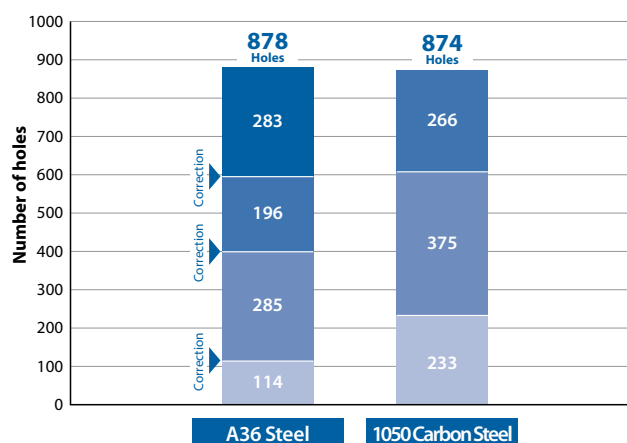


Stable Performance Even in General Steels

A36 Steel and 1050 Carbon Steel

Since there is no cutting chip trouble, it is effective for avoiding the risk of tool breakage. Processing consolidation is also made possible.

Size	Ø 3.1 x 8 P0.7	
Material	A36 Steel	1050 Carbon Steel
Speed	150 SFM (3581 RPM)	150 SFM (1910 RPM)
Feed	2.60 IPM (0.0009 IPT)	2.87 IPM (0.0015 IPT)
Thread Size	M4 x 0.7	
Depth	7mm (1.75D)	
Coolant	Water soluble	
Machine	VMC	

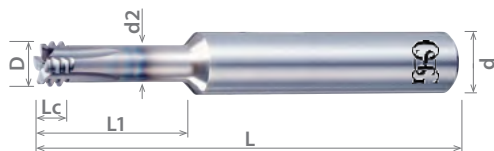


List 16645

A BRAND AT-2, Straight Flute, End Cut



THREAD MILL	SPEED FEED 19	CARBIDE	DUROREY	4 FLUTE	0°	LH	SHANK h6	PACKED 1 PIECE
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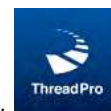
EDP Number		Thread Size	Diameter	Overall Length	Length of Cut	Neck Length	Shank Diameter	Coolant-Through
			D (Inch)	L (Inch)	Lc (Inch)	L1 (Inch)	d (Inch)	
1664500011	●	No. 8 - 32 UNC	0.122	2.000	0.094	0.406	0.250	-
1664500111	●	No. 10 - 24 UNC	0.146	3.000	0.125	0.484	0.250	-
1664500211	●	1/4 - 20 UNC	0.179	3.000	0.150	0.625	0.250	-
1664500311	●	1/4 - 28 UNF	0.179	3.000	0.107	0.589	0.250	-
1664500411	●	5/16 - 18 UNC	0.224	3.500	0.167	0.764	0.375	-
1664500511	●	5/16 - 24 UNF	0.224	3.500	0.125	0.730	0.375	-
1664500611	●	3/8 - 16 UNC	0.264	3.500	0.188	0.906	0.375	-
1664500711	●	3/8 - 24 UNF	0.264	3.500	0.125	0.854	0.375	-
1664500811	●	1/2 - 13 UNC	0.362	3.500	0.231	1.192	0.375	●
1664500911	●	1/2 - 20 UNF	0.362	3.500	0.150	1.125	0.375	●

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details

Note: For internal threads only.

ATP

For more information on thread mill applications, including ThreadPro software, visit: osgtool.com/ThreadPro.



P					M			K	N		S		H			
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel			
Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium				
Low	Medium	High							6061	Casting	Inconel	6Al4V (30 HRC)				
1010	1035	1065	4140	Steel	300	400	17-4 PH		7075				~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC
1018	1045		4340													
○	○	○	○	⊗	○	○	○	○	○	○	○	○	○	○	⊗	⊗

○ Good ○ Best

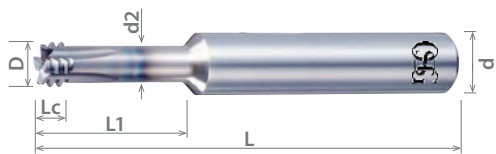


A Brand AT-2

Advanced Performance End-Cutting Thread Mill for High-Hardness Steel

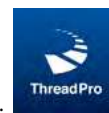
List 16640

A BRAND AT-2, Straight Flute, End Cut



EDP Number		Thread Size	Diameter	Overall Length	Length of Cut	Neck Length	Shank Diameter	Coolant-Through
			D (mm)	L (mm)	Lc (mm)	L1 (mm)	d (mm)	
8331200	●	M3 x 0.5	2.40	50.00	1.50	7.25	6.00	-
8331201	●	M4 x 0.7	3.10	50.00	2.10	9.75	6.00	-
8331202	●	M5 x 0.8	4.00	50.00	2.40	12.00	6.00	-
8331203	●	M6 x 1	4.60	50.00	3.00	14.50	6.00	-
8331204	●	M8 x 1.25	6.20	70.00	3.75	19.13	10.00	-
8331205	●	M10 x 1.5	7.50	70.00	4.50	23.75	10.00	●
8331206	●	M12 x 1.75	9.00	80.00	5.25	28.38	10.00	●

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details
Note: For internal threads only.



For more information on thread mill applications, including ThreadPro software, visit: osgtool.com/ThreadPro.

P					M			K	N		S		H			
Steel					Stainless Steel				Non-Ferrous		HRSA		Hardened Steel			
Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium				
Low	Medium	High			300	400	17-4 PH		6061 7075	Casting			Inconel	6Al4V (30 HRC)	~35 HRC	35-45 HRC
1010	1035	1065	4140	Die Steel												
1018	1045		4340													
○		○	○	⊙	○	○	○	○	○	○	○	○	○	○	○	○

○ Good ○ Best

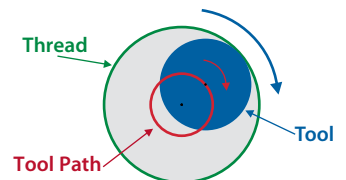


List 16640/16645 - A Brand AT-2

	P															M		
Work Material	Carbon Steels									Alloy Steel			Die Steel			Stainless Steel		
	Low		Medium		High													
	1010, 1018		1035, 1045		1065		4140, 4340, 8620			D2, H13, A6			300, 400, 17-4 PH					
Coolant	Water Soluble		Water Soluble		Water Soluble		Water Soluble			Water Soluble			Water Soluble					
Cutting Speed (SFM)	115-180		260-525		260-525		200-400			115-330			115-330					
Thread Size	Speed (RPM)	Feed (IPM)	Feed (IPT)	Speed (RPM)	Feed (IPM)	Feed (IPT)	Speed (RPM)	Feed (IPM)	Feed (IPT)	Speed (RPM)	Feed (IPM)	Feed (IPT)	Speed (RPM)	Feed (IPM)	Feed (IPT)	Speed (RPM)	Feed (IPM)	Feed (IPT)
M3x0.5	5968	1.89	0.0004	10610	3.35	0.0004	10610	3.35	0.0004	7958	2.52	0.0004	5968	1.89	0.0004	5968	1.89	0.0004
M4x0.7	4621	2.44	0.0006	8214	4.37	0.0006	8214	4.37	0.0006	6161	3.27	0.0006	4621	2.44	0.0006	4621	2.44	0.0006
No. 8-32	4621	1.85	0.0004	8214	3.35	0.0004	8214	3.35	0.0004	6161	2.52	0.0004	4621	1.85	0.0004	4621	1.85	0.0004
No. 10-32	4621	2.65	0.0004	8214	4.70	0.0004	8214	4.70	0.0004	6161	3.53	0.0004	4621	2.65	0.0004	4621	2.65	0.0004
No. 10-24	3871	2.13	0.0006	6882	3.78	0.0006	6882	3.78	0.0006	5162	2.83	0.0006	3871	2.13	0.0006	3871	2.13	0.0006
M5x0.8	3581	1.93	0.0007	6366	3.43	0.0007	6366	3.43	0.0007	4775	2.56	0.0007	3581	1.93	0.0007	3581	1.93	0.0007
M6x1.0	3114	2.28	0.0008	5536	4.06	0.0008	5536	4.06	0.0008	4152	3.07	0.0008	3114	2.28	0.0008	3114	2.28	0.0008
1/4-20, 1/4-28	3148	3.50	0.001	5597	6.26	0.001	5597	6.26	0.001	4197	4.69	0.001	3148	3.50	0.001	3148	3.50	0.001
5/16-18, 5/16-24	2513	3.35	0.0012	4468	5.94	0.0012	4468	5.94	0.0012	3351	4.45	0.0012	2513	3.35	0.0012	2513	3.35	0.0012
M8x1.25	2310	2.44	0.0012	4107	4.37	0.0012	4107	4.37	0.0012	3080	3.27	0.0012	2310	2.44	0.0012	2310	2.44	0.0012
3/8-16, 3/8-24	2138	3.50	0.0014	3801	6.22	0.0014	3801	6.22	0.0014	2851	4.65	0.0014	2138	3.50	0.0014	2138	3.50	0.0014
M10x1.5	1910	2.64	0.0014	3395	4.69	0.0014	3395	4.69	0.0014	2546	3.50	0.0014	1910	2.64	0.0014	1910	2.64	0.0014
M12x1.75	1592	2.83	0.0018	2839	5.00	0.0018	2839	5.00	0.0018	2122	3.74	0.0018	1592	2.83	0.0018	1592	2.83	0.0018
1/2-13, 1/2-20	1557	3.03	0.0018	2768	5.39	0.0018	2768	5.39	0.0018	2076	4.06	0.0018	1557	3.03	0.0018	1557	3.03	0.0018

Work Material	K			N									S					
	Cast Iron			Aluminum			Cu, Brass, Brass Casting			Bronze			Nickel Alloy			Titanium		
	Ductile Cast Iron			6061, 7075			B21, B37, B63			B124, B103, B160			Inconel			Ti-6Al-4V		
	G2			Water Soluble			Water Soluble			Water Soluble			Water Soluble			Water Soluble		
Coolant	Air Blow			Water Soluble			Water Soluble			Water Soluble			Water Soluble			Water Soluble		
Cutting Speed (SFM)	115-330			115-330			115-330			115-250			115-180			115-180		
Thread Size	Speed (RPM)	Feed (IPM)	Feed (IPT)	Speed (RPM)	Feed (IPM)	Feed (IPT)	Speed (RPM)	Feed (IPM)	Feed (IPT)	Speed (RPM)	Feed (IPM)	Feed (IPT)	Speed (RPM)	Feed (IPM)	Feed (IPT)	Speed (RPM)	Feed (IPM)	Feed (IPT)
M3x0.5	7958	2.52	0.0004	10610	3.35	0.0004	7958	2.52	0.0004	5968	2.47	0.0004	4642	1.46	0.0004	5968	1.89	0.0004
M4x0.7	6161	3.27	0.0006	8214	4.37	0.0006	6161	3.27	0.0006	4621	3.05	0.0006	3594	1.93	0.0006	4621	2.44	0.0006
No. 8-32	6161	2.52	0.0004	8214	3.37	0.0004	6161	2.52	0.0004	4621	1.89	0.0004	3594	1.46	0.0004	4621	1.85	0.0004
No. 10-32	6161	3.53	0.0004	8214	4.70	0.0004	6161	3.53	0.0004	4621	2.65	0.0004	3594	2.06	0.0004	4621	2.65	0.0004
No. 10-24	5162	2.83	0.0006	6882	3.82	0.0006	5162	2.87	0.0006	3871	2.15	0.0006	3011	1.65	0.0006	3871	2.13	0.0006
M5x0.8	4775	2.56	0.0007	6366	3.43	0.0007	4775	2.56	0.0007	3581	2.57	0.0007	2785	1.50	0.0007	3581	1.93	0.0007
M6x1.0	4152	3.07	0.0008	5536	4.06	0.0008	4152	3.07	0.0008	3114	2.31	0.0008	2422	1.77	0.0008	3114	2.28	0.0008
1/4-20, 1/4-28	4197	4.69	0.001	5597	6.36	0.001	4197	4.77	0.001	3148	3.58	0.001	2449	2.72	0.001	3148	3.50	0.001
5/16-18, 5/16-24	3351	4.45	0.0012	4468	6.07	0.0012	3351	4.56	0.0012	2513	3.42	0.0012	1955	2.60	0.0012	2513	3.35	0.0012
M8x1.25	3080	3.27	0.0012	4107	4.37	0.0012	3080	3.27	0.0012	2310	2.57	0.0012	1797	1.93	0.0012	2310	2.44	0.0012
3/8-16, 3/8-24	2851	4.65	0.0014	3801	6.30	0.0014	2851	4.73	0.0014	2138	3.54	0.0014	1663	2.72	0.0014	2138	3.50	0.0014
M10x1.5	2546	3.50	0.0014	3395	4.69	0.0014	2546	3.50	0.0014	1910	3.04	0.0014	1485	2.05	0.0014	1910	2.64	0.0014
M12x1.75	2122	3.74	0.0018	2839	5.00	0.0018	2122	3.74	0.0018	1592	3.26	0.0018	1238	2.20	0.0018	1592	2.83	0.0018
1/2-13, 1/2-20	2076	4.06	0.0018	2768	5.50	0.0018	2076	4.13	0.0018	1557	3.09	0.0018	1211	2.36	0.0018	1557	3.03	0.0018

	H						Other		
Work Material	Hardened Steel						Thermosetting Plastic Thermo Plastic		
	40-50 HRC			50-65 HRC					
Coolant	Air Blow			Air Blow			Water Soluble		
Cutting Speed (SFM)	115-215			115-180			115-330		
Thread Size	Speed (RPM)	Feed (IPM)	Feed (IPT)	Speed (RPM)	Feed (IPM)	Feed (IPT)	Speed (RPM)	Feed (IPM)	Feed (IPT)
M3x0.5	5968	1.89	0.0004	5968	1.89	0.0004	7958	2.52	0.0004
M4x0.7	4621	2.44	0.0006	4621	2.44	0.0006	6161	3.27	0.0006
No. 8-32	4621	1.85	0.0004	4621	1.85	0.0004	6161	2.52	0.0004
No. 10-32	4621	2.65	0.0004	4621	2.65	0.0004	6161	3.53	0.0004
No. 10-24	3871	2.13	0.0006	3871	2.13	0.0006	5162	2.83	0.0006
M5x0.8	3581	1.93	0.0007	3581	1.93	0.0007	4775	2.56	0.0007
M6x1.0	3114	2.28	0.0008	3114	2.28	0.0008	4152	3.07	0.0008
1/4-20, 1/4-28	3148	3.50	0.001	3148	3.50	0.001	4197	4.69	0.001
5/16-18, 5/16-24	2513	3.35	0.0012	2513	3.35	0.0012	3351	4.45	0.0012
M8x1.25	2310	2.44	0.0012	2310	2.44	0.0012	3080	3.27	0.0012
3/8-16, 3/8-24	2138	3.50	0.0014	2138	3.50	0.0014	2851	4.65	0.0014
M10x1.5	1910	2.64	0.0014	1910	2.64	0.0014	2546	3.50	0.0014
M12x1.75	1592	2.83	0.0018	1592	2.83	0.0018	2122	3.74	0.0018
1/2-13, 1/2-20	1557	3.03	0.0018	1557	3.03	0.0018	2076	4.06	0.0018



Formula

$$V_f = \frac{f_z \times z \times n \times (D_m - D_c)}{D_m}$$

V_f : IPM (Table Feed)

f_z : IPT

z : # of Flutes

n : Speed (RPM)

Thread Size

D_m = Actual path for cutting edge

D_c = Tool Dia.

1. Tool is left hand cutting - program spindle for counter clockwise rotation.
2. Please use the recommended coolant type for each material.
3. Table feed in IPM is tool path feed, this is the feed that should be used in your program.
4. Feed per Tooth will be the actual cutting edge feed, use these values when programming in ThreadPro.
5. Table values are nominal cutting parameters, please adjust based on results from cutting, setup, workholding, etc.

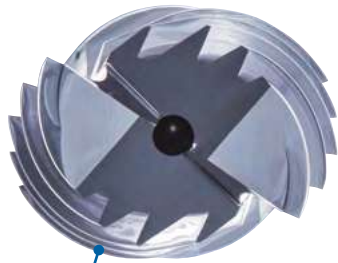
A Brand AT-2 R-SPEC

Features & Benefits

Coolant Hole

To evacuate chips smoothly.

*Over Ø4.6



End Cutting Edge

Helical drilling & threading can be done simultaneously.

Left-Hand Cut

Results in long tool life by climb milling.

*Counterclockwise Spindle Rotation

2-Flute

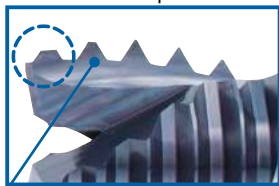
For wide chip room.

DLC-IGUSS Coating

To prevent welding on the cutting edge and achieve more tool life.

Unique Cutting Edge Shape

To prevent deflection of tool. *PAT. in Japan



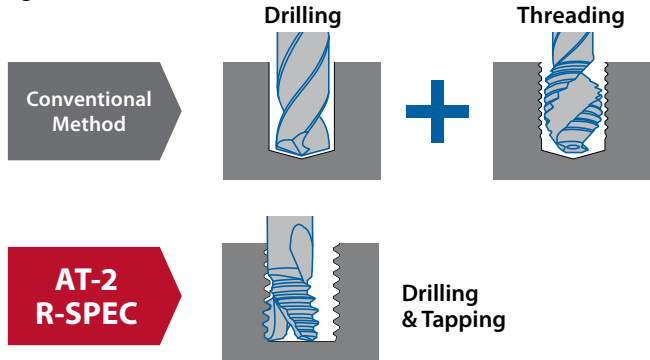
Roughing Teeth

To realize high efficiency by cutting load distribution.

Cycle Time Reduction

2 Processes with 1 Tool

Achieves drilling and threading by continuous helical cutting with a single tool.



Hole Position Accuracy

Countermeasure Against Misalignment in Cast

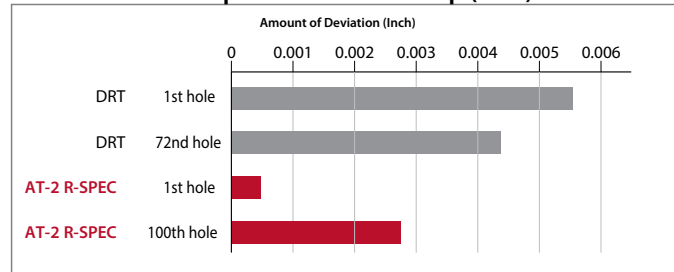
Rough position settings and inclined nature of cast holes can cause position shifting in following processes.

Issues in Cast Hole

1. Rough Hole Position
2. Draft Angle



Hole Position Comparison vs Drill & Tap (DRT)



Tool: M8x1.25 Depth: 0.7087" Material: Casting Aluminum
Machining Test Shifter 0.02756" from the pilot hole Ø0.1693"

DRT: SFM = 328, IPR = 0.0492

AT-2 R-SPEC: AFM = 722, IPR = 0.0472

Air Blow Option

Can Also Be Available with Air Blow

Q. There are cases that oil cannot be used in machining electrical parts.

A. It is recommended to use coolant, but it can also be used with air blow due to the fragmentation of chips and the welding resistance effect of the DLC coat (pre-holes are necessary).



Cycle Time Reduction Against Drill & Tap

ADC12 Aluminum Alloy

Tool	AT-2 R-SPEC	ADO-3D	A-SFT
Size	M6 x 1.0	5.0mm	M6 x 1.0
Material	ADC12 Aluminum Alloy		
Speed	525 SFM	230 SFM	62 SFM
Feed	0.0138 IPT	0.0067 IPR	Tapping
Depth	12mm Threading Depth		
Coolant	Water Soluble		
Machine	BT40 Horizontal		
Total Holes	13 Hole Cycle		
Cycle Time	62.5s	93.3s	



71m/min 0.17 mm/rev
(4,520 min-1 768 mm/min)



18.8 m/min
(1,000 min-1)

93.3s

Including 1 ATC

**30.8s
Reduction**



160 m/min 0.35 mm/t
(11,072 min-1 1,808 mm/min)

62.5s

Cycle Time Reduction Against Tap

6061 Aluminum Alloy

Tool	AT-2 R-SPEC	A-SFT
Size	M6 x 1.0	
Material	6061 Aluminum Alloy	
Speed	720 SFM	89 SFM
Feed	0.0090 IPT	Tapping
Depth	12 mm Threading Depth	
Coolant	Water Soluble	
Machine	HSK50 Vertical	
Cycle Time	2.27s	3.83s



27.2 m/min
(2,000 min-1)

3.83s

**1.56s
Reduction**



220 m/min 0.228 mm/t
(13,840 min-1 1,621 mm/min)

2.27s

Threading in Aluminum with Air Blow

Aluminum Alloy (AlMgSi0.5)

AT-2 R-SPEC can be used with air blow if there is a pre-hole.

	Case 1	Case 2
Thread size	M6 x 1	M8 x 1.25
Thread length	0.3150"	0.5118"
Drill depth	0.1969"	0.2638"
Machine	HSK 63 vertical MC (HERMLE)	
Coolant	Air Blow	
Work material	Aluminum Alloy (AlMgSi0.5)	
Cutting speed	722 SFM	
Feed rate	0.0049 IPT	
Cutting time	3.0 s	6.7 s



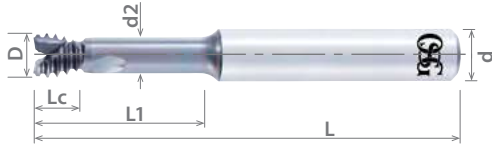
AT-2 R-SPEC after 100 Holes

A Brand AT-2 R-SPEC

Advanced Performance End-Cutting Thread Mill for Non-Ferrous Materials

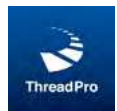
List 16647

A BRAND AT-2 R-SPEC, End Cut



EDP Number		Thread Size	Diameter	Overall Length	Length of Cut	Neck Length	Shank Diameter	Coolant-Through
			D (Inch)	L (Inch)	Lc (Inch)	L1 (Inch)	d (Inch)	
1664700009	●	No. 4 - 40 UNC	0.083	2.000	0.125	0.311	0.250	-
1664700109	●	No. 6 - 32 UNC	0.100	2.000	0.156	0.385	0.250	-
1664700209	●	No. 8 - 32 UNC	0.122	2.000	0.156	0.437	0.250	-
1664700309	●	No. 10 - 24 UNC	0.146	3.000	0.208	0.526	0.250	-
1664700409	●	No. 10 - 32 UNF	0.146	3.000	0.156	0.489	0.250	-
1664700509	●	1/4 - 20 UNC	0.179	3.000	0.250	0.675	0.250	●
1664700609	●	1/4 - 28 UNF	0.179	3.000	0.179	0.625	0.250	●
1664700709	●	5/16 - 18 UNC	0.224	3.500	0.278	0.819	0.375	●
1664700809	●	5/16 - 24 UNF	0.224	3.500	0.208	0.771	0.375	●
1664700909	●	3/8 - 16 UNC	0.264	3.500	0.313	0.969	0.375	●
1664701009	●	3/8 - 24 UNF	0.264	3.500	0.208	0.896	0.375	●
1664701109	●	1/2 - 13 UNC	0.362	3.500	0.385	1.269	0.375	●
1664701209	●	1/2 - 20 UNF	0.362	3.500	0.250	1.175	0.375	●

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details
Note: For internal threads only.



For more information on thread mill applications, including ThreadPro software, visit: osgttool.com/ThreadPro.

P Steel					M			K Cast Iron	N		S	H					
Carbon Steel				Alloy Steel	Die Steel	Stainless Steel			Non-Ferrous		HRSA		Hardened Steel				
Low	Medium	High	Aluminum						Nickel Alloy	Titanium							
1010	1035	1065	4140						4340	6061	7075	Casting					Inconel
1018	1045				300	400	17-4 PH										

○ Good ○ Best

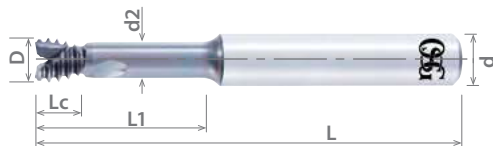


A Brand AT-2 R-SPEC

Advanced Performance End-Cutting Thread Mill for Non-Ferrous Materials

List 16642

A BRAND AT-2 R-SPEC, End Cut



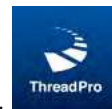
EDP Number		Thread Size	Diameter	Overall Length	Length of Cut	Neck Length	Shank Diameter	Coolant-Through
			D (mm)	L (mm)	Lc (mm)	L1 (mm)	d (mm)	
8331220	●	M3 x 0.5	2.40	50.00	1.50	7.75	6	-
8331227	●	M3 x 0.5	2.40	50.00	1.50	9.25	6	-
8331221	●	M4 x 0.7	3.10	50.00	2.10	10.45	6	-
8331228	●	M4 x 0.7	3.10	50.00	2.10	12.45	6	-
8331222	●	M5 x 0.8	4.00	50.00	2.40	12.80	6	-
8331229	●	M5 x 0.8	4.00	50.00	2.40	15.30	6	-
8331223	●	M6 x 1	4.60	50.00	3.00	15.50	6	●
8331230	●	M6 x 1	4.60	50.00	3.00	18.50	6	●
8331224	●	M8 x 1.25	6.20	70.00	3.75	20.38	8	●
8331231	●	M8 x 1.25	6.20	70.00	3.75	24.38	8	●
8331225	●	M10 x 1.5	7.50	80.00	4.50	25.25	10	●
8331232	●	M10 x 1.5	7.50	80.00	4.50	30.25	10	●
8331226	●	M12 x 1.75	9.00	80.00	5.25	30.13	10	●
8331233	●	M12 x 1.75	9.00	80.00	5.25	36.13	10	●

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details

Note: For internal threads only.



For more information on thread mill applications, including ThreadPro software, visit: osgtool.com/ThreadPro.



P Steel					M			K Cast Iron	N		S		H			
Carbon Steel			Alloy Steel	Die Steel	Stainless Steel				Non-Ferrous		HRSA		Hardened Steel			
Low	Medium	High							Aluminum		Nickel Alloy	Titanium				
1010 1018	1035 1045	1065	4140 4340	300	400	17-4 PH	6061 7075		Casting	Inconel	6Al4V (30 HRC)	~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC	
							⊙	⊙								

○ Good ○ Best



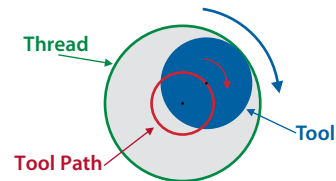
A Brand AT-2 R-SPEC

Advanced Performance End-Cutting Thread Mill for Non-Ferrous Materials

List 16642/16647 - A Brand AT-2 R-SPEC

Work Material	N														
	Copper			Brass			Brass Casting			Aluminum Alloy Casting			Aluminum		
				B21, B36			B62						6061, 7075		
Coolant	Water Soluble			Water Soluble			Water Soluble			Water Soluble			Water Soluble		
Cutting Speed (SFM)	330-985			330-985			330-985			330-985			330-985		
Thread Size	Speed (RPM)	Feed (IPM)	Feed (IPT)	Speed (RPM)	Feed (IPM)	Feed (IPT)	Speed (RPM)	Feed (IPM)	Feed (IPT)	Speed (RPM)	Feed (IPM)	Feed (IPT)	Speed (RPM)	Feed (IPM)	Feed (IPT)
No. 4-40	15188	9.28	0.00118	15188	9.28	0.00118	15188	9.28	0.00118	15188	92.81	0.0118	15188	9.28	0.00118
M3x0.5	13263	6.26	0.00118	13263	6.26	0.00118	13263	6.26	0.00118	13263	62.68	0.0118	13263	6.26	0.00118
No. 6-32	15280	9.93	0.00118	15280	9.93	0.00118	15280	9.93	0.00118	15280	99.30	0.0118	15280	9.93	0.00118
M4x0.7	14375	7.64	0.00118	14375	7.64	0.00118	14375	7.64	0.00118	14375	76.42	0.0118	14375	7.64	0.00118
No. 8-32	14090	8.52	0.00118	14090	8.52	0.00118	14090	8.52	0.00118	14090	85.16	0.0118	14090	8.52	0.00118
No. 10-24, No. 10-32	17164	9.38	0.00118	17164	9.38	0.00118	17164	9.38	0.00118	17164	93.80	0.0118	17164	9.38	0.00118
M5x0.8	15915	10.04	0.00157	15915	10.04	0.00157	15915	10.04	0.00157	15915	75.20	0.0118	15915	10.04	0.00157
M6x1.0	15224	11.18	0.00157	15224	11.18	0.00157	15224	11.18	0.00157	15224	111.89	0.0157	15224	11.18	0.00157
1/4-20, 1/4-28	15408	13.74	0.00157	15408	13.74	0.00157	15408	13.74	0.00157	15408	137.40	0.0157	15408	13.74	0.00157
5/16-18, 5/16-24	12313	10.95	0.00157	12313	10.95	0.00157	12313	10.95	0.00157	12313	109.49	0.0157	12313	10.95	0.00157
M8x1.25	12322	10.91	0.00197	12322	10.91	0.00197	12322	10.91	0.00197	12322	87.32	0.0157	12322	10.91	0.00197
3/8-16, 3/8-24	11402	13.30	0.00197	11402	13.30	0.00197	11402	13.30	0.00197	11402	132.98	0.0197	11402	13.30	0.00197
M10x1.5	10186	10.04	0.00197	10186	10.04	0.00197	10186	10.04	0.00197	10186	80.20	0.0157	10186	10.04	0.00197
M12x1.75	8488	8.35	0.00197	8488	8.35	0.00197	8488	8.35	0.00197	8488	66.85	0.0157	8488	8.35	0.00197
1/2-13, 1/2-20	8315	9.04	0.00197	8315	9.04	0.00197	8315	9.04	0.00197	8315	90.42	0.0197	8315	9.04	0.00197

Work Material	N					
	Magnesium Alloy			Zinc Alloy		
Coolant	Water Soluble			Water Soluble		
Cutting Speed (SFM)	330-985			330-985		
Thread Size	Speed (RPM)	Feed (IPM)	Feed (IPT)	Speed (RPM)	Feed (IPM)	Feed (IPT)
No. 4-40	15188	9.28	0.00118	15188	9.28	0.00118
M3x0.5	13263	6.26	0.00118	13263	6.26	0.00118
No. 6-32	15280	9.93	0.00118	15280	9.93	0.00118
M4x0.7	14375	7.64	0.00118	14375	7.64	0.00118
No. 8-32	14090	8.52	0.00118	14090	8.52	0.00118
No. 10-24, No. 10-32	17164	9.38	0.00118	17164	9.38	0.00118
M5x0.8	15915	10.04	0.00157	15915	10.04	0.00157
M6x1.0	15224	11.18	0.00157	15224	11.18	0.00157
1/4-20, 1/4-28	15408	13.74	0.00157	15408	13.74	0.00157
5/16-18, 5/16-24	12313	10.95	0.00157	12313	10.95	0.00157
M8x1.25	12322	10.91	0.00197	12322	10.91	0.00197
3/8-16, 3/8-24	11402	13.30	0.00197	11402	13.30	0.00197
M10x1.5	10186	10.04	0.00197	10186	10.04	0.00197
M12x1.75	8488	8.35	0.00197	8488	8.35	0.00197
1/2-13, 1/2-20	8315	9.04	0.00197	8315	9.04	0.00197



Formula

$$V_f = \frac{f_z \times z \times n \times (D_m - D_c)}{D_m}$$

V_f : IPM (Table Feed)

f_z : IPT

z : # of Flutes

n : Speed (RPM)

Thread Size

D_m = Actual path for cutting edge

D_c = Tool Dia.

1. Tool is left hand cutting - program spindle for counter clockwise rotation.
2. Please use the recommended coolant type for each material.
3. Table feed in IPM is tool path feed, this is the feed that should be used in your program.
4. Feed per Tooth will be the actual cutting edge feed, use these values when programming in ThreadPro.
5. When machining magnesium, please refer to the coolant oil manufacturer's specification for recommended oil. Please also properly dispose of the cutting chips to prevent fire hazards.
6. Please use water soluble coolant unless there is pre hole made by casting or drilling.



Revolutionary Productivity with Zero Cutting Chips

Avoid Common Tapping Troubles

Most tapping troubles are caused by unstable chip evacuation. The A-XPF forms threads by plastic deformation of the work material and does not generate cutting chips. It is a revolutionary product that excels in a wide range of work materials and cutting conditions.

Common Tapping Issues

1	Breakage and chipping	26%
2	Dimensional error	17%
3	Galling	14%
	Other	43%

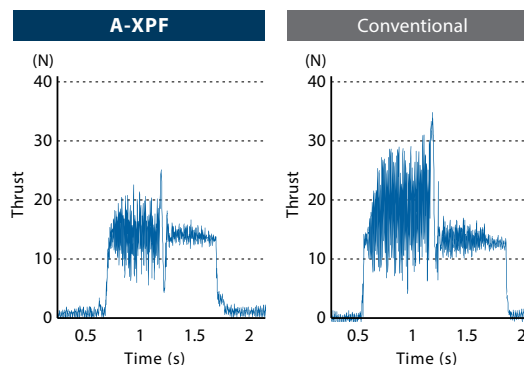
Source: OSG Technical Consultation Division



Stable Machining with Reduced Thrust

4140 (30 HRC)

Tool	A-XPF M3×0.5 2P
Work Material	4140 (30HRC)
Drill Hole Size	φ2.8×9mm (Blind)
Tapping Length	6mm (2D)
Cutting Speed	49 SFM (1,591RPM)
Coolant	Water-soluble Chlorine-free (5%)
Machine	BT30 Vertical Machining Center



VI Coating

Improved Machining Efficiency and Durability

Improved cutting edge rigidity by a special thread shape.

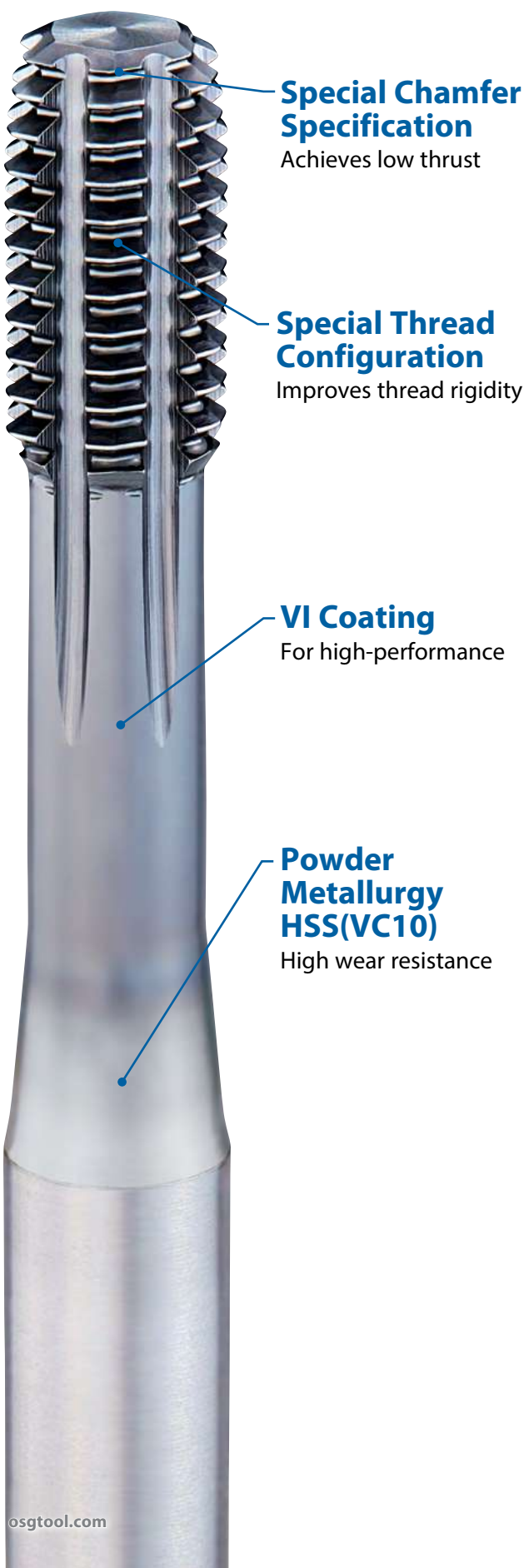
NEW VI Coating: Coating with high-hardness, oxidation resistance, and excellent lubricity that is suitable for high-load machining.

Lubricate Layer
Wear-Resistant Layer
Toughness Layer
Wear-Resistant Layer
Toughness Layer
Wear-Resistant Layer
Toughness Layer
Base Metal

Coating Color	Coating Structure	Hardness	Oxidation Temp. (C)	Adhesion Strength	Surface Roughness	Wear Resistance	Welding Resistance	Toughness
Black	Cr-based composite multilayer film	45	1,100	○	⊙	○	⊙	○

VI coating is registered trademarks of OSG Corporation.

○ Good ⊙ Best



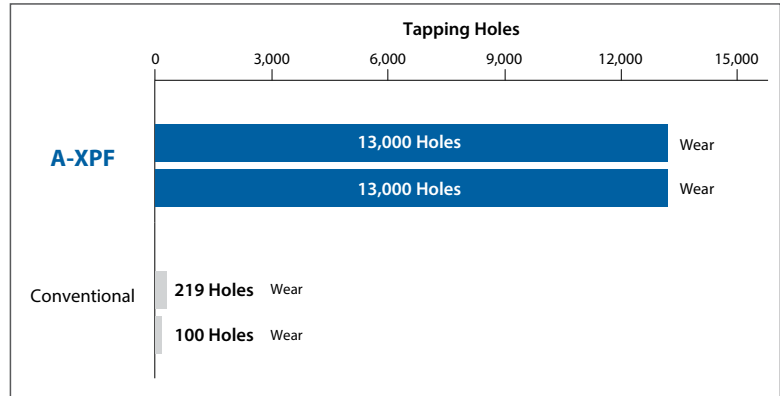
High-Speed Machining with VI Coating

Achieves Cutting Speed of 100 SFM in High Hardness Materials

Achieves high speed and stable machining in 4140 (30HRC).

Tool	A-XPF
Size	M6 x 1.0
Material	4140 (30HRC)
Drill Hole Size	Ø5.52x19mm
Tapping Depth	12mm (2D)
Cutting Speed	98 SFM (1,591 RPM)
Coolant	Water Soluble Chlorine-Free (5%)
Machine	BT40 Horizontal Machining Center

For testing purposes, the conventional product was also used under high-speed cutting condition.

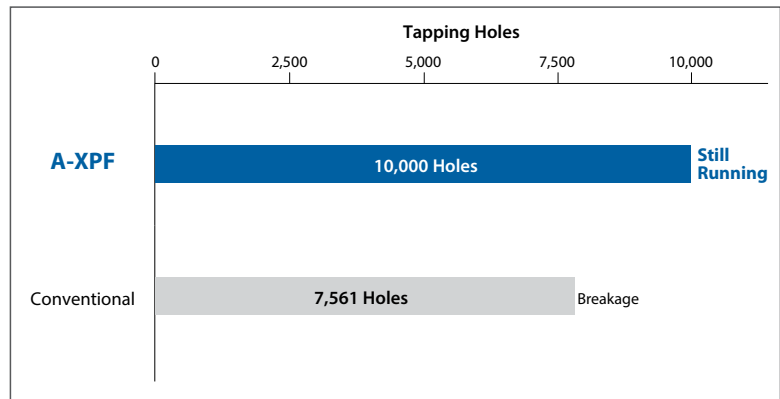


Small Diameter Threading

Achieves Excellent Durability in Small-Diameter Machining by Reducing Thrust

Outstanding durability even when machining small diameter threads in martensitic stainless steel.

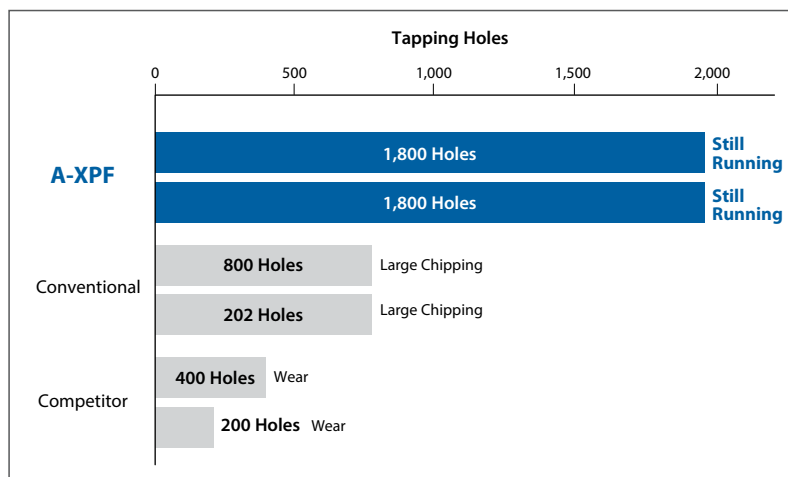
Tool	A-XPF
Size	M1 x 0.25 2P
Material	420 HC (192 HBW)
Drill Hole Size	Ø0.91x3.5mm (Blind)
Tapping Depth	2mm (2D)
Cutting Speed	33 SFM (3,183 RPM)
Coolant	Water Soluble Chlorine-Free (5%)
Machine	BT30 Vertical Machining Center



Stable Durability with Stainless Steel using Coolant

304 Stainless Steel

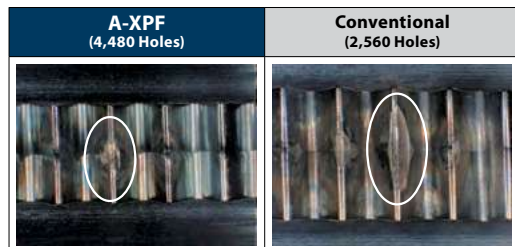
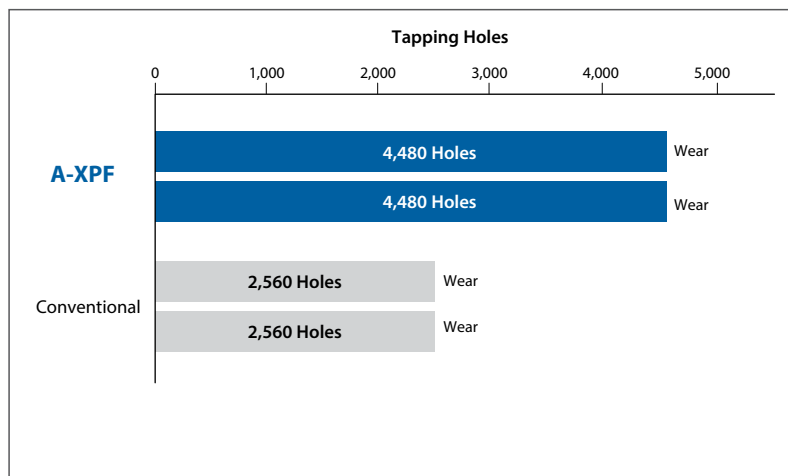
Tool	A-XPF
Size	M3 x 0.5 1P
Material	304 SS
Drill Hole Size	Ø2.8x9mm (Blind)
Tapping Depth	6mm (2D)
Cutting Speed	33 SFM (1,061 RPM)
Coolant	Water Soluble Chlorine-Free (5%)
Machine	BT30 Vertical Machining Center



Stable Durability in High-Hardness Material

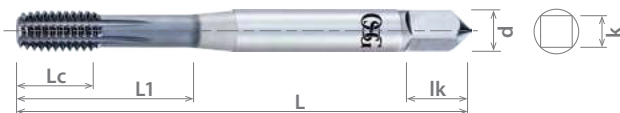
4140 (30 HRC)

Tool	A-XPF
Size	M16 x 1.5 2P
Material	4140 (30 HRC)
Drill Hole Size	Ø15.3x30mm (Through)
Tapping Depth	30mm
Cutting Speed	49 SFM (298 RPM)
Coolant	Water Soluble Chlorine-Free (5%)
Machine	BT50 Horizontal Machining Center



List 26250

A BRAND A-XPF



EDP Number		Thread Size	Thread Limit	Chamfer Type	Overall Length	Thread Length	Neck Length	Shank Diameter	Square Width	Square Length	Tap Drill Size	
					L (Inch)	Lc (Inch)	L1 (Inch)	d (Inch)	k (Inch)	lk (Inch)	Min (Inch)	Max (Inch)
2625000802	●	No. 0 - 80 UNF	H2	Modified Bottom (2.5P)	1.575	0.315	0.355	0.141	0.110	0.188	0.053	0.055
2625000803	●	No. 0 - 80 UNF	H3	Modified Bottom (2.5P)	1.575	0.315	0.355	0.141	0.110	0.188	0.053	0.055
2625008013	●	No. 0 - 80 UNF	H3	Bottom (1.5P)	1.575	0.315	0.355	0.141	0.110	0.188	0.053	0.055
2625001642	○	No. 1 - 64 UNC	H2	Modified Bottom (2.5P)	1.772	0.315	0.355	0.141	0.110	0.188	0.064	0.067
2625001643	●	No. 1 - 64 UNC	H3	Modified Bottom (2.5P)	1.772	0.315	0.355	0.141	0.110	0.188	0.064	0.067
2625016413	●	No. 1 - 64 UNC	H3	Bottom (1.5P)	1.772	0.315	0.355	0.141	0.110	0.188	0.064	0.067
2625001722	○	No. 1 - 72 UNF	H2	Modified Bottom (2.5P)	1.772	0.315	0.355	0.141	0.110	0.188	0.065	0.068
2625001723	●	No. 1 - 72 UNF	H3	Modified Bottom (2.5P)	1.772	0.315	0.355	0.141	0.110	0.188	0.065	0.068
2625017213	●	No. 1 - 72 UNF	H3	Bottom (1.5P)	1.772	0.315	0.355	0.141	0.110	0.188	0.065	0.068
2625002562	●	No. 2 - 56 UNC	H2	Modified Bottom (2.5P)	1.772	0.375	0.414	0.141	0.110	0.188	0.076	0.080
2625002563	●	No. 2 - 56 UNC	H3	Modified Bottom (2.5P)	1.772	0.375	0.414	0.141	0.110	0.188	0.076	0.080
2625025613	●	No. 2 - 56 UNC	H3	Bottom (1.5P)	1.772	0.375	0.414	0.141	0.110	0.188	0.076	0.080
2625002642	○	No. 2 - 64 UNF	H2	Modified Bottom (2.5P)	1.772	0.375	0.414	0.141	0.110	0.188	0.077	0.080
2625002643	○	No. 2 - 64 UNF	H3	Modified Bottom (2.5P)	1.772	0.375	0.414	0.141	0.110	0.188	0.077	0.080
2625026413	●	No. 2 - 64 UNF	H3	Bottom (1.5P)	1.772	0.375	0.414	0.141	0.110	0.188	0.077	0.080
2625003482	●	No. 3 - 48 UNC	H2	Modified Bottom (2.5P)	1.969	0.375	0.414	0.141	0.110	0.188	0.087	0.092
2625003483	●	No. 3 - 48 UNC	H3	Modified Bottom (2.5P)	1.969	0.375	0.414	0.141	0.110	0.188	0.087	0.092
2625034813	○	No. 3 - 48 UNC	H3	Bottom (1.5P)	1.969	0.375	0.414	0.141	0.110	0.188	0.087	0.092
2625003562	○	No. 3 - 56 UNF	H2	Modified Bottom (2.5P)	1.969	0.375	0.414	0.141	0.110	0.188	0.089	0.092
2625003563	●	No. 3 - 56 UNF	H3	Modified Bottom (2.5P)	1.969	0.375	0.414	0.141	0.110	0.188	0.089	0.092
2625035613	○	No. 3 - 56 UNF	H3	Bottom (1.5P)	1.969	0.375	0.414	0.141	0.110	0.188	0.089	0.092
2625004403	●	No. 4 - 40 UNC	H3	Modified Bottom (2.5P)	2.205	0.300	0.709	0.141	0.110	0.188	0.098	0.103
2625004405	●	No. 4 - 40 UNC	H5	Modified Bottom (2.5P)	2.205	0.300	0.709	0.141	0.110	0.188	0.098	0.103
2625044015	●	No. 4 - 40 UNC	H5	Bottom (1.5P)	2.205	0.300	0.709	0.141	0.110	0.188	0.098	0.103
2625004483	●	No. 4 - 48 UNF	H3	Modified Bottom (2.5P)	2.205	0.300	0.709	0.141	0.110	0.188	0.100	0.104
2625004485	●	No. 4 - 48 UNF	H5	Modified Bottom (2.5P)	2.205	0.300	0.709	0.141	0.110	0.188	0.100	0.104
2625044815	●	No. 4 - 48 UNF	H5	Bottom (1.5P)	2.205	0.300	0.709	0.141	0.110	0.188	0.100	0.104
2625005403	●	No. 5 - 40 UNC	H3	Modified Bottom (2.5P)	2.205	0.300	0.709	0.141	0.110	0.188	0.111	0.115
2625005405	●	No. 5 - 40 UNC	H5	Modified Bottom (2.5P)	2.205	0.300	0.709	0.141	0.110	0.188	0.111	0.115
2625054015	●	No. 5 - 40 UNC	H5	Bottom (1.5P)	2.205	0.300	0.709	0.141	0.110	0.188	0.111	0.115
2625005443	○	No. 5 - 44 UNF	H3	Modified Bottom (2.5P)	2.205	0.300	0.709	0.141	0.110	0.188	0.112	0.116
2625005445	○	No. 5 - 44 UNF	H5	Modified Bottom (2.5P)	2.205	0.300	0.709	0.141	0.110	0.188	0.112	0.116
2625054415	○	No. 5 - 44 UNF	H5	Bottom (1.5P)	2.205	0.300	0.709	0.141	0.110	0.188	0.112	0.116
2625006323	●	No. 6 - 32 UNC	H3	Modified Bottom (2.5P)	2.205	0.375	0.788	0.141	0.110	0.188	0.120	0.125
2625006325	●	No. 6 - 32 UNC	H5	Modified Bottom (2.5P)	2.205	0.375	0.788	0.141	0.110	0.188	0.120	0.125
2625063215	●	No. 6 - 32 UNC	H5	Bottom (1.5P)	2.205	0.375	0.788	0.141	0.110	0.188	0.120	0.125
2625006403	●	No. 6 - 40 UNF	H3	Modified Bottom (2.5P)	2.205	0.375	0.788	0.141	0.110	0.188	0.124	0.128
2625006405	●	No. 6 - 40 UNF	H5	Modified Bottom (2.5P)	2.205	0.375	0.788	0.141	0.110	0.188	0.124	0.128
2625064015	●	No. 6 - 40 UNF	H5	Bottom (1.5P)	2.205	0.375	0.788	0.141	0.110	0.188	0.124	0.128
2625006485	●	No. 6 - 48 UNEF	H5	Modified Bottom (2.5P)	2.205	0.375	0.788	0.141	0.110	0.188	0.124	0.128
2625008323	●	No. 8 - 32 UNC	H3	Modified Bottom (2.5P)	2.481	0.375	0.827	0.168	0.131	0.250	0.146	0.151
2625008325	●	No. 8 - 32 UNC	H5	Modified Bottom (2.5P)	2.481	0.375	0.827	0.168	0.131	0.250	0.146	0.151
2625083215	●	No. 8 - 32 UNC	H5	Bottom (1.5P)	2.481	0.375	0.827	0.168	0.131	0.250	0.146	0.151
2625008363	●	No. 8 - 36 UNF	H3	Modified Bottom (2.5P)	2.481	0.375	0.827	0.168	0.131	0.250	0.148	0.152
2625008365	●	No. 8 - 36 UNF	H5	Modified Bottom (2.5P)	2.481	0.375	0.827	0.168	0.131	0.250	0.148	0.152
2625083615	○	No. 8 - 36 UNF	H5	Bottom (1.5P)	2.481	0.375	0.827	0.168	0.131	0.250	0.148	0.152
2625008405	●	No. 8 - 40 UNEF	H5	Modified Bottom (2.5P)	2.481	0.375	0.827	0.168	0.131	0.250	0.148	0.152
2625010216	●	No. 10 - 24 UNC	H6	Bottom (1.5P)	2.756	0.500	0.945	0.194	0.152	0.250	0.166	0.172
2625010244	●	No. 10 - 24 UNC	H4	Modified Bottom (2.5P)	2.756	0.500	0.945	0.194	0.152	0.250	0.166	0.172
2625010246	●	No. 10 - 24 UNC	H6	Modified Bottom (2.5P)	2.756	0.500	0.945	0.194	0.152	0.250	0.166	0.172
2625010316	●	No. 10 - 32 UNF	H6	Bottom (1.5P)	2.756	0.500	0.945	0.194	0.152	0.250	0.172	0.176
2625010324	●	No. 10 - 32 UNF	H4	Modified Bottom (2.5P)	2.756	0.500	0.945	0.194	0.152	0.250	0.172	0.176
2625010326	●	No. 10 - 32 UNF	H6	Modified Bottom (2.5P)	2.756	0.500	0.945	0.194	0.152	0.250	0.172	0.176
2625012245	○	No. 12 - 24 UNC	H5	Modified Bottom (2.5P)	3.150	0.500	1.103	0.220	0.165	0.281	0.192	0.198
2625012247	●	No. 12 - 24 UNC	H7	Modified Bottom (2.5P)	3.150	0.500	1.103	0.220	0.165	0.281	0.192	0.198
2625012417	○	No. 12 - 24 UNC	H7	Bottom (1.5P)	3.150	0.500	1.103	0.220	0.165	0.281	0.192	0.198

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details



List 26250 (Continued)

A BRAND A-XPF



EDP Number		Thread Size	Thread Limit	Chamfer Type	Overall Length	Thread Length	Neck Length	Shank Diameter	Square Width	Square Length	Tap Drill Size	
					L (Inch)	Lc (Inch)	L1 (Inch)	d (Inch)	k (Inch)	lk (Inch)	Min (Inch)	Max (Inch)
2625012285	●	No. 12 - 28 UNF	H5	Modified Bottom (2.5P)	3.150	0.500	1.103	0.220	0.165	0.281	0.196	0.200
2625012287	●	No. 12 - 28 UNF	H7	Modified Bottom (2.5P)	3.150	0.500	1.103	0.220	0.165	0.281	0.196	0.200
2625012817	○	No. 12 - 28 UNF	H7	Bottom (1.5P)	3.150	0.500	1.103	0.220	0.165	0.281	0.196	0.200
2625014204	●	1/4 - 20 UNC	H4	Modified Bottom (2.5P)	3.150	0.500	1.182	0.255	0.191	0.313	0.222	0.227
2625014206	●	1/4 - 20 UNC	H6	Modified Bottom (2.5P)	3.150	0.500	1.182	0.255	0.191	0.313	0.222	0.227
2625014216	●	1/4 - 20 UNC	H6	Bottom (1.5P)	3.150	0.500	1.182	0.255	0.191	0.313	0.222	0.227
2625014284	●	1/4 - 28 UNF	H4	Modified Bottom (2.5P)	3.150	0.500	1.182	0.255	0.191	0.313	0.230	0.234
2625014286	●	1/4 - 28 UNF	H6	Modified Bottom (2.5P)	3.150	0.500	1.182	0.255	0.191	0.313	0.230	0.234
2625014816	●	1/4 - 28 UNF	H6	Bottom (1.5P)	3.150	0.500	1.182	0.255	0.191	0.313	0.230	0.234
2625051617	●	5/16 - 18 UNC	H7	Bottom (1.5P)	3.544	0.556	1.378	0.318	0.238	0.375	0.281	0.288
2625056185	●	5/16 - 18 UNC	H5	Modified Bottom (2.5P)	3.544	0.556	1.378	0.318	0.238	0.375	0.281	0.288
2625056187	●	5/16 - 18 UNC	H7	Modified Bottom (2.5P)	3.544	0.556	1.378	0.318	0.238	0.375	0.281	0.288
2625056217	●	5/16 - 24 UNF	H7	Bottom (1.5P)	3.544	0.556	1.378	0.318	0.238	0.375	0.289	0.294
2625056245	●	5/16 - 24 UNF	H5	Modified Bottom (2.5P)	3.544	0.556	1.378	0.318	0.238	0.375	0.289	0.294
2625056247	●	5/16 - 24 UNF	H7	Modified Bottom (2.5P)	3.544	0.556	1.378	0.318	0.238	0.375	0.289	0.294
2625038117	●	3/8 - 16 UNC	H7	Bottom (1.5P)	3.938	0.626	1.575	0.381	0.286	0.438	0.339	0.347
2625038165	●	3/8 - 16 UNC	H5	Modified Bottom (2.5P)	3.938	0.626	1.575	0.381	0.286	0.438	0.339	0.347
2625038167	●	3/8 - 16 UNC	H7	Modified Bottom (2.5P)	3.938	0.626	1.575	0.381	0.286	0.438	0.339	0.347
2625038217	●	3/8 - 24 UNF	H7	Bottom (1.5P)	3.938	0.626	1.575	0.381	0.286	0.438	0.351	0.357
2625038245	●	3/8 - 24 UNF	H5	Modified Bottom (2.5P)	3.938	0.626	1.575	0.381	0.286	0.438	0.351	0.357
2625038247	●	3/8 - 24 UNF	H7	Modified Bottom (2.5P)	3.938	0.626	1.575	0.381	0.286	0.438	0.351	0.357
2625076118	●	7/16 - 14 UNC	H8	Bottom (1.5P)	3.938	0.713	1.713	0.323	0.242	0.406	0.397	0.405
2625076145	●	7/16 - 14 UNC	H5	Modified Bottom (2.5P)	3.938	0.713	1.713	0.323	0.242	0.406	0.397	0.405
2625076148	●	7/16 - 14 UNC	H8	Modified Bottom (2.5P)	3.938	0.713	1.713	0.323	0.242	0.406	0.397	0.405
2625076205	●	7/16 - 20 UNF	H5	Modified Bottom (2.5P)	3.938	0.713	1.713	0.323	0.242	0.406	0.409	0.415
2625076208	●	7/16 - 20 UNF	H8	Modified Bottom (2.5P)	3.938	0.713	1.713	0.323	0.242	0.406	0.409	0.415
2625076218	●	7/16 - 20 UNF	H8	Bottom (1.5P)	3.938	0.713	1.713	0.323	0.242	0.406	0.409	0.415
2625012118	●	1/2 - 13 UNC	H8	Bottom (1.5P)	4.331	0.768	1.934	0.367	0.275	0.438	0.457	0.465
2625012135	●	1/2 - 13 UNC	H5	Modified Bottom (2.5P)	4.331	0.768	1.934	0.367	0.275	0.438	0.457	0.465
2625012138	●	1/2 - 13 UNC	H8	Modified Bottom (2.5P)	4.331	0.768	1.934	0.367	0.275	0.438	0.457	0.465
2625012205	●	1/2 - 20 UNF	H5	Modified Bottom (2.5P)	3.938	0.768	1.934	0.367	0.275	0.438	0.472	0.477
2625012208	●	1/2 - 20 UNF	H8	Modified Bottom (2.5P)	3.938	0.768	1.934	0.367	0.275	0.438	0.472	0.477
2625012218	●	1/2 - 20 UNF	H8	Bottom (1.5P)	3.938	0.768	1.934	0.367	0.275	0.438	0.472	0.477
2625096127	●	9/16 - 12 UNC	H7	Modified Bottom (2.5P)	4.331	0.835	1.973	0.429	0.322	0.500	0.515	0.525
2625096120	●	9/16 - 12 UNC	H10	Modified Bottom (2.5P)	4.331	0.835	1.973	0.429	0.322	0.500	0.515	0.525
2625091117	●	9/16 - 12 UNC	H7	Bottom (1.5P)	4.331	0.835	1.973	0.429	0.322	0.500	0.515	0.525
2625096187	●	9/16 - 18 UNF	H7	Modified Bottom (2.5P)	3.938	0.835	1.973	0.429	0.322	0.500	0.531	0.538
2625096180	●	9/16 - 18 UNF	H10	Modified Bottom (2.5P)	3.938	0.835	1.973	0.429	0.322	0.500	0.531	0.538
2625091810	○	9/16 - 18 UNF	H10	Bottom (1.5P)	3.938	0.835	1.973	0.429	0.322	0.500	0.531	0.538
2625058110	●	5/8 - 11 UNC	H10	Modified Bottom (2.5P)	4.331	0.910	2.126	0.480	0.360	0.563	0.574	0.584
2625058117	●	5/8 - 11 UNC	H7	Modified Bottom (2.5P)	4.331	0.910	2.126	0.480	0.360	0.563	0.574	0.584
2625058410	●	5/8 - 11 UNC	H10	Bottom (1.5P)	4.331	0.910	2.126	0.480	0.360	0.563	0.574	0.584
2625058180	●	5/8 - 18 UNF	H10	Modified Bottom (2.5P)	3.938	0.910	2.126	0.480	0.360	0.563	0.594	0.600
2625058187	●	5/8 - 18 UNF	H7	Modified Bottom (2.5P)	3.938	0.910	2.126	0.480	0.360	0.563	0.594	0.600
2625058810	●	5/8 - 18 UNF	H10	Bottom (1.5P)	3.938	0.910	2.126	0.480	0.360	0.563	0.594	0.600
2625034100	●	3/4 - 10 UNC	H10	Modified Bottom (2.5P)	4.922	1.000	2.434	0.590	0.442	0.688	0.693	0.704
2625034107	●	3/4 - 10 UNC	H7	Modified Bottom (2.5P)	4.922	1.000	2.434	0.590	0.442	0.688	0.693	0.704
2625034110	●	3/4 - 10 UNC	H10	Bottom (1.5P)	4.922	1.000	2.434	0.590	0.442	0.688	0.693	0.704
2625034160	●	3/4 - 16 UNF	H10	Modified Bottom (2.5P)	4.331	1.000	2.434	0.590	0.442	0.688	0.714	0.722

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details

CONTINUED ATP

	P					M			K	N		S		H			
	Steel					Stainless Steel				Non-Ferrous		HRSA		Hardened Steel			
	Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium				
	Low	Medium	High			6061	Casting	Inconel		6Al4V	~35	35-45	45-50	50-70			
	1010	1035	1065	4140	300	400	17-4 PH	7075				(30 HRC)	HRC	HRC	HRC	HRC	
	1018	1045		4340													
	⊙	⊙	⊙	⊙	⊙	⊙	⊙		⊙	⊙	○	○	⊙	○			
2.5P, ≤ 1/2	30-165 SFM	30-165 SFM	30-130 SFM	30-115 SFM	15-100 SFM	15-50 SFM	15-50 SFM	10-30 SFM		65-165 SFM	65-165 SFM	8-12 SFM	8-15 SFM	15-100 SFM	8-25 SFM		
2.5P, ≥ 9/16	15-85 SFM	15-85 SFM	15-65 SFM	15-50 SFM	15-50 SFM	15-35 SFM	15-35 SFM	10-25 SFM		30-100 SFM	30-100 SFM	8-12 SFM	8-15 SFM	15-50 SFM	8-12 SFM		
1.5P	15-85 SFM	15-85 SFM	15-65 SFM	15-50 SFM	15-50 SFM	15-35 SFM	15-35 SFM	10-25 SFM		30-85 SFM	30-85 SFM	8-12 SFM	8-15 SFM	15-50 SFM	8-12 SFM		

1. Speeds given are assuming the use of water-soluble coolant.

2. For stainless steel, please use non-water-soluble coolant or highly lubricated water-soluble coolant.

○ Good ○ Best

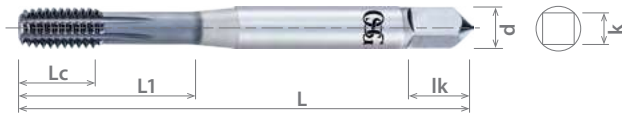


A Brand A-XPF

Highly Efficient Multi-Purpose Forming Tap

List 26250 (Continued)

A BRAND A-XPF



EDP Number		Thread Size	Thread Limit	Chamfer Type	Overall Length	Thread Length	Neck Length	Shank Diameter	Square Width	Square Length	Tap Drill Size	
					L (Inch)	Lc (Inch)	L1 (Inch)	d (Inch)	k (Inch)	Ik (Inch)	Min (Inch)	Max (Inch)
2625034167	●	3/4 - 16 UNF	H7	Modified Bottom (2.5P)	4.331	1.000	2.434	0.590	0.442	0.688	0.714	0.722
2625034610	●	3/4 - 16 UNF	H10	Bottom (1.5P)	3.938	1.000	2.434	0.590	0.442	0.688	0.714	0.722
2625078901	●	7/8 - 9 UNC	H11	Modified Bottom (2.5P)	5.512	1.111	2.654	0.697	0.523	0.750	0.812	0.824
2625078908	●	7/8 - 9 UNC	H8	Modified Bottom (2.5P)	5.512	1.111	2.654	0.697	0.523	0.750	0.812	0.824
2625078911	○	7/8 - 9 UNC	H11	Bottom (1.5P)	5.512	1.111	2.654	0.697	0.523	0.750	0.812	0.824
2625078111	○	7/8 - 14 UNF	H11	Bottom (1.5P)	4.922	1.111	2.654	0.697	0.523	0.750	0.835	0.843
2625078141	●	7/8 - 14 UNF	H11	Modified Bottom (2.5P)	4.922	1.111	2.654	0.697	0.523	0.750	0.835	0.843
2625078148	○	7/8 - 14 UNF	H8	Modified Bottom (2.5P)	4.922	1.111	2.654	0.697	0.523	0.750	0.835	0.843
2625001081	●	1 - 8 UNC	H11	Modified Bottom (2.5P)	6.300	1.252	3.012	0.800	0.600	0.813	0.929	0.942
2625001088	●	1 - 8 UNC	H8	Modified Bottom (2.5P)	6.300	1.252	3.012	0.800	0.600	0.813	0.929	0.942
2625018111	●	1 - 8 UNC	H11	Bottom (1.5P)	6.300	1.252	3.012	0.800	0.600	0.813	0.929	0.942
2625001121	○	1 - 12 UNF	H11	Modified Bottom (2.5P)	5.512	1.252	3.012	0.800	0.600	0.813	0.953	0.962
2625001128	○	1 - 12 UNF	H8	Modified Bottom (2.5P)	5.512	1.252	3.012	0.800	0.600	0.813	0.953	0.962
2625011211	●	1 - 12 UNF	H11	Bottom (1.5P)	5.512	1.252	3.012	0.800	0.600	0.813	0.953	0.962

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details

ATP

	P					M			K	N		S		H			
	Steel					Stainless Steel				Non-Ferrous		HRSA		Hardened Steel			
	Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium				
	Low	Medium	High							6061 7075	Casting	Inconel	6Al4V (30 HRC)				
	1010 1018	1035 1045	1065	4140 4340	300	400	17-4 PH					~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC		
	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙		⊙	⊙	○	○	⊙	○		
2.5P, ≤ 1/2	30-165 SFM	30-165 SFM	30-130 SFM	30-115 SFM	15-100 SFM	15-50 SFM	15-50 SFM	10-30 SFM		65-165 SFM	65-165 SFM	8-12 SFM	8-15 SFM	15-100 SFM	8-25 SFM		
2.5P, ≥ 9/16	15-85 SFM	15-85 SFM	15-65 SFM	15-50 SFM	15-50 SFM	15-35 SFM	15-35 SFM	10-25 SFM		30-100 SFM	30-100 SFM	8-12 SFM	8-15 SFM	15-50 SFM	8-12 SFM		
1.5P	15-85 SFM	15-85 SFM	15-65 SFM	15-50 SFM	15-50 SFM	15-35 SFM	15-35 SFM	10-25 SFM		30-85 SFM	30-85 SFM	8-12 SFM	8-15 SFM	15-50 SFM	8-12 SFM		

1. Speeds given are assuming the use of water-soluble coolant.

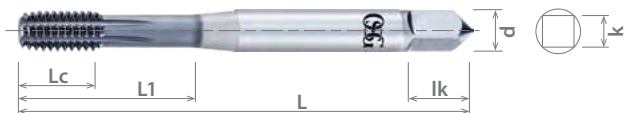
2. For stainless steel, please use non-water-soluble coolant or highly lubricated water-soluble coolant.

○ Good ○ Best



List 26350

A BRAND A-XPF



EDP Number		Thread Size	Thread Limit	Chamfer Type	Overall Length	Thread Length	Neck Length	Shank Diameter	Square Width	Square Length	Tap Drill Size	
					L (mm)	Lc (mm)	L1 (mm)	d (mm)	k (mm)	lk (mm)	Min (mm)	Max (mm)
2635012515	●	M1 x 0.25	D5	Bottom (1.5P)	40.00	5.50	6.50	3.58	2.79	4.76	0.87	0.91
2635012525	●	M1 x 0.25	D5	Modified Bottom (2.5P)	40.00	5.50	6.50	3.58	2.79	4.76	0.87	0.91
2635012215	●	M1.2 x 0.25	D5	Bottom (1.5P)	40.00	5.50	6.50	3.58	2.79	4.76	1.07	1.11
2635012225	●	M1.2 x 0.25	D5	Modified Bottom (2.5P)	40.00	5.50	6.50	3.58	2.79	4.76	1.07	1.11
2635014315	●	M1.4 x 0.3	D5	Bottom (1.5P)	40.00	7.00	8.00	3.58	2.79	4.76	1.25	1.29
2635014325	○	M1.4 x 0.3	D5	Modified Bottom (2.5P)	40.00	7.00	8.00	3.58	2.79	4.76	1.25	1.29
2635016315	●	M1.6 x 0.35	D5	Bottom (1.5P)	40.00	8.00	9.00	3.58	2.79	4.76	1.40	1.45
2635016353	●	M1.6 x 0.35	D3	Modified Bottom (2.5P)	40.00	8.00	9.00	3.58	2.79	4.76	1.40	1.45
2635016355	●	M1.6 x 0.35	D5	Modified Bottom (2.5P)	40.00	8.00	9.00	3.58	2.79	4.76	1.40	1.45
2635017315	●	M1.7 x 0.35	D5	Bottom (1.5P)	40.00	8.00	9.00	3.58	2.79	4.76	1.50	1.55
2635017353	○	M1.7 x 0.35	D3	Modified Bottom (2.5P)	40.00	8.00	9.00	3.58	2.79	4.76	1.50	1.55
2635017355	○	M1.7 x 0.35	D5	Modified Bottom (2.5P)	40.00	8.00	9.00	3.58	2.79	4.76	1.50	1.55
2635018315	○	M1.8 x 0.35	D5	Bottom (1.5P)	40.00	8.00	9.00	3.58	2.79	4.76	1.60	1.65
2635018353	○	M1.8 x 0.35	D3	Modified Bottom (2.5P)	40.00	8.00	9.00	3.58	2.79	4.76	1.60	1.65
2635018355	●	M1.8 x 0.35	D5	Modified Bottom (2.5P)	40.00	8.00	9.00	3.58	2.79	4.76	1.60	1.65
2635024155	●	M2 x 0.4	D5	Bottom (1.5P)	45.00	8.00	9.00	3.58	2.79	4.76	1.77	1.83
2635002043	●	M2 x 0.4	D3	Modified Bottom (2.5P)	45.00	8.00	9.00	3.58	2.79	4.76	1.77	1.83
2635002045	●	M2 x 0.4	D5	Modified Bottom (2.5P)	45.00	8.00	9.00	3.58	2.79	4.76	1.77	1.83
2635025415	●	M2.5 x 0.45	D5	Bottom (1.5P)	50.00	9.50	10.50	3.58	2.79	4.76	2.25	2.31
2635025453	●	M2.5 x 0.45	D3	Modified Bottom (2.5P)	50.00	9.50	10.50	3.58	2.79	4.76	2.25	2.31
2635025455	●	M2.5 x 0.45	D5	Modified Bottom (2.5P)	50.00	9.50	10.50	3.58	2.79	4.76	2.25	2.31
2635026415	○	M2.6 x 0.45	D5	Bottom (1.5P)	50.00	9.50	10.50	3.58	2.79	4.76	2.35	2.41
2635026425	○	M2.6 x 0.45	D5	Modified Bottom (2.5P)	50.00	9.50	10.50	3.58	2.79	4.76	2.35	2.41
2635003053	●	M3 x 0.5	D3	Modified Bottom (2.5P)	56.00	6.00	18.00	3.58	2.79	4.76	2.72	2.79
2635003055	●	M3 x 0.5	D5	Modified Bottom (2.5P)	56.00	6.00	18.00	3.58	2.79	4.76	2.72	2.79
2635003353	●	M3 x 0.35	D3	Modified Bottom (2.5P)	56.00	6.00	18.00	3.58	2.79	4.76	2.80	2.85
2635003355	○	M3 x 0.35	D5	Modified Bottom (2.5P)	56.00	6.00	18.00	3.58	2.79	4.76	2.80	2.85
2635030515	●	M3 x 0.5	D5	Bottom (1.5P)	56.00	6.00	18.00	3.58	2.79	4.76	2.72	2.79
2635033515	○	M3 x 0.35	D5	Bottom (1.5P)	56.00	6.00	18.00	3.58	2.79	4.76	2.80	2.85
2635035064	●	M3.5 x 0.6	D4	Modified Bottom (2.5P)	56.00	7.20	20.00	3.58	2.79	4.76	3.16	3.24
2635035066	○	M3.5 x 0.6	D6	Modified Bottom (2.5P)	56.00	7.20	20.00	3.58	2.79	4.76	3.16	3.24
2635035616	●	M3.5 x 0.6	D6	Bottom (1.5P)	56.00	7.20	20.00	3.58	2.79	4.76	3.16	3.24
2635004054	○	M4 x 0.5	D4	Modified Bottom (2.5P)	63.00	8.40	21.00	4.27	3.33	6.35	3.72	3.79
2635004056	●	M4 x 0.5	D6	Modified Bottom (2.5P)	63.00	8.40	21.00	4.27	3.33	6.35	3.72	3.79
2635004074	●	M4 x 0.7	D4	Modified Bottom (2.5P)	63.00	8.40	21.00	4.27	3.33	6.35	3.60	3.70
2635004076	●	M4 x 0.7	D6	Modified Bottom (2.5P)	63.00	8.40	21.00	4.27	3.33	6.35	3.60	3.70
2635040516	●	M4 x 0.5	D6	Bottom (1.5P)	63.00	8.40	21.00	4.27	3.33	6.35	3.72	3.79
2635040716	●	M4 x 0.7	D6	Bottom (1.5P)	63.00	8.40	21.00	4.27	3.33	6.35	3.60	3.70
2635045716	○	M4.5 x 0.75	D6	Bottom (1.5P)	70.00	9.00	25.00	4.93	3.86	6.35	4.08	4.17
2635045754	○	M4.5 x 0.75	D4	Modified Bottom (2.5P)	70.00	9.00	25.00	4.93	3.86	6.35	4.08	4.17
2635045756	○	M4.5 x 0.75	D6	Modified Bottom (2.5P)	70.00	9.00	25.00	4.93	3.86	6.35	4.08	4.17
2635005053	○	M5 x 0.5	D3	Modified Bottom (2.5P)	70.00	9.60	25.00	4.93	3.86	6.35	4.72	4.79
2635005055	●	M5 x 0.5	D5	Modified Bottom (2.5P)	70.00	9.60	25.00	4.93	3.86	6.35	4.72	4.79
2635005084	●	M5 x 0.8	D4	Modified Bottom (2.5P)	70.00	9.60	25.00	4.93	3.86	6.35	4.55	4.65

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details

CONTINUED

	P					M			K	N		S		H			
	Steel					Stainless Steel				Non-Ferrous		HRSA		Hardened Steel			
	Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium				
	Low	Medium	High							6061 7075	Casting	Inconel	6Al4V (30 HRC)				
	1010 1018	1035 1045	1065	4140 4340	300	400	17-4 PH	6061 7075		Casting	Inconel	6Al4V (30 HRC)	~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC	
	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙		⊙	⊙	○	○	⊙	○		
2.5P, ≤ M12	30-165 SFM	30-165 SFM	30-130 SFM	30-115 SFM	15-100 SFM	15-50 SFM	15-50 SFM	10-30 SFM		65-165 SFM	65-165 SFM	8-12 SFM	8-15 SFM	15-100 SFM	8-25 SFM		
2.5P, ≥ M14	15-85 SFM	15-85 SFM	15-65 SFM	15-50 SFM	15-50 SFM	15-35 SFM	15-35 SFM	10-25 SFM		30-100 SFM	30-100 SFM	8-12 SFM	8-15 SFM	15-50 SFM	8-12 SFM		
1.5P	15-85 SFM	15-85 SFM	15-65 SFM	15-50 SFM	15-50 SFM	15-35 SFM	15-35 SFM	10-25 SFM		30-85 SFM	30-85 SFM	8-12 SFM	8-15 SFM	15-50 SFM	8-12 SFM		

1. Speeds given are assuming the use of water-soluble coolant.

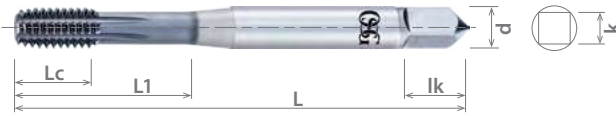
2. For stainless steel, please use non-water-soluble coolant or highly lubricated water-soluble coolant.

○ Good ○ Best



List 26350 (Continued)

A BRAND A-XPF



EDP Number		Thread Size	Thread Limit	Chamfer Type	Overall Length	Thread Length	Neck Length	Shank Diameter	Square Width	Square Length	Tap Drill Size	
					L (mm)	Lc (mm)	L1 (mm)	d (mm)	k (mm)	lk (mm)	Min (mm)	Max (mm)
2635005087	●	M5 x 0.8	D7	Modified Bottom (2.5P)	70.00	9.60	25.00	4.93	3.86	6.35	4.55	4.65
2635005015	●	M5 x 0.5	D5	Bottom (1.5P)	70.00	9.60	25.00	4.93	3.86	6.35	4.72	4.79
2635005087	●	M5 x 0.8	D7	Bottom (1.5P)	70.00	9.60	25.00	4.93	3.86	6.35	4.55	4.65
2635006015	●	M6 x 1	D5	Modified Bottom (2.5P)	80.00	10.00	30.00	6.48	4.85	7.94	5.43	5.56
2635006018	●	M6 x 1	D8	Modified Bottom (2.5P)	80.00	10.00	30.00	6.48	4.85	7.94	5.43	5.56
2635006754	●	M6 x 0.75	D4	Modified Bottom (2.5P)	80.00	10.00	30.00	6.48	4.85	7.94	5.57	5.67
2635006757	●	M6 x 0.75	D7	Modified Bottom (2.5P)	80.00	10.00	30.00	6.48	4.85	7.94	5.57	5.67
2635060118	●	M6 x 1	D8	Bottom (1.5P)	80.00	10.00	30.00	6.48	4.85	7.94	5.43	5.56
2635067517	●	M6 x 0.75	D7	Bottom (1.5P)	80.00	10.00	30.00	6.48	4.85	7.94	5.57	5.67
2635007015	●	M7 x 1	D5	Modified Bottom (2.5P)	80.00	12.00	30.00	8.08	6.05	9.53	6.43	6.56
2635007018	●	M7 x 1	D8	Modified Bottom (2.5P)	80.00	12.00	30.00	8.08	6.05	9.53	6.43	6.56
2635070118	●	M7 x 1	D8	Bottom (1.5P)	80.00	12.00	30.00	8.08	6.05	9.53	6.43	6.56
2635008015	●	M8 x 1	D5	Modified Bottom (2.5P)	90.00	12.00	35.00	8.08	6.05	9.53	7.43	7.56
2635008018	●	M8 x 1	D8	Modified Bottom (2.5P)	90.00	12.00	35.00	8.08	6.05	9.53	7.43	7.56
2635008255	●	M8 x 1.25	D5	Modified Bottom (2.5P)	90.00	12.00	35.00	8.08	6.05	9.53	7.29	7.43
2635008259	●	M8 x 1.25	D9	Modified Bottom (2.5P)	90.00	12.00	35.00	8.08	6.05	9.53	7.29	7.43
2635008754	○	M8 x 0.75	D4	Modified Bottom (2.5P)	80.00	12.00	30.00	8.08	6.05	9.53	7.57	7.67
2635008757	○	M8 x 0.75	D7	Modified Bottom (2.5P)	80.00	12.00	30.00	8.08	6.05	9.53	7.57	7.67
2635080118	●	M8 x 1	D8	Bottom (1.5P)	90.00	12.00	35.00	8.08	6.05	9.53	7.43	7.56
2635081219	●	M8 x 1.25	D9	Bottom (1.5P)	90.00	12.00	35.00	8.08	6.05	9.53	7.29	7.43
2635087517	○	M8 x 0.75	D7	Bottom (1.5P)	80.00	12.00	30.00	8.08	6.05	9.53	7.57	7.67
2635010015	●	M10 x 1	D5	Modified Bottom (2.5P)	90.00	15.00	35.00	9.68	7.26	11.11	9.43	9.56
2635010018	●	M10 x 1	D8	Modified Bottom (2.5P)	90.00	15.00	35.00	9.68	7.26	11.11	9.43	9.56
2635010110	●	M10 x 1.5	D10	Bottom (1.5P)	100.00	15.00	39.00	9.68	7.26	11.11	9.15	9.31
2635010118	●	M10 x 1	D8	Bottom (1.5P)	90.00	15.00	35.00	9.68	7.26	11.11	9.43	9.56
2635010119	●	M10 x 1.25	D9	Bottom (1.5P)	100.00	15.00	39.00	9.68	7.26	11.11	9.29	9.43
2635010150	●	M10 x 1.5	D10	Modified Bottom (2.5P)	100.00	15.00	39.00	9.68	7.26	11.11	9.15	9.31
2635010156	●	M10 x 1.5	D6	Modified Bottom (2.5P)	100.00	15.00	39.00	9.68	7.26	11.11	9.15	9.31
2635010255	●	M10 x 1.25	D5	Modified Bottom (2.5P)	100.00	15.00	39.00	9.68	7.26	11.11	9.29	9.43
2635010259	●	M10 x 1.25	D9	Modified Bottom (2.5P)	100.00	15.00	39.00	9.68	7.26	11.11	9.29	9.43
2635012110	●	M12 x 1	D10	Bottom (1.5P)	100.00	17.00	49.10	9.32	6.99	11.11	11.43	11.56
2635012111	●	M12 x 1.5	D11	Bottom (1.5P)	100.00	17.00	49.10	9.32	6.99	11.11	11.15	11.31
2635012120	●	M12 x 1	D10	Modified Bottom (2.5P)	100.00	17.00	49.10	9.32	6.99	11.11	11.43	11.56
2635012151	●	M12 x 1.5	D11	Modified Bottom (2.5P)	100.00	17.00	49.10	9.32	6.99	11.11	11.15	11.31
2635012156	●	M12 x 1.5	D6	Modified Bottom (2.5P)	100.00	17.00	49.10	9.32	6.99	11.11	11.15	11.31
2635012171	●	M12 x 1.75	D11	Bottom (1.5P)	110.00	17.00	49.10	9.32	6.99	11.11	11.01	11.18
2635012210	●	M12 x 1.25	D10	Bottom (1.5P)	100.00	17.00	49.10	9.32	6.99	11.11	11.29	11.43
2635012220	●	M12 x 1.25	D10	Modified Bottom (2.5P)	100.00	17.00	49.10	9.32	6.99	11.11	11.29	11.43
2635012751	●	M12 x 1.75	D11	Modified Bottom (2.5P)	110.00	17.00	49.10	9.32	6.99	11.11	11.01	11.18
2635012756	●	M12 x 1.75	D6	Modified Bottom (2.5P)	110.00	17.00	49.10	9.32	6.99	11.11	11.01	11.18
2635014022	●	M14 x 2	D12	Modified Bottom (2.5P)	110.00	20.00	50.10	10.90	8.18	12.70	12.87	13.06
2635014027	●	M14 x 2	D7	Modified Bottom (2.5P)	110.00	20.00	50.10	10.90	8.18	12.70	12.87	13.06
2635014151	●	M14 x 1.5	D11	Modified Bottom (2.5P)	100.00	20.00	50.10	10.90	8.18	12.70	13.15	13.31
2635014156	●	M14 x 1.5	D6	Modified Bottom (2.5P)	100.00	20.00	50.10	10.90	8.18	12.70	13.15	13.31
2635014212	●	M14 x 2	D12	Bottom (1.5P)	110.00	20.00	50.10	10.90	8.18	12.70	12.87	13.06
2635014511	●	M14 x 1.5	D11	Bottom (1.5P)	100.00	20.00	50.10	10.90	8.18	12.70	13.15	13.31
2635016111	●	M16 x 1.5	D11	Bottom (1.5P)	100.00	20.00	54.00	12.19	9.14	14.29	15.15	15.31
2635016151	●	M16 x 1.5	D11	Modified Bottom (2.5P)	100.00	20.00	54.00	12.19	9.14	14.29	15.15	15.31
2635016156	●	M16 x 1.5	D6	Modified Bottom (2.5P)	100.00	20.00	54.00	12.19	9.14	14.29	15.15	15.31
2635016202	●	M16 x 2	D12	Modified Bottom (2.5P)	110.00	20.00	54.00	12.19	9.14	14.29	14.87	15.06
2635016207	●	M16 x 2	D7	Modified Bottom (2.5P)	110.00	20.00	54.00	12.19	9.14	14.29	14.87	15.06
2635016212	●	M16 x 2	D12	Bottom (1.5P)	110.00	20.00	54.00	12.19	9.14	14.29	14.87	15.06
2635018111	●	M18 x 1.5	D11	Bottom (1.5P)	110.00	25.00	55.00	13.77	10.31	15.88	17.15	17.31
2635018151	●	M18 x 1.5	D11	Modified Bottom (2.5P)	110.00	25.00	55.00	13.77	10.31	15.88	17.15	17.31
2635018156	○	M18 x 1.5	D6	Modified Bottom (2.5P)	110.00	25.00	55.00	13.77	10.31	15.88	17.15	17.31

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details



List 26350 (Continued)

A BRAND A-XPF



EDP Number		Thread Size	Thread Limit	Chamfer Type	Overall Length	Thread Length	Neck Length	Shank Diameter	Square Width	Square Length	Tap Drill Size	
					L (mm)	Lc (mm)	L1 (mm)	d (mm)	k (mm)	lk (mm)	Min (mm)	Max (mm)
2635018212	○	M18 x 2.5	D12	Bottom (1.5P)	125.00	25.00	55.00	13.77	10.31	15.88	16.59	16.82
2635018252	●	M18 x 2.5	D12	Modified Bottom (2.5P)	125.00	25.00	55.00	13.77	10.31	15.88	16.59	16.82
2635018257	●	M18 x 2.5	D7	Modified Bottom (2.5P)	125.00	25.00	55.00	13.77	10.31	15.88	16.59	16.82
2635020111	●	M20 x 1.5	D11	Bottom (1.5P)	125.00	25.00	61.80	16.56	12.42	17.46	19.15	19.31
2635020151	●	M20 x 1.5	D11	Modified Bottom (2.5P)	125.00	25.00	61.80	16.56	12.42	17.46	19.15	19.31
2635020156	●	M20 x 1.5	D6	Modified Bottom (2.5P)	125.00	25.00	61.80	16.56	12.42	17.46	19.15	19.31
2635020212	●	M20 x 2.5	D12	Bottom (1.5P)	140.00	25.00	61.80	16.56	12.42	17.46	18.58	18.82
2635020252	●	M20 x 2.5	D12	Modified Bottom (2.5P)	140.00	25.00	61.80	16.56	12.42	17.46	18.58	18.82
2635020257	●	M20 x 2.5	D7	Modified Bottom (2.5P)	140.00	25.00	61.80	16.56	12.42	17.46	18.58	18.82
2635022111	●	M22 x 1.5	D11	Bottom (1.5P)	125.00	25.00	67.40	17.70	13.28	19.05	21.15	21.31
2635022121	●	M22 x 1.5	D11	Modified Bottom (2.5P)	125.00	25.00	67.40	17.70	13.28	19.05	21.15	21.31
2635022212	○	M22 x 2	D12	Bottom (1.5P)	140.00	25.00	67.40	17.70	13.28	19.05	20.87	21.06
2635022222	○	M22 x 2	D12	Modified Bottom (2.5P)	140.00	25.00	67.40	17.70	13.28	19.05	20.87	21.06
2635022512	○	M22 x 2.5	D12	Bottom (1.5P)	140.00	25.00	67.40	17.70	13.28	19.05	20.58	20.82
2635022522	●	M22 x 2.5	D12	Modified Bottom (2.5P)	140.00	25.00	67.40	17.70	13.28	19.05	20.58	20.82
2635024111	○	M24 x 1.5	D11	Bottom (1.5P)	140.00	25.00	68.40	19.30	14.48	19.05	23.15	23.31
2635024121	○	M24 x 1.5	D11	Modified Bottom (2.5P)	140.00	25.00	68.40	19.30	14.48	19.05	23.15	23.31
2635024123	●	M24 x 2	D13	Bottom (1.5P)	140.00	30.00	68.40	19.30	14.48	19.05	22.87	23.06
2635024223	●	M24 x 2	D13	Modified Bottom (2.5P)	140.00	30.00	68.40	19.30	14.48	19.05	22.87	23.06
2635024315	●	M24 x 3	D15	Bottom (1.5P)	160.00	30.00	68.40	19.30	14.48	19.05	22.30	22.56
2635024325	●	M24 x 3	D15	Modified Bottom (2.5P)	160.00	30.00	68.40	19.30	14.48	19.05	22.30	22.56

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details



	P					M			K	N		S		H			
	Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel			
	Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium				
	Low	Medium	High														
	1010	1035	1065	4140	4340	300	400	17-4 PH		6061 7075	Casting	Inconel	6Al4V (30 HRC)	~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC
	⊙	⊙	⊙	⊙		⊙	⊙	⊙		⊙	⊙	○	○	⊙	○		
2.5P, ≤ M12	30-165 SFM	30-165 SFM	30-130 SFM	30-115 SFM	15-100 SFM	15-50 SFM	15-50 SFM	10-30 SFM		65-165 SFM	65-165 SFM	8-12 SFM	8-15 SFM	15-100 SFM	8-25 SFM		
2.5P, ≥ M14	15-85 SFM	15-85 SFM	15-65 SFM	15-50 SFM	15-50 SFM	15-35 SFM	15-35 SFM	10-25 SFM		30-100 SFM	30-100 SFM	8-12 SFM	8-15 SFM	15-50 SFM	8-12 SFM		
1.5P	15-85 SFM	15-85 SFM	15-65 SFM	15-50 SFM	15-50 SFM	15-35 SFM	15-35 SFM	10-25 SFM		30-85 SFM	30-85 SFM	8-12 SFM	8-15 SFM	15-50 SFM	8-12 SFM		

1. Speeds given are assuming the use of water-soluble coolant.

2. For stainless steel, please use non-water-soluble coolant or highly lubricated water-soluble coolant.

○ Good ○ Best

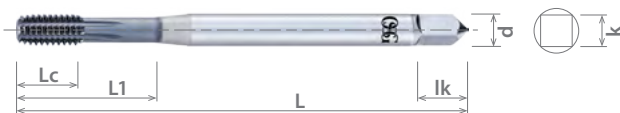


A Brand A-LT-XPF

Highly Efficient Multi-Purpose Forming Tap

List 26255

A BRAND A-LT-XPF



EDP Number		Thread Size	Thread Limit	Chamfer Type	Overall Length	Thread Length	Neck Length	Shank Diameter	Square Width	Square Length	Tap Drill Size	
					L (Inch)	Lc (Inch)	L1 (Inch)	d (Inch)	k (Inch)	lk (Inch)	Min (Inch)	Max (Inch)
2625554025	○	No. 5 - 40 UNC	H5	Modified Bottom (2.5P)	3.150	0.300	0.709	0.141	0.110	0.188	0.111	0.115
2625554255	○	No. 5 - 40 UNC	H5	Modified Bottom (2.5P)	4.725	0.300	0.709	0.141	0.110	0.188	0.111	0.115
2625554425	○	No. 5 - 44 UNF	H5	Modified Bottom (2.5P)	3.150	0.300	0.709	0.141	0.110	0.188	0.112	0.116
2625554205	○	No. 5 - 44 UNF	H5	Modified Bottom (2.5P)	4.725	0.300	0.709	0.141	0.110	0.188	0.112	0.116
2625563225	●	No. 6 - 32 UNC	H5	Modified Bottom (2.5P)	3.150	0.375	0.788	0.141	0.110	0.188	0.120	0.125
2625563255	●	No. 6 - 32 UNC	H5	Modified Bottom (2.5P)	4.725	0.375	0.788	0.141	0.110	0.188	0.120	0.125
2625564025	○	No. 6 - 40 UNF	H5	Modified Bottom (2.5P)	3.150	0.375	0.788	0.141	0.110	0.188	0.124	0.128
2625564255	○	No. 6 - 40 UNF	H5	Modified Bottom (2.5P)	4.725	0.375	0.788	0.141	0.110	0.188	0.124	0.128
2625583225	●	No. 8 - 32 UNC	H5	Modified Bottom (2.5P)	3.150	0.375	0.827	0.168	0.131	0.250	0.146	0.151
2625583255	●	No. 8 - 32 UNC	H5	Modified Bottom (2.5P)	4.725	0.375	0.827	0.168	0.131	0.250	0.146	0.151
2625583625	○	No. 8 - 36 UNF	H5	Modified Bottom (2.5P)	3.150	0.375	0.827	0.168	0.131	0.250	0.148	0.152
2625586255	○	No. 8 - 36 UNF	H5	Modified Bottom (2.5P)	4.725	0.375	0.827	0.168	0.131	0.250	0.148	0.152
2625510226	●	No. 10 - 24 UNC	H6	Modified Bottom (2.5P)	3.938	0.500	0.945	0.194	0.152	0.250	0.166	0.172
2625510426	●	No. 10 - 24 UNC	H6	Modified Bottom (2.5P)	5.906	0.500	0.945	0.194	0.152	0.250	0.166	0.172
2625510326	●	No. 10 - 32 UNF	H6	Modified Bottom (2.5P)	3.938	0.500	0.945	0.194	0.152	0.250	0.172	0.176
2625510256	●	No. 10 - 32 UNF	H6	Modified Bottom (2.5P)	5.906	0.500	0.945	0.194	0.152	0.250	0.172	0.176
2625512227	○	No. 12 - 24 UNC	H7	Modified Bottom (2.5P)	3.938	0.500	1.103	0.220	0.165	0.281	0.192	0.198
2625512427	○	No. 12 - 24 UNC	H7	Modified Bottom (2.5P)	5.906	0.500	1.103	0.220	0.165	0.281	0.192	0.198
2625512827	○	No. 12 - 28 UNF	H7	Modified Bottom (2.5P)	3.938	0.500	1.103	0.220	0.165	0.281	0.196	0.200
2625512257	○	No. 12 - 28 UNF	H7	Modified Bottom (2.5P)	5.906	0.500	1.103	0.220	0.165	0.281	0.196	0.200
2625514226	●	1/4 - 20 UNC	H6	Modified Bottom (2.5P)	3.938	0.500	1.182	0.255	0.191	0.313	0.222	0.227
2625514026	●	1/4 - 20 UNC	H6	Modified Bottom (2.5P)	5.906	0.500	1.182	0.255	0.191	0.313	0.222	0.227
2625514826	●	1/4 - 28 UNF	H6	Modified Bottom (2.5P)	3.938	0.500	1.182	0.255	0.191	0.313	0.230	0.234
2625514256	●	1/4 - 28 UNF	H6	Modified Bottom (2.5P)	5.906	0.500	1.182	0.255	0.191	0.313	0.230	0.234
2625551127	●	5/16 - 18 UNC	H7	Modified Bottom (2.5P)	4.331	0.556	1.378	0.318	0.238	0.375	0.281	0.288
2625556127	●	5/16 - 18 UNC	H7	Modified Bottom (2.5P)	5.906	0.556	1.378	0.318	0.238	0.375	0.281	0.288
2625551227	●	5/16 - 24 UNF	H7	Modified Bottom (2.5P)	4.331	0.556	1.378	0.318	0.238	0.375	0.289	0.294
2625551427	●	5/16 - 24 UNF	H7	Modified Bottom (2.5P)	5.906	0.556	1.378	0.318	0.238	0.375	0.289	0.294
2625538127	●	3/8 - 16 UNC	H7	Modified Bottom (2.5P)	4.725	0.626	1.575	0.381	0.286	0.438	0.339	0.347
2625538627	●	3/8 - 16 UNC	H7	Modified Bottom (2.5P)	5.906	0.626	1.575	0.381	0.286	0.438	0.339	0.347
2625538227	●	3/8 - 24 UNF	H7	Modified Bottom (2.5P)	4.725	0.626	1.575	0.381	0.286	0.438	0.351	0.357
2625538427	●	3/8 - 24 UNF	H7	Modified Bottom (2.5P)	5.906	0.626	1.575	0.381	0.286	0.438	0.351	0.357
2625571128	○	7/16 - 14 UNC	H8	Modified Bottom (2.5P)	4.725	0.713	1.713	0.323	0.242	0.406	0.397	0.405
2625576128	○	7/16 - 14 UNC	H8	Modified Bottom (2.5P)	5.906	0.713	1.713	0.323	0.242	0.406	0.397	0.405
2625571228	●	7/16 - 20 UNF	H8	Modified Bottom (2.5P)	4.725	0.713	1.713	0.323	0.242	0.406	0.409	0.415
2625576228	●	7/16 - 20 UNF	H8	Modified Bottom (2.5P)	5.906	0.713	1.713	0.323	0.242	0.406	0.409	0.415
2625512128	●	1/2 - 13 UNC	H8	Modified Bottom (2.5P)	5.906	0.768	1.934	0.367	0.275	0.438	0.457	0.465
2625512328	●	1/2 - 13 UNC	H8	Modified Bottom (2.5P)	7.087	0.768	1.934	0.367	0.275	0.438	0.457	0.465
2625512228	○	1/2 - 20 UNF	H8	Modified Bottom (2.5P)	5.906	0.768	1.934	0.367	0.275	0.438	0.472	0.477
2625512028	○	1/2 - 20 UNF	H8	Modified Bottom (2.5P)	7.087	0.768	1.934	0.367	0.275	0.438	0.472	0.477
2625591127	○	9/16 - 12 UNC	H7	Modified Bottom (2.5P)	5.906	0.835	1.973	0.429	0.322	0.500	0.515	0.525
2625591227	○	9/16 - 12 UNC	H7	Modified Bottom (2.5P)	7.087	0.835	1.973	0.429	0.322	0.500	0.515	0.525
2625591827	○	9/16 - 18 UNF	H7	Modified Bottom (2.5P)	5.906	0.835	1.973	0.429	0.322	0.500	0.531	0.538
2625596827	○	9/16 - 18 UNF	H7	Modified Bottom (2.5P)	7.087	0.835	1.973	0.429	0.322	0.500	0.531	0.538
2625558127	●	5/8 - 11 UNC	H7	Modified Bottom (2.5P)	5.906	0.910	2.126	0.480	0.360	0.563	0.574	0.584
2625558257	●	5/8 - 11 UNC	H7	Modified Bottom (2.5P)	7.087	0.910	2.126	0.480	0.360	0.563	0.574	0.584
2625558827	●	5/8 - 18 UNF	H7	Modified Bottom (2.5P)	5.906	0.910	2.126	0.480	0.360	0.563	0.594	0.600
2625551827	●	5/8 - 18 UNF	H7	Modified Bottom (2.5P)	7.087	0.910	2.126	0.480	0.360	0.563	0.594	0.600
2625534127	●	3/4 - 10 UNC	H7	Modified Bottom (2.5P)	7.087	1.000	2.434	0.590	0.442	0.688	0.693	0.704
2625534027	●	3/4 - 10 UNC	H7	Modified Bottom (2.5P)	8.662	1.000	2.434	0.590	0.442	0.688	0.693	0.704
2625534627	●	3/4 - 16 UNF	H7	Modified Bottom (2.5P)	7.087	1.000	2.434	0.590	0.442	0.688	0.714	0.722
2625531627	●	3/4 - 16 UNF	H7	Modified Bottom (2.5P)	8.662	1.000	2.434	0.590	0.442	0.688	0.714	0.722
2625579828	○	7/8 - 9 UNC	H8	Modified Bottom (2.5P)	7.087	1.111	2.654	0.697	0.523	0.750	0.812	0.824
2625575258	●	7/8 - 9 UNC	H8	Modified Bottom (2.5P)	8.662	1.111	2.654	0.697	0.523	0.750	0.812	0.824
2625578128	○	7/8 - 14 UNF	H8	Modified Bottom (2.5P)	7.087	1.111	2.654	0.697	0.523	0.750	0.835	0.843
2625578428	○	7/8 - 14 UNF	H8	Modified Bottom (2.5P)	8.662	1.111	2.654	0.697	0.523	0.750	0.835	0.843

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details



List 26255 (Continued)

A BRAND A-LT-XPF



EDP Number		Thread Size	Thread Limit	Chamfer Type	Overall Length	Thread Length	Neck Length	Shank Diameter	Square Width	Square Length	Tap Drill Size	
					L (Inch)	Lc (Inch)	L1 (Inch)	d (Inch)	k (Inch)	lk (Inch)	Min (Inch)	Max (Inch)
2625518208	○	1 - 8 UNC	H8	Modified Bottom (2.5P)	7.087	1.252	3.012	0.800	0.600	0.813	0.929	0.942
2625518258	●	1 - 8 UNC	H8	Modified Bottom (2.5P)	8.662	1.252	3.012	0.800	0.600	0.813	0.929	0.942
2625511428	○	1 - 12 UNF	H8	Modified Bottom (2.5P)	7.087	1.252	3.012	0.800	0.600	0.813	0.953	0.962
2625514208	○	1 - 12 UNF	H8	Modified Bottom (2.5P)	8.662	1.252	3.012	0.800	0.600	0.813	0.953	0.962

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details



	P					M			K	N		S	H				
	Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel			
	Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium				
	Low	Medium	High														
	1010 1018	1035 1045	1065	4140 4340		300	400	17-4 PH		6061 7075	Casting	Inconel	6Al4V (30 HRC)	~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC
	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙		⊙	⊙	○	○	⊙	○		
2.5P, ≤ 1/2	30-165 SFM	30-165 SFM	30-130 SFM	30-115 SFM	15-100 SFM	15-50 SFM	15-50 SFM	10-30 SFM		65-165 SFM	65-165 SFM	8-12 SFM	8-15 SFM	15-100 SFM	8-25 SFM		
2.5P, ≥ 9/16	15-85 SFM	15-85 SFM	15-65 SFM	15-50 SFM	15-50 SFM	15-35 SFM	15-35 SFM	10-25 SFM		30-100 SFM	30-100 SFM	8-12 SFM	8-15 SFM	15-50 SFM	8-12 SFM		
1.5P	15-85 SFM	15-85 SFM	15-65 SFM	15-50 SFM	15-50 SFM	15-35 SFM	15-35 SFM	10-25 SFM		30-85 SFM	30-85 SFM	8-12 SFM	8-15 SFM	15-50 SFM	8-12 SFM		

1. Speeds given are assuming the use of water-soluble coolant.

2. For stainless steel, please use non-water-soluble coolant or highly lubricated water-soluble coolant.

○ Good ○ Best

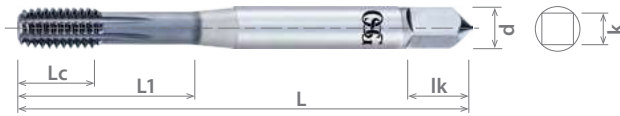


A Brand A-LT-XPF

Highly Efficient Multi-Purpose Forming Tap

List 26355

A BRAND A-LT-XPF



EDP Number		Thread Size	Thread Limit	Chamfer Type	Overall Length	Thread Length	Neck Length	Shank Diameter	Square Width	Square Length	Tap Drill Size	
					L (mm)	Lc (mm)	L1 (mm)	d (mm)	k (mm)	lk (mm)	Min (mm)	Max (mm)
2635530325	○	M3 x 0.35	D5	Modified Bottom (2.5P)	80.00	6.00	18.00	3.58	2.79	4.76	2.80	2.85
2635533525	○	M3 x 0.35	D5	Modified Bottom (2.5P)	120.00	6.00	18.00	3.58	2.79	4.76	2.80	2.85
2635530525	●	M3 x 0.5	D5	Modified Bottom (2.5P)	80.00	6.00	18.00	3.58	2.79	4.76	2.72	2.79
2635535025	●	M3 x 0.5	D5	Modified Bottom (2.5P)	120.00	6.00	18.00	3.58	2.79	4.76	2.72	2.79
2635535226	○	M3.5 x 0.6	D6	Modified Bottom (2.5P)	80.00	7.20	20.00	3.58	2.79	4.76	3.16	3.24
2635535626	○	M3.5 x 0.6	D6	Modified Bottom (2.5P)	120.00	7.20	20.00	3.58	2.79	4.76	3.16	3.24
2635540526	○	M4 x 0.5	D6	Modified Bottom (2.5P)	80.00	8.40	21.00	4.27	3.33	6.35	3.72	3.79
2635545256	○	M4 x 0.5	D6	Modified Bottom (2.5P)	120.00	8.40	21.00	4.27	3.33	6.35	3.72	3.79
2635540726	●	M4 x 0.7	D6	Modified Bottom (2.5P)	80.00	8.40	21.00	4.27	3.33	6.35	3.60	3.70
2635547256	●	M4 x 0.7	D6	Modified Bottom (2.5P)	120.00	8.40	21.00	4.27	3.33	6.35	3.60	3.70
2635545726	○	M4.5 x 0.75	D6	Modified Bottom (2.5P)	90.00	9.00	25.00	4.93	3.86	6.35	4.08	4.17
2635545526	○	M4.5 x 0.75	D6	Modified Bottom (2.5P)	120.00	9.00	25.00	4.93	3.86	6.35	4.08	4.17
2635550525	○	M5 x 0.5	D5	Modified Bottom (2.5P)	100.00	9.60	25.00	4.93	3.86	6.35	4.72	4.79
2635550255	○	M5 x 0.5	D5	Modified Bottom (2.5P)	150.00	9.60	25.00	4.93	3.86	6.35	4.72	4.79
2635550827	●	M5 x 0.8	D7	Modified Bottom (2.5P)	100.00	9.60	25.00	4.93	3.86	6.35	4.55	4.65
2635550257	●	M5 x 0.8	D7	Modified Bottom (2.5P)	150.00	9.60	25.00	4.93	3.86	6.35	4.55	4.65
2635560727	○	M6 x 0.75	D7	Modified Bottom (2.5P)	100.00	10.00	30.00	6.48	4.85	7.94	5.57	5.67
2635567527	○	M6 x 0.75	D7	Modified Bottom (2.5P)	150.00	10.00	30.00	6.48	4.85	7.94	5.57	5.67
2635561028	●	M6 x 1	D8	Modified Bottom (2.5P)	100.00	10.00	30.00	6.48	4.85	7.94	5.43	5.56
2635561258	●	M6 x 1	D8	Modified Bottom (2.5P)	150.00	10.00	30.00	6.48	4.85	7.94	5.43	5.56
2635571258	○	M7 x 1	D8	Modified Bottom (2.5P)	100.00	12.00	30.00	8.08	6.05	9.53	6.43	6.56
2635571028	○	M7 x 1	D8	Modified Bottom (2.5P)	150.00	12.00	30.00	8.08	6.05	9.53	6.43	6.56
2635580727	●	M8 x 0.75	D7	Modified Bottom (2.5P)	110.00	12.00	30.00	8.08	6.05	9.53	7.57	7.67
2635587527	○	M8 x 0.75	D7	Modified Bottom (2.5P)	150.00	12.00	30.00	8.08	6.05	9.53	7.57	7.65
2635581258	○	M8 x 1	D8	Modified Bottom (2.5P)	110.00	12.00	35.00	8.08	6.05	9.53	7.43	7.56
2635581028	●	M8 x 1	D8	Modified Bottom (2.5P)	150.00	12.00	35.00	8.08	6.05	9.53	7.43	7.56
2635581229	●	M8 x 1.25	D9	Modified Bottom (2.5P)	110.00	12.00	35.00	8.08	6.05	9.53	7.29	7.43
2635582529	●	M8 x 1.25	D9	Modified Bottom (2.5P)	150.00	12.00	35.00	8.08	6.05	9.53	7.29	7.43
2635510128	●	M10 x 1	D8	Modified Bottom (2.5P)	120.00	15.00	35.00	9.68	7.26	11.11	9.43	9.56
2635510258	○	M10 x 1	D8	Modified Bottom (2.5P)	150.00	15.00	35.00	9.68	7.26	11.11	9.43	9.56
2635510129	○	M10 x 1.25	D9	Modified Bottom (2.5P)	120.00	15.00	39.00	9.68	7.26	11.11	9.29	9.43
2635510229	○	M10 x 1.25	D9	Modified Bottom (2.5P)	150.00	15.00	39.00	9.68	7.26	11.11	9.29	9.43
2635510120	●	M10 x 1.5	D10	Modified Bottom (2.5P)	120.00	15.00	39.00	9.68	7.26	11.11	9.15	9.31
2635510520	●	M10 x 1.5	D10	Modified Bottom (2.5P)	150.00	15.00	39.00	9.68	7.26	11.11	9.15	9.31
2635512120	○	M12 x 1	D10	Modified Bottom (2.5P)	150.00	17.00	49.10	9.32	6.99	11.11	11.43	11.56
2635512210	○	M12 x 1	D10	Modified Bottom (2.5P)	180.00	17.00	49.10	9.32	6.99	11.11	11.43	11.56
2635512520	●	M12 x 1.25	D10	Modified Bottom (2.5P)	150.00	17.00	49.10	9.32	6.99	11.11	11.29	11.43
2635512250	○	M12 x 1.25	D10	Modified Bottom (2.5P)	180.00	17.00	49.10	9.32	6.99	11.11	11.29	11.43
2635512121	○	M12 x 1.5	D11	Modified Bottom (2.5P)	150.00	17.00	49.10	9.32	6.99	11.11	11.15	11.31
2635512251	○	M12 x 1.5	D11	Modified Bottom (2.5P)	180.00	17.00	49.10	9.32	6.99	11.11	11.15	11.31
2635512721	●	M12 x 1.75	D11	Modified Bottom (2.5P)	150.00	17.00	49.10	9.32	6.99	11.11	11.01	11.18
2635512751	●	M12 x 1.75	D11	Modified Bottom (2.5P)	180.00	17.00	49.10	9.32	6.99	11.11	11.01	11.18
2635514121	●	M14 x 1.5	D11	Modified Bottom (2.5P)	150.00	20.00	50.10	10.90	8.18	12.70	13.15	13.31
2635514521	○	M14 x 1.5	D11	Modified Bottom (2.5P)	180.00	20.00	50.10	10.90	8.18	12.70	13.15	13.31
2635514222	●	M14 x 2	D12	Modified Bottom (2.5P)	150.00	20.00	50.10	10.90	8.18	12.70	12.87	13.06
2635514252	●	M14 x 2	D12	Modified Bottom (2.5P)	180.00	20.00	50.10	10.90	8.18	12.70	12.87	13.06
2635516121	●	M16 x 1.5	D11	Modified Bottom (2.5P)	150.00	20.00	54.00	12.19	9.14	14.29	15.15	15.31
2635516521	○	M16 x 1.5	D11	Modified Bottom (2.5P)	180.00	20.00	54.00	12.19	9.14	14.29	15.15	15.31
2635516222	●	M16 x 2	D12	Modified Bottom (2.5P)	150.00	20.00	54.00	12.19	9.14	14.29	14.87	15.06
2635516252	●	M16 x 2	D12	Modified Bottom (2.5P)	180.00	20.00	54.00	12.19	9.14	14.29	14.87	15.06
2635518121	○	M18 x 1.5	D11	Modified Bottom (2.5P)	150.00	25.00	55.00	13.77	10.31	15.88	17.15	17.31
2635518521	○	M18 x 1.5	D11	Modified Bottom (2.5P)	180.00	25.00	55.00	13.77	10.31	15.88	17.15	17.31
2635518252	○	M18 x 2.5	D12	Modified Bottom (2.5P)	150.00	25.00	55.00	13.77	10.31	15.88	16.59	16.82
2635518552	○	M18 x 2.5	D12	Modified Bottom (2.5P)	180.00	25.00	55.00	13.77	10.31	15.88	16.59	16.82
2635520121	○	M20 x 1.5	D11	Modified Bottom (2.5P)	180.00	25.00	61.80	16.56	12.42	17.46	19.15	19.31

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details



List 26355 (Continued)

A BRAND A-LT-XPF



EDP Number		Thread Size	Thread Limit	Chamfer Type	Overall Length	Thread Length	Neck Length	Shank Diameter	Square Width	Square Length	Tap Drill Size	
					L (mm)	Lc (mm)	L1 (mm)	d (mm)	k (mm)	lk (mm)	Min (mm)	Max (mm)
2635520521	○	M20 x 1.5	D11	Modified Bottom (2.5P)	220.00	25.00	61.80	16.56	12.42	17.46	19.15	19.31
2635520252	○	M20 x 2.5	D12	Modified Bottom (2.5P)	180.00	25.00	61.80	16.56	12.42	17.46	18.58	18.82
2635520222	●	M20 x 2.5	D12	Modified Bottom (2.5P)	220.00	25.00	61.80	16.56	12.42	17.46	18.58	18.82

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details

ATP

	P					M			K	N		S		H			
	Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel			
	Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium				
	Low	Medium	High								6061 7075	Casting	Inconel	6Al4V (30 HRC)	~35 HRC	35-45 HRC	45-50 HRC
	1010 1018	1035 1045	1065	4140 4340		300	400	17-4 PH			6061 7075	Casting	Inconel	6Al4V (30 HRC)	~35 HRC	35-45 HRC	45-50 HRC
	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙		⊙	⊙	○	○	⊙	○		
2.5P, ≤ M12	30-165 SFM	30-165 SFM	30-130 SFM	30-115 SFM	15-100 SFM	15-50 SFM	15-50 SFM	10-30 SFM		65-165 SFM	65-165 SFM	8-12 SFM	8-15 SFM	15-100 SFM	8-25 SFM		
2.5P, ≥ M14	15-85 SFM	15-85 SFM	15-65 SFM	15-50 SFM	15-50 SFM	15-35 SFM	15-35 SFM	10-25 SFM		30-100 SFM	30-100 SFM	8-12 SFM	8-15 SFM	15-50 SFM	8-12 SFM		
1.5P	15-85 SFM	15-85 SFM	15-65 SFM	15-50 SFM	15-50 SFM	15-35 SFM	15-35 SFM	10-25 SFM		30-85 SFM	30-85 SFM	8-12 SFM	8-15 SFM	15-50 SFM	8-12 SFM		

1. Speeds given are assuming the use of water-soluble coolant.

2. For stainless steel, please use non-water-soluble coolant or highly lubricated water-soluble coolant.

○ Good ○ Best

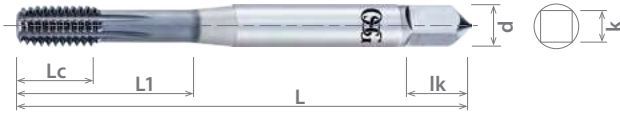


A Brand A-XPF-STI

Highly Efficient Multi-Purpose Forming Tap

List 26260

A BRAND A-XPF-STI



EDP Number		Thread Size	Thread Limit	Chamfer Type	Overall Length	Thread Length	Neck Length	Shank Diameter	Square Width	Square Length	Tap Drill Size	
					L (Inch)	Lc (Inch)	L1 (Inch)	d (Inch)	k (Inch)	lk (Inch)	Min (Inch)	Max (Inch)
2626000108	●	No. 2 - 56 UNC STI	H1	Modified Bottom (2.5P)	2.205	0.252	0.709	0.141	0.110	0.188	0.099	0.103
2626000208	●	No. 2 - 56 UNC STI	H2	Modified Bottom (2.5P)	2.205	0.252	0.709	0.141	0.110	0.188	0.099	0.103
2626000308	●	No. 4 - 40 UNC STI	H2	Modified Bottom (2.5P)	2.481	0.351	0.827	0.141	0.110	0.188	0.130	0.135
2626000408	●	No. 4 - 40 UNC STI	H3	Modified Bottom (2.5P)	2.481	0.351	0.827	0.141	0.110	0.188	0.130	0.135
2626000508	○	No. 4 - 48 UNF STI	H2	Modified Bottom (2.5P)	2.205	0.351	0.788	0.141	0.110	0.188	0.127	0.131
2626000608	○	No. 4 - 48 UNF STI	H3	Modified Bottom (2.5P)	2.205	0.351	0.788	0.141	0.110	0.188	0.127	0.131
2626000708	●	No. 6 - 32 UNC STI	H2	Modified Bottom (2.5P)	2.756	0.438	0.985	0.194	0.152	0.250	0.161	0.166
2626000808	●	No. 6 - 32 UNC STI	H3	Modified Bottom (2.5P)	2.756	0.438	0.985	0.194	0.152	0.250	0.161	0.166
2626000908	○	No. 6 - 40 UNF STI	H2	Modified Bottom (2.5P)	2.756	0.438	0.985	0.168	0.131	0.250	0.156	0.161
2626001008	○	No. 6 - 40 UNF STI	H3	Modified Bottom (2.5P)	2.756	0.438	0.985	0.168	0.131	0.250	0.156	0.161
2626001108	●	No. 8 - 32 UNC STI	H2	Modified Bottom (2.5P)	3.150	0.438	1.182	0.220	0.165	0.281	0.187	0.192
2626001208	●	No. 8 - 32 UNC STI	H3	Modified Bottom (2.5P)	3.150	0.438	1.182	0.220	0.165	0.281	0.187	0.192
2626001308	○	No. 8 - 36 UNF STI	H2	Modified Bottom (2.5P)	3.150	0.438	1.182	0.220	0.165	0.281	0.184	0.189
2626001408	○	No. 8 - 36 UNF STI	H3	Modified Bottom (2.5P)	3.150	0.438	1.182	0.220	0.165	0.281	0.184	0.189
2626001508	●	No. 10 - 24 UNC STI	H3	Modified Bottom (2.5P)	3.150	0.583	1.182	0.255	0.191	0.313	0.221	0.226
2626001608	●	No. 10 - 24 UNC STI	H4	Modified Bottom (2.5P)	3.150	0.583	1.182	0.255	0.191	0.313	0.221	0.226
2626001708	●	No. 10 - 32 UNF STI	H3	Modified Bottom (2.5P)	3.150	0.583	1.182	0.255	0.191	0.313	0.213	0.217
2626001808	●	No. 10 - 32 UNF STI	H4	Modified Bottom (2.5P)	3.150	0.583	1.182	0.255	0.191	0.313	0.213	0.217
2626001908	●	1/4 - 20 UNC STI	H3	Modified Bottom (2.5P)	3.544	0.500	1.378	0.318	0.238	0.375	0.287	0.292
2626002008	●	1/4 - 20 UNC STI	H4	Modified Bottom (2.5P)	3.544	0.500	1.378	0.318	0.238	0.375	0.287	0.292
2626002108	●	1/4 - 28 UNF STI	H3	Modified Bottom (2.5P)	3.544	0.500	1.378	0.318	0.238	0.375	0.276	0.281
2626002208	●	1/4 - 28 UNF STI	H4	Modified Bottom (2.5P)	3.544	0.500	1.378	0.318	0.238	0.375	0.276	0.281
2626002308	●	5/16 - 18 UNC STI	H4	Modified Bottom (2.5P)	3.938	0.556	1.536	0.381	0.286	0.438	0.353	0.360
2626002408	●	5/16 - 18 UNC STI	H5	Modified Bottom (2.5P)	3.938	0.556	1.536	0.381	0.286	0.438	0.353	0.360
2626002508	●	5/16 - 24 UNF STI	H4	Modified Bottom (2.5P)	3.544	0.556	1.378	0.381	0.286	0.438	0.343	0.348
2626002608	●	5/16 - 24 UNF STI	H5	Modified Bottom (2.5P)	3.544	0.556	1.378	0.381	0.286	0.438	0.343	0.348
2626002708	●	3/8 - 16 UNC STI	H5	Modified Bottom (2.5P)	3.938	0.626	1.934	0.367	0.275	0.438	0.421	0.428
2626002808	●	3/8 - 16 UNC STI	H6	Modified Bottom (2.5P)	3.938	0.626	1.934	0.367	0.275	0.438	0.421	0.428
2626002908	○	3/8 - 24 UNF STI	H5	Modified Bottom (2.5P)	3.544	0.626	1.713	0.323	0.242	0.406	0.406	0.411
2626003008	●	3/8 - 24 UNF STI	H6	Modified Bottom (2.5P)	3.544	0.626	1.729	0.323	0.242	0.406	0.406	0.411
2626003108	○	7/16 - 14 UNC STI	H5	Modified Bottom (2.5P)	4.331	0.713	1.973	0.429	0.322	0.500	0.490	0.498
2626003208	○	7/16 - 14 UNC STI	H7	Modified Bottom (2.5P)	4.331	0.713	1.973	0.429	0.322	0.500	0.490	0.498
2626003308	○	7/16 - 20 UNF STI	H5	Modified Bottom (2.5P)	3.938	0.713	1.934	0.367	0.275	0.438	0.474	0.480
2626003408	○	7/16 - 20 UNF STI	H7	Modified Bottom (2.5P)	3.938	0.713	1.934	0.367	0.275	0.438	0.474	0.480
2626003508	●	1/2 - 13 UNC STI	H5	Modified Bottom (2.5P)	4.331	0.768	2.126	0.480	0.360	0.563	0.556	0.565
2626003608	●	1/2 - 13 UNC STI	H7	Modified Bottom (2.5P)	4.331	0.768	2.126	0.480	0.360	0.563	0.556	0.565
2626003708	○	1/2 - 20 UNF STI	H5	Modified Bottom (2.5P)	3.938	0.768	1.973	0.429	0.322	0.500	0.537	0.542
2626003808	○	1/2 - 20 UNF STI	H7	Modified Bottom (2.5P)	3.938	0.768	1.973	0.429	0.322	0.500	0.537	0.542
2626003908	○	9/16 - 12 UNC STI	H7	Modified Bottom (2.5P)	0.434	0.835	2.166	0.542	0.406	0.625	0.623	0.633
2626004008	○	9/16 - 12 UNC STI	H9	Modified Bottom (2.5P)	0.434	0.835	2.166	0.542	0.406	0.625	0.623	0.633
2626004108	○	9/16 - 18 UNF STI	H7	Modified Bottom (2.5P)	3.938	0.835	2.126	0.480	0.360	0.563	0.603	0.610
2626004208	○	9/16 - 18 UNF STI	H9	Modified Bottom (2.5P)	3.938	0.835	2.126	0.480	0.360	0.563	0.603	0.610
2626004308	○	5/8 - 11 UNC STI	H7	Modified Bottom (2.5P)	4.922	0.910	2.434	0.590	0.442	0.688	0.692	0.702
2626004408	○	5/8 - 11 UNC STI	H9	Modified Bottom (2.5P)	4.922	0.910	2.434	0.590	0.442	0.688	0.692	0.702
2626004508	○	5/8 - 18 UNF STI	H7	Modified Bottom (2.5P)	4.331	0.910	2.166	0.542	0.406	0.625	0.666	0.673
2626004608	○	5/8 - 18 UNF STI	H9	Modified Bottom (2.5P)	4.331	0.910	2.166	0.542	0.406	0.625	0.666	0.673
2626004708	○	3/4 - 10 UNC STI	H7	Modified Bottom (2.5P)	5.512	1.000	2.654	0.697	0.523	0.750	0.823	0.834
2626004808	○	3/4 - 10 UNC STI	H9	Modified Bottom (2.5P)	5.512	1.000	2.654	0.697	0.523	0.750	0.823	0.834
2626004908	○	3/4 - 16 UNF STI	H7	Modified Bottom (2.5P)	4.922	1.000	2.434	0.652	0.489	0.688	0.796	0.803
2626005008	○	3/4 - 16 UNF STI	H9	Modified Bottom (2.5P)	4.922	1.000	2.434	0.652	0.489	0.688	0.796	0.803
2626005108	○	7/8 - 9 UNC STI	H7	Modified Bottom (2.5P)	6.300	1.111	3.012	0.800	0.600	0.813	0.957	0.969
2626005208	○	7/8 - 9 UNC STI	H10	Modified Bottom (2.5P)	6.300	1.111	3.012	0.800	0.600	0.813	0.957	0.969
2626005308	○	7/8 - 14 UNF STI	H7	Modified Bottom (2.5P)	5.512	1.111	3.012	0.800	0.600	0.813	0.927	0.936
2626005408	○	7/8 - 14 UNF STI	H10	Modified Bottom (2.5P)	5.512	1.111	3.012	0.800	0.600	0.813	0.927	0.936
2626005508	○	1 - 8 UNC STI	H8	Modified Bottom (2.5P)	7.087	1.252	3.115	1.021	0.766	1.000	1.092	1.105
2626005608	○	1 - 8 UNC STI	H11	Modified Bottom (2.5P)	7.087	1.252	3.115	1.021	0.766	1.000	1.092	1.105

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details

ATP



List 26260 (Continued)

A BRAND A-XPF-STI



EDP Number		Thread Size	Thread Limit	Chamfer Type	Overall Length	Thread Length	Neck Length	Shank Diameter	Square Width	Square Length	Tap Drill Size	
					L (Inch)	Lc (Inch)	L1 (Inch)	d (Inch)	k (Inch)	lk (Inch)	Min (Inch)	Max (Inch)
2626005708	○	1 - 12 UNF STI	H8	Modified Bottom (2.5P)	5.512	1.252	3.115	0.896	0.672	0.875	1.061	1.071
2626005808	○	1 - 12 UNF STI	H11	Modified Bottom (2.5P)	5.512	1.252	3.115	0.896	0.672	0.875	1.061	1.041

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details

ATP

	P					M			K	N		S	H				
	Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel			
	Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium				
	Low	Medium	High														
	1010 1018	1035 1045	1065	4140 4340		300	400	17-4 PH		6061 7075	Casting	Inconel	6Al4V (30 HRC)	~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC
	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙		⊙	⊙	○	○	⊙	○		
2.5P, ≤ 1/2	30-165 SFM	30-165 SFM	30-130 SFM	30-115 SFM	15-100 SFM	15-50 SFM	15-50 SFM	10-30 SFM		65-165 SFM	65-165 SFM	8-12 SFM	8-15 SFM	15-100 SFM	8-25 SFM		
2.5P, ≥ 9/16	15-85 SFM	15-85 SFM	15-65 SFM	15-50 SFM	15-50 SFM	15-35 SFM	15-35 SFM	10-25 SFM		30-100 SFM	30-100 SFM	8-12 SFM	8-15 SFM	15-50 SFM	8-12 SFM		
1.5P	15-85 SFM	15-85 SFM	15-65 SFM	15-50 SFM	15-50 SFM	15-35 SFM	15-35 SFM	10-25 SFM		30-85 SFM	30-85 SFM	8-12 SFM	8-15 SFM	15-50 SFM	8-12 SFM		

1. Speeds given are assuming the use of water-soluble coolant.

2. For stainless steel, please use non-water-soluble coolant or highly lubricated water-soluble coolant.

○ Good ○ Best

A Brand A-XPF-STI

Highly Efficient Multi-Purpose Forming Tap

List 26360

A BRAND A-XPF-STI

A



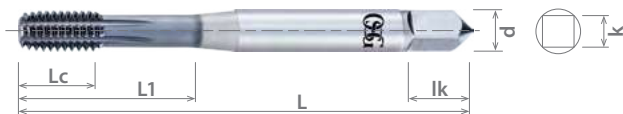
FORMING

STI

VC10

VI

PACKED
1 PIECE



EDP Number		Thread Size	Thread Limit	Chamfer Type	Overall Length	Thread Length	Neck Length	Shank Diameter	Square Width	Square Length	Tap Drill Size	
					L (mm)	Lc (mm)	L1 (mm)	d (mm)	k (mm)	lk (mm)	Min (mm)	Max (mm)
2636000108	●	M2 x 0.4 STI	D3	Modified Bottom (2.5P)	50.00	8.00	9.00	3.58	2.79	4.76	2.29	2.35
2636000208	●	M2.5 x 0.45 STI	D3	Modified Bottom (2.5P)	56.00	6.30	18.00	3.58	2.79	4.76	2.83	2.90
2636000308	●	M3 x 0.5 STI	D3	Modified Bottom (2.5P)	63.00	7.00	21.00	3.58	2.79	4.76	3.37	3.44
2636000408	●	M4 x 0.7 STI	D4	Modified Bottom (2.5P)	70.00	9.80	25.00	4.93	3.86	6.35	4.51	4.61
2636000508	●	M5 x 0.8 STI	D4	Modified Bottom (2.5P)	80.00	11.20	30.00	6.48	4.85	7.94	5.59	5.69
2636000608	●	M6 x 1 STI	D5	Modified Bottom (2.5P)	90.00	10.00	35.00	8.08	6.05	9.53	6.73	6.86
2636000708	●	M8 x 1.25 STI	D6	Modified Bottom (2.5P)	100.00	12.00	39.00	9.68	7.26	11.11	8.92	9.05
2636000808	●	M10 x 1.5 STI	D8	Modified Bottom (2.5P)	100.00	15.00	49.10	9.32	6.99	11.11	11.10	11.26
2636000908	●	M12 x 1.75 STI	D9	Modified Bottom (2.5P)	110.00	17.00	50.10	10.90	8.18	12.70	13.28	13.46
2636001008	●	M14 x 2 STI	D10	Modified Bottom (2.5P)	110.00	20.00	55.00	13.77	10.31	15.88	15.47	15.66
2636001108	●	M16 x 2 STI	D10	Modified Bottom (2.5P)	125.00	20.00	61.80	14.99	11.23	17.46	17.47	17.66
2636001208	●	M18 x 2.5 STI	D10	Modified Bottom (2.5P)	140.00	25.00	67.40	17.70	13.28	19.05	19.83	20.07
2636001308	○	M20 x 2.5 STI	D10	Modified Bottom (2.5P)	160.00	25.00	68.40	19.30	14.48	19.05	21.83	22.07
2636001408	○	M22 x 2.5 STI	D10	Modified Bottom (2.5P)	160.00	25.00	76.50	20.32	15.24	20.64	23.83	24.07
2636001508	●	M24 x 3 STI	D11	Modified Bottom (2.5P)	160.00	30.00	79.10	22.76	17.07	22.23	26.20	26.46

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details

ATP

	P					M			K	N		S		H			
	Steel					Stainless Steel				Non-Ferrous		HRSA		Hardened Steel			
	Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium				
	Low	Medium	High							6061 7075	Casting						
	1010 1018	1035 1045	1065	4140 4340	300	400	17-4 PH	6061 7075		Casting	Inconel	6Al4V (30 HRC)	~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC	
	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙		⊙	○	○	⊙	○			
2.5P, ≤ M12	30-165 SFM	30-165 SFM	30-130 SFM	30-115 SFM	15-100 SFM	15-50 SFM	15-50 SFM	10-30 SFM		65-165 SFM	65-165 SFM	8-12 SFM	8-15 SFM	15-100 SFM	8-25 SFM		
2.5P, ≥ M14	15-85 SFM	15-85 SFM	15-65 SFM	15-50 SFM	15-50 SFM	15-35 SFM	15-35 SFM	10-25 SFM		30-100 SFM	30-100 SFM	8-12 SFM	8-15 SFM	15-50 SFM	8-12 SFM		
1.5P	15-85 SFM	15-85 SFM	15-65 SFM	15-50 SFM	15-50 SFM	15-35 SFM	15-35 SFM	10-25 SFM		30-85 SFM	30-85 SFM	8-12 SFM	8-15 SFM	15-50 SFM	8-12 SFM		

1. Speeds given are assuming the use of water-soluble coolant.

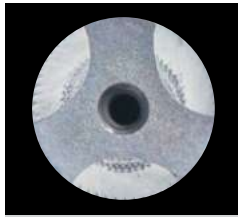
2. For stainless steel, please use non-water-soluble coolant or highly lubricated water-soluble coolant.

○ Good ○ Best

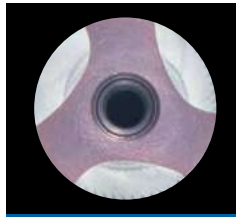


Larger Coolant Hole

1.3 Times More Coolant Flow



Conventional

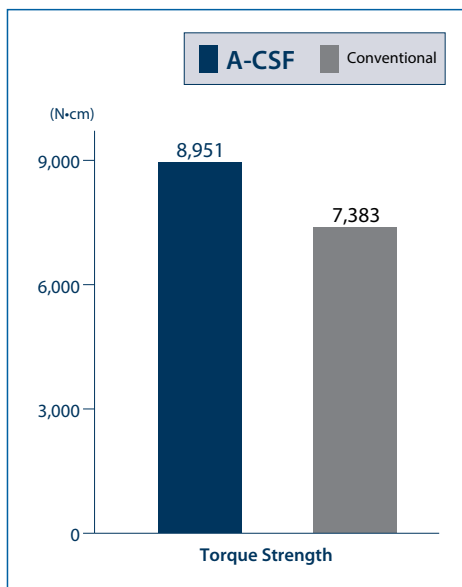


A-CSF

Ideal for Cast Iron

Rigid Design Prevents Tool Breakage

Tool	A-CSF
Size	M10 x 1.5
Drill Hole Size	Ø 8.5 x 20mm (Blind)
Work Material	Pearlitic Cast Iron
Tapping Depth	15mm (1.5xD)
Cutting Speed	40 SFM (640 RPM)
Coolant	Water-Soluble (Internal)
Machine	Vertical Machining Center (Synchronized)



*Cutting Torque 650N-cm

Larger Oil Hole Design
for excellent coolant flow

Bright
for greater performance
in non-ferrous materials.

Ultra-Fine Grain Carbide
for high wear resistance
and toughness



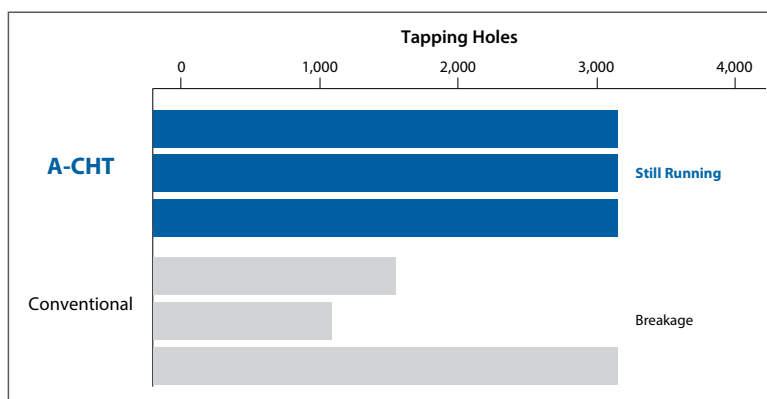
A Brand A-CSF & A-CHT

Cutting Data

Stable and Consistent Performance

Stable Machining in Ductile Cast Iron

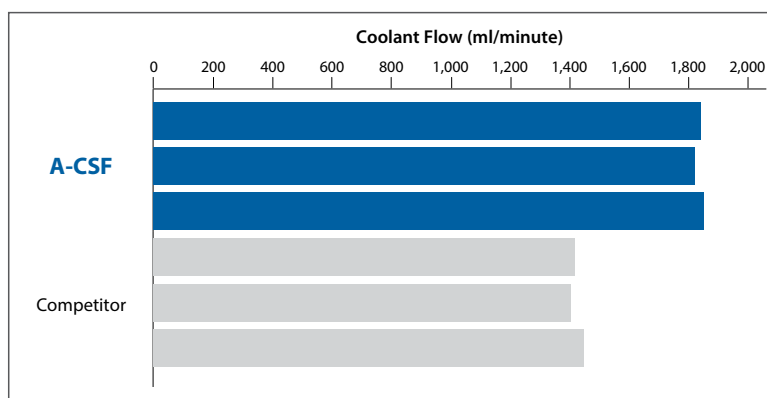
Tool	A-CHT	Conventional
Size	ØM6 x 1	
Drill Hole Size	Ø5mm x 15mm (Blind)	
Work Material	Ductile Cast Iron	
Tapping Depth	12mm (2xD)	
Cutting Speed	100 SFM (1,600 RPM)	
Coolant	Water Soluble Chlorine-Free (10%) (Internal)	
Machine	Horizontal Machining Center (Synchronized)	



Exceptional Coolant Flow

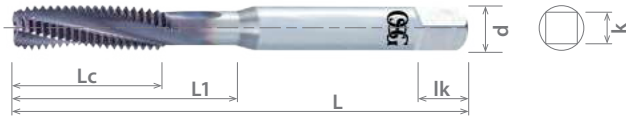
Coolant Flow Amount by Time

Tool	A-CSF	Competitor
Size	ØM6 x 1	
Spindle Speed	61 SFM (1,000 RPM)	
Coolant	Water Soluble Chlorine-Free (10%)	
Coolant Pressure	1 MPa	
Time Run	60 Seconds	



List 16605

A BRAND A-CSF, DIN Overall Length



EDP Number		Thread Size	Thread Limit	Chamfer Type	Overall Length	Thread Length	Neck Length	Shank Dia.	Square Width	Square Length
					L (Inch)	Lc (Inch)	L1 (Inch)	d (Inch)	k (Inch)	lk (Inch)
1660500100	●	1/4 - 20 UNC	H5	Bottom (1.5P)	3.140	0.598	1.181	0.255	0.191	0.313
1660500000	●	1/4 - 20 UNC	H5	Modified Bottom (2.5P)	3.140	0.598	1.181	0.255	0.191	0.313
1660500300	●	1/4 - 28 UNF	H4	Bottom (1.5P)	3.140	0.598	1.181	0.255	0.191	0.313
1660500200	●	1/4 - 28 UNF	H4	Modified Bottom (2.5P)	3.140	0.598	1.181	0.255	0.191	0.313
1660500500	●	5/16 - 18 UNC	H5	Bottom (1.5P)	3.540	0.665	1.377	0.318	0.238	0.375
1660500400	●	5/16 - 18 UNC	H5	Modified Bottom (2.5P)	3.540	0.665	1.377	0.318	0.238	0.375
1660500700	●	3/8 - 16 UNC	H5	Bottom (1.5P)	3.930	0.751	1.377	0.381	0.286	0.438
1660500600	●	3/8 - 16 UNC	H5	Modified Bottom (2.5P)	3.930	0.751	1.377	0.381	0.286	0.438
1660500900	●	7/16 - 14 UNC	H5	Bottom (1.5P)	3.930	0.858	-	0.323	0.242	0.406
1660500800	●	7/16 - 14 UNC	H5	Modified Bottom (2.5P)	3.930	0.858	-	0.323	0.242	0.406
1660501100	●	1/2 - 13 UNC	H5	Bottom (1.5P)	4.330	0.921	-	0.367	0.275	0.438
1660501000	●	1/2 - 13 UNC	H5	Modified Bottom (2.5P)	4.330	0.921	-	0.367	0.275	0.438

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details

Note: Other coatings are available upon request.

Reduce SFM 50% - 70% while using external coolant.

ATP

P					M			K	N		S	H				
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel			
Carbon Steel			Alloy Steel	Aluminum					Nickel Alloy	Titanium						
Low	Medium	High														
1010	1035	1065	4140	Die Steel	300	400	17-4 PH	6061	Casting	Inconel	6Al4V (30 HRC)	~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC	
1018	1045		4340													
								⊙	⊙	⊙						
								15-50 SFM	30-330 SFM	30-330 SFM						

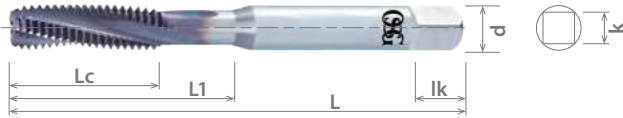
○ Good ○ Best

A Brand A-CSF

Advanced Performance Carbide Coolant-Through Taps for Cast Iron and Aluminum Alloy

List 16600

A BRAND A-CSF, DIN Overall Length



EDP Number		Thread Size	Thread Limit	Chamfer Type	Overall Length	Thread Length	Neck Length	Shank Dia.	Square Width	Square Length
					L (mm)	Lc (mm)	L1 (mm)	d (mm)	k (mm)	lk (mm)
1660000000	●	M5 x 0.8	D4	Bottom (1.5P)	70.00	10.00	25.00	4.93	3.86	6.35
1660000100	●	M5 x 0.8	D4	Modified Bottom (2.5P)	70.00	10.00	25.00	4.93	3.86	6.35
1660000200	●	M6 x 1	D5	Bottom (1.5P)	80.00	12.00	31.00	6.48	4.85	7.94
1660000300	●	M6 x 1	D5	Modified Bottom (2.5P)	80.00	12.00	31.00	6.48	4.85	7.94
1660000400	●	M8 x 1.25	D5	Bottom (1.5P)	90.00	15.00	35.00	8.08	6.05	9.53
1660000500	●	M8 x 1.25	D5	Modified Bottom (2.5P)	90.00	15.00	35.00	8.08	6.05	9.53
1660000800	●	M10 x 1.25	D5	Bottom (1.5P)	100.00	18.00	39.00	9.68	7.26	11.11
1660000900	●	M10 x 1.25	D5	Modified Bottom (2.5P)	100.00	18.00	39.00	9.68	7.26	11.11
1660000600	●	M10 x 1.5	D6	Bottom (1.5P)	100.00	18.00	39.00	9.68	7.26	11.11
1660000700	●	M10 x 1.5	D6	Modified Bottom (2.5P)	100.00	18.00	39.00	9.68	7.26	11.11
1660001000	●	M12 x 1.75	D6	Bottom (1.5P)	110.00	21.00	-	9.32	6.99	11.11
1660001100	●	M12 x 1.75	D6	Modified Bottom (2.5P)	110.00	21.00	-	9.32	6.99	11.11

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details

Note: Other coatings are available upon request. Note: Reduce SFM 50% - 70% while using external coolant.



P					M			K	N		S		H				
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel				
Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium					
Low	Medium	High							6061	Casting							
1010	1035	1065	4140	Die Steel	300	400	17-4 PH	6061	Casting	Inconel	6Al4V	(30 HRC)	~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC	
1018	1045	1065	4340					7075									
								⊙	⊙	⊙							
								15-50 SFM	30-330 SFM	30-330 SFM							

○ Good ◎ Best



List 16615

A BRAND A-CHT, DIN Overall Length



EDP		Thread Size	Thread Limit	Overall Length	Thread Length	Neck Length	Shank Diameter	Square Width	Square Length	Number of Flutes
				L (Inch)	Lc (Inch)	L1 (Inch)	d (Inch)	k (Inch)	lk (Inch)	
1661500200	●	No. 12 - 24 UNC	H3	3.150	0.500	0.945	0.220	0.165	0.281	3
1661500300	●	No. 12 - 28 UNF	H3	3.150	0.500	0.945	0.220	0.165	0.281	3
1661500400	●	1/4 - 20 UNC	H5	3.150	0.598	1.181	0.255	0.191	0.313	3
1661500500	●	1/4 - 28 UNF	H4	3.150	0.598	1.181	0.255	0.191	0.313	3
1661500600	●	5/16 - 18 UNC	H5	3.543	0.665	1.378	0.318	0.238	0.375	4
1661500700	●	5/16 - 24 UNF	H4	3.543	0.665	1.378	0.318	0.238	0.375	4
1661500800	●	3/8 - 16 UNC	H5	3.937	0.752	1.378	0.381	0.286	0.438	4
1661500900	●	3/8 - 24 UNF	H4	3.543	0.752	1.378	0.381	0.286	0.438	4
1661501000	●	7/16 - 14 UNC	H5	3.937	0.858	-	0.323	0.242	0.406	4
1661501100	●	7/16 - 20 UNF	H5	3.937	0.858	-	0.323	0.242	0.406	4
1661501200	●	1/2 - 13 UNC	H5	4.331	0.921	-	0.367	0.275	0.438	4
1661501300	●	1/2 - 20 UNF	H5	3.937	0.921	-	0.367	0.275	0.438	4
1661501400	●	5/8 - 11 UNC	H5	4.331	1.091	-	0.480	0.360	0.563	4
1661501500	●	5/8 - 18 UNF	H5	3.937	1.091	-	0.480	0.360	0.563	4

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details

Note: Other coatings are available upon request. Reduce SFM 50% - 70% while using external coolant.



P					M			K	N		S		H			
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel			
Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium				
Low	Medium	High							6061 7075	Casting	Inconel	6Al4V (30 HRC)				
1010 1018	1035 1045	1065	4140 4340		300	400	17-4 PH	⊙		⊙			~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC
								15-50 SFM		30-330 SFM						

○ Good ○ Best



A Brand A-CHT

Advanced Performance Coolant-Through Taps Designed for Cast Iron

List 16610

A BRAND A-CHT, DIN Overall Length



EDP		Thread Size	Thread Limit	Overall Length	Thread Length	Neck Length	Shank Diameter	Square Width	Square Length	Number of Flutes
				L (mm)	Lc (mm)	L1 (mm)	d (mm)	k (mm)	lk (mm)	
1661000000	●	M5 x 0.8	D4	70.00	10.00	25.00	4.93	3.86	6.35	3
1661000100	●	M6 x 1	D5	80.00	12.00	31.00	6.48	4.85	7.94	3
1661000200	●	M8 x 1.25	D5	90.00	15.00	35.00	8.08	6.05	9.53	4
1661000400	●	M10 x 1.25	D5	100.00	18.00	39.00	9.68	7.26	11.11	4
1661000300	●	M10 x 1.5	D6	100.00	18.00	39.00	9.68	7.26	11.11	4
1661000700	●	M12 x 1.25	D6	100.00	21.00	-	9.32	6.99	11.11	4
1661000600	●	M12 x 1.5	D6	100.00	21.00	-	9.32	6.99	11.11	4
1661000500	●	M12 x 1.75	D6	110.00	21.00	-	9.32	6.99	11.11	4
1661000900	●	M14 x 1.5	D7	100.00	24.00	-	10.90	8.18	12.70	4
1661000800	●	M14 x 2	D7	110.00	24.00	-	10.90	8.18	12.70	4
1661001100	●	M16 x 1.5	D7	100.00	24.00	-	12.19	9.14	14.29	4
1661001000	●	M16 x 2	D7	110.00	24.00	-	12.19	9.14	14.29	4

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details

Note: Other coatings are available upon request. Reduce SFM 50% - 70% while using external coolant.



P					M			K	N		S	H				
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel			
Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium				
Low	Medium	High							6061	Casting	Inconel	6Al4V (30 HRC)				
1010	1035	1065	4140	Die Steel	300	400	17-4 PH	6061 7075				~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC	
1018	1045		4340													
								15-50 SFM		30-330 SFM						

○ Good ◎ Best



Chip Evacuation

Excellent Chip Evacuation in Various Materials

Most tapping troubles are caused by unstable chip evacuation. The A-Tap series resolves such troubles and is applicable to a wide range of work materials and cutting conditions.



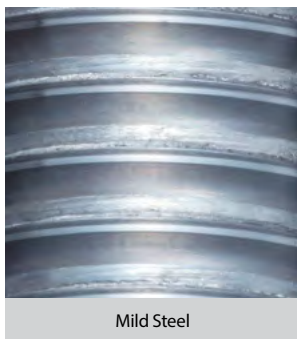
Conventional Tap



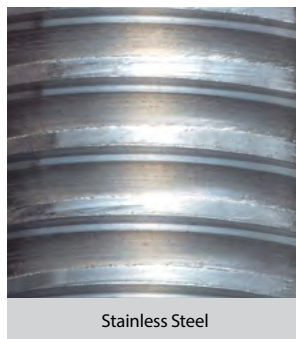
A-SFT

Superior Threads

No Galling of the Work Material



Mild Steel



Stainless Steel

Sharp Cutting Edge

stabilizes chip shape

Variable Lead Flute

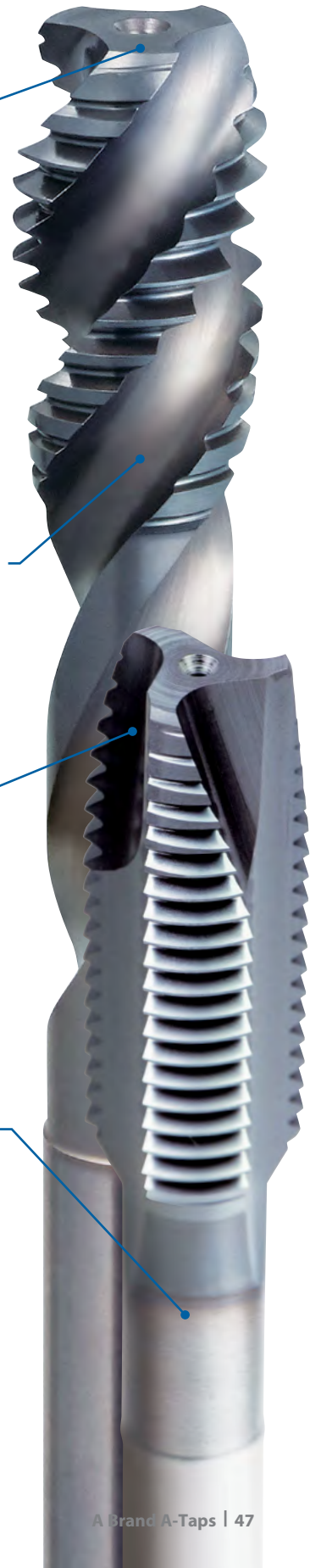
accelerates chip evacuation

V Coating

for high wear resistance

Powder Metallurgy HSS

for high wear resistance and toughness

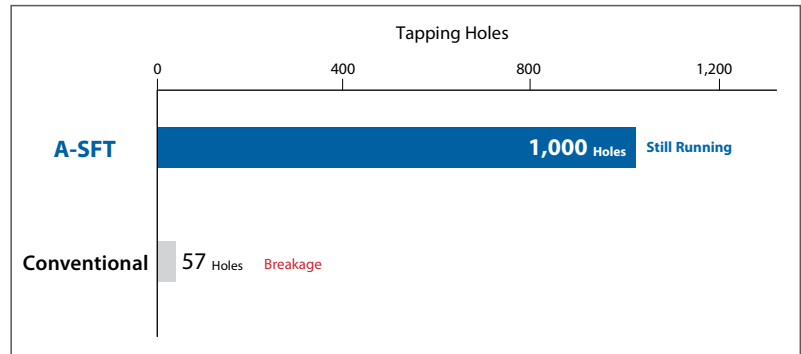


Deep Hole Tapping in Stainless Steel

304 Stainless Steel

The A-SFT is capable of achieving superior results in stainless steel with water-soluble coolant. Capable of continuing after 1,000 holes while the competitor tool broke after tapping just 57 holes.

Tool	A-SFT	Conventional
Drill Size	ØM8 x 1.25 (2.5P Chamfer)	
Work Material	304 Stainless Steel	
Pre-Drilled Hole	Ø6.8mm x 22mm (Blind)	
Tapping Depth	16mm (2D)	
Cutting Speed	33 SFM (398 RPM)	
Coolant	Water-soluble Chlorine-Free (10%)	
Machine	Vertical Machining Center (Synchronized)	



Cutting Edge after Tapping 1,000 Holes

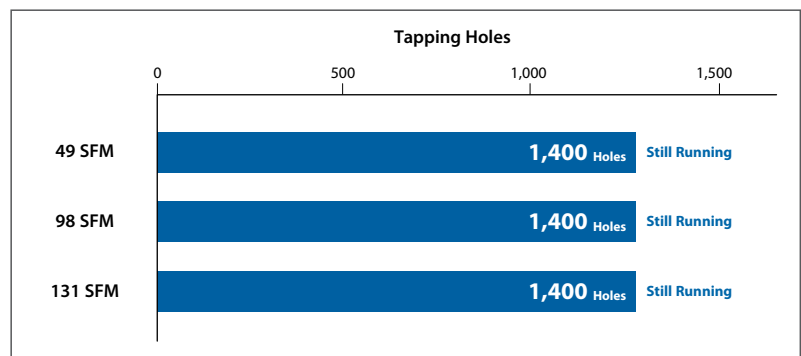


Cutting Speed and Performance Stability

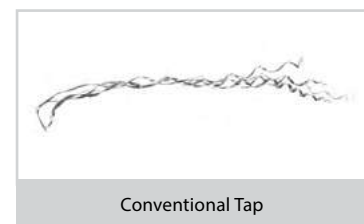
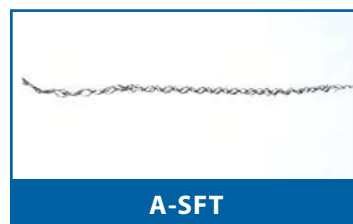
1045 Carbon Steel

The A-SFT maintained stable cutting when tapping at 49, 98 and 131 SFM in carbon steel.

Tool	A-SFT	Conventional
Drill Size	ØM8 x 1.25 (2.5P Chamfer)	
Work Material	304 Stainless Steel	
Pre-Drilled Hole	Ø6.8mm x 22mm (Blind)	
Tapping Depth	16mm (2D)	
Cutting Speed	33 SFM (398 RPM)	
Coolant	Water-soluble Chlorine-Free (10%)	
Machine	Vertical Machining Center (Synchronized)	



Chips Generated at 131 SFM



Large Hole Threading

1045 Carbon Steel and 304 Stainless Steel

The use of water-soluble coolant is possible even in difficult to machine materials such as carbon steels and stainless steels, which could not be achieved with conventional taps.

Tool	A-SFT	Conventional
Drill Size	ØM36 x 4	
Work Material	1045 Carbon Steel 304 Stainless Steel	
Pre-Drilled Hole	Ø32mm x 70mm (Blind)	
Tapping Depth	54mm (1.5D)	
Cutting Speed	23 SFM (62 RPM)	
Coolant	Water-soluble Chlorine-Free (20%)	
Machine	Horizontal Machining Center	

Visual Reference of Internal Threads.
(Results may vary based on machining conditions.)

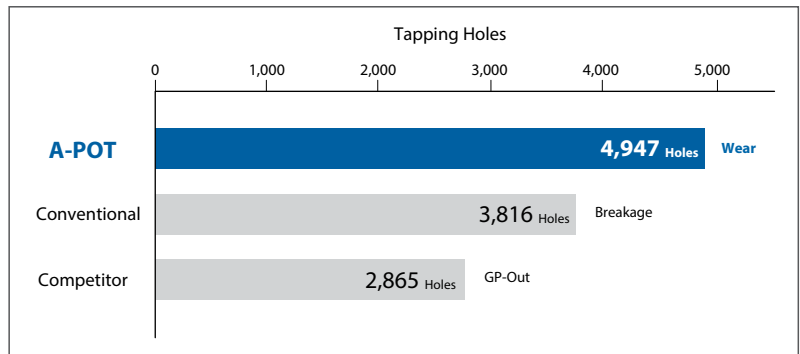


Maximize the Performance of Your Machine

Carbon Steel (1045)

The A-POT greatly outperformed the competitor and conventional taps.

Tool	A-POT	Conventional	Competitor
Drill Size	ØM8 x 1.25		
Work Material	1050 Steel		
Pre-Drilled Hole	Ø6.8mm x 16mm (Through)		
Tapping Depth	16mm (2D)		
Cutting Speed	98 SFM (1,190 RPM)		
Coolant	Water-soluble Chlorine-Free (10%)		
Machine	Horizontal Machining Center (Synchronized)		

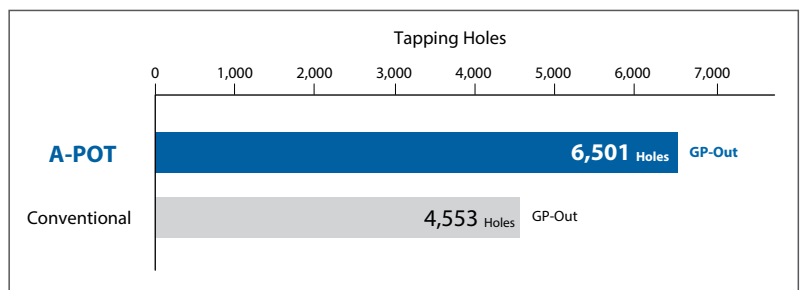


High Speed Machining

Carbon Steel (1045)

The A-POT achieved 1.5 times the durability compared to conventional taps.

Tool	A-POT	Conventional
Drill Size	ØM8 x 1.25	
Work Material	1045 Steel	
Pre-Drilled Hole	Ø6.8mm x 16mm (Through)	
Tapping Depth	16mm (2D)	
Cutting Speed	164 SFM (1,990 RPM)	
Coolant	Water-soluble Chlorine-Free (10%)	
Machine	Vertical Machining Center (Synchronized)	



A Brand A-SFT

Advanced Performance Taps for a Variety of Materials

List 16505

A BRAND A-SFT, DIN Overall Length



EDP Number		Thread Size	Thread Limit	Chamfer Type	Overall Length	Thread Length	Neck Length	Shank Dia.	Square Width	Square Length	Number of Flutes
					L (Inch)	Lc (Inch)	L1 (Inch)	d (Inch)	k (Inch)	lk (Inch)	
1650508908	●	No. 4 - 40 UNC	H2	Bottom (1.5P)	2.205	0.196	0.740	0.141	0.110	0.188	2
1650500108	●	No. 4 - 40 UNC	H2	Modified Bottom (2.5P)	2.205	0.196	0.740	0.141	0.110	0.188	2
1650509008	●	No. 4 - 48 UNF	H2	Bottom (1.5P)	2.205	0.196	0.740	0.141	0.110	0.188	2
1650500208	●	No. 4 - 48 UNF	H2	Modified Bottom (2.5P)	2.205	0.196	0.740	0.141	0.110	0.188	2
1650509108	●	No. 5 - 40 UNC	H2	Bottom (1.5P)	2.205	0.200	0.780	0.141	0.110	0.188	2
1650500308	●	No. 5 - 40 UNC	H2	Modified Bottom (2.5P)	2.205	0.200	0.780	0.141	0.110	0.188	2
1650509208	●	No. 5 - 44 UNF	H2	Bottom (1.5P)	2.205	0.200	0.780	0.141	0.110	0.188	2
1650500408	●	No. 5 - 44 UNF	H2	Modified Bottom (2.5P)	2.205	0.200	0.780	0.141	0.110	0.188	2
1650509308	●	No. 6 - 32 UNC	H2	Bottom (1.5P)	2.205	0.248	0.783	0.141	0.110	0.188	3
1650500608	●	No. 6 - 32 UNC	H2	Modified Bottom (2.5P)	2.205	0.248	0.783	0.141	0.110	0.188	2
1650513108	●	No. 6 - 32 UNC	H2	Modified Bottom (2.5P)	2.205	0.248	0.783	0.141	0.110	0.188	3
1650513208	●	No. 6 - 32 UNC	H3	Bottom (1.5P)	2.205	0.248	0.783	0.141	0.110	0.188	2
1650509408	●	No. 6 - 32 UNC	H3	Bottom (1.5P)	2.205	0.248	0.783	0.141	0.110	0.188	3
1650500508	●	No. 6 - 32 UNC	H3	Modified Bottom (2.5P)	2.205	0.248	0.783	0.141	0.110	0.188	2
1650509508	●	No. 6 - 40 UNF	H2	Bottom (1.5P)	2.205	0.248	0.783	0.141	0.110	0.188	3
1650500708	●	No. 6 - 40 UNF	H2	Modified Bottom (2.5P)	2.205	0.248	0.783	0.141	0.110	0.188	2
1650509608	●	No. 8 - 32 UNC	H2	Bottom (1.5P)	2.480	0.251	0.826	0.168	0.131	0.250	3
1650500908	●	No. 8 - 32 UNC	H2	Modified Bottom (2.5P)	2.480	0.251	0.826	0.168	0.131	0.250	2
1650509708	●	No. 8 - 32 UNC	H3	Bottom (1.5P)	2.480	0.251	0.826	0.168	0.131	0.250	3
1650500808	●	No. 8 - 32 UNC	H3	Modified Bottom (2.5P)	2.480	0.251	0.826	0.168	0.131	0.250	2
1650509808	●	No. 8 - 36 UNF	H2	Bottom (1.5P)	2.480	0.251	0.826	0.168	0.131	0.250	3
1650501008	●	No. 8 - 36 UNF	H2	Modified Bottom (2.5P)	2.480	0.251	0.826	0.168	0.131	0.250	2
1650509908	●	No. 10 - 24 UNC	H3	Bottom (1.5P)	2.756	0.326	0.976	0.194	0.152	0.250	3
1650501108	●	No. 10 - 24 UNC	H3	Modified Bottom (2.5P)	2.756	0.326	0.976	0.194	0.152	0.250	2
1650510008	●	No. 10 - 32 UNF	H2	Bottom (1.5P)	2.756	0.326	1.590	0.194	0.152	0.250	3
1650501308	●	No. 10 - 32 UNF	H2	Modified Bottom (2.5P)	2.756	0.326	0.976	0.194	0.152	0.250	2
1650510108	●	No. 10 - 32 UNF	H3	Bottom (1.5P)	2.756	0.326	1.590	0.194	0.152	0.250	3
1650501208	●	No. 10 - 32 UNF	H3	Modified Bottom (2.5P)	2.756	0.326	0.976	0.194	0.152	0.250	2
1650510208	●	No. 12 - 24 UNC	H3	Bottom (1.5P)	3.150	0.330	1.177	0.220	0.165	0.281	3
1650501408	●	No. 12 - 24 UNC	H3	Modified Bottom (2.5P)	3.150	0.330	1.177	0.220	0.165	0.281	2
1650510308	●	No. 12 - 28 UNF	H3	Bottom (1.5P)	3.150	0.330	1.177	0.220	0.165	0.281	3
1650501508	●	No. 12 - 28 UNF	H3	Modified Bottom (2.5P)	3.150	0.330	1.177	0.220	0.165	0.281	2
1650510408	●	No. 12 - 32 UNEF	H3	Bottom (1.5P)	3.150	0.330	1.177	0.220	0.165	0.281	3
1650505608	●	No. 12 - 32 UNEF	H3	Modified Bottom (2.5P)	3.150	0.330	1.177	0.220	0.165	0.281	2
1650510608	●	1/4 - 20 UNC	H3	Bottom (1.5P)	3.150	0.397	1.177	0.255	0.191	0.313	3
1650501708	●	1/4 - 20 UNC	H3	Modified Bottom (2.5P)	3.150	0.397	1.177	0.255	0.191	0.313	2
1650510708	●	1/4 - 20 UNC	H5	Bottom (1.5P)	3.150	0.397	1.177	0.255	0.191	0.313	3
1650501608	●	1/4 - 20 UNC	H5	Modified Bottom (2.5P)	3.150	0.397	1.177	0.255	0.191	0.313	2
1650510908	●	1/4 - 28 UNF	H3	Bottom (1.5P)	3.150	0.397	1.177	0.255	0.191	0.313	3
1650501908	●	1/4 - 28 UNF	H3	Modified Bottom (2.5P)	3.150	0.397	1.177	0.255	0.191	0.313	2
1650510808	●	1/4 - 28 UNF	H4	Bottom (1.5P)	3.150	0.397	1.177	0.255	0.191	0.313	3
1650501808	●	1/4 - 28 UNF	H4	Modified Bottom (2.5P)	3.150	0.397	1.177	0.255	0.191	0.313	2
1650510508	●	1/4 - 32 UNEF	H3	Bottom (1.5P)	3.150	0.397	1.177	0.255	0.191	0.313	2
1650511008	●	1/4 - 32 UNEF	H3	Bottom (1.5P)	3.150	0.397	1.177	0.255	0.191	0.313	3
1650505708	●	1/4 - 32 UNEF	H3	Modified Bottom (2.5P)	3.150	0.397	1.177	0.255	0.191	0.313	2
1650511108	●	5/16 - 18 UNC	H3	Bottom (1.5P)	3.543	0.444	1.377	0.318	0.238	0.375	3
1650502108	●	5/16 - 18 UNC	H3	Modified Bottom (2.5P)	3.543	0.444	1.377	0.318	0.238	0.375	3
1650511208	●	5/16 - 18 UNC	H5	Bottom (1.5P)	3.543	0.444	1.377	0.318	0.238	0.375	3
1650502008	●	5/16 - 18 UNC	H5	Modified Bottom (2.5P)	3.543	0.444	1.377	0.318	0.238	0.375	3
1650511308	●	5/16 - 24 UNF	H3	Bottom (1.5P)	3.543	0.444	1.377	0.318	0.238	0.375	3
1650502308	●	5/16 - 24 UNF	H3	Modified Bottom (2.5P)	3.543	0.444	1.377	0.318	0.238	0.375	3
1650511408	●	5/16 - 24 UNF	H4	Bottom (1.5P)	3.543	0.444	1.377	0.318	0.238	0.375	3
1650502208	●	5/16 - 24 UNF	H4	Modified Bottom (2.5P)	3.543	0.444	1.377	0.318	0.238	0.375	3

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details



List 16505 (Continued)

A BRAND A-SFT, DIN Overall Length



EDP Number		Thread Size	Thread Limit	Chamfer Type	Overall Length	Thread Length	Neck Length	Shank Dia.	Square Width	Square Length	Number of Flutes
					L (Inch)	Lc (Inch)	L1 (Inch)	d (Inch)	k (Inch)	lk (Inch)	
1650511508	●	5/16 - 32 UNEF	H3	Bottom (1.5P)	3.150	0.444	1.377	0.318	0.238	0.375	3
1650505808	●	5/16 - 32 UNEF	H3	Modified Bottom (2.5P)	3.150	0.444	1.377	0.318	0.238	0.375	3
1650511608	●	3/8 - 16 UNC	H3	Bottom (1.5P)	3.937	0.500	1.535	0.381	0.286	0.438	3
1650502508	●	3/8 - 16 UNC	H3	Modified Bottom (2.5P)	3.937	0.500	1.535	0.381	0.286	0.438	3
1650511708	●	3/8 - 16 UNC	H5	Bottom (1.5P)	3.937	0.500	1.535	0.381	0.286	0.438	3
1650502408	●	3/8 - 16 UNC	H5	Modified Bottom (2.5P)	3.937	0.500	1.535	0.381	0.286	0.438	3
1650511808	●	3/8 - 24 UNF	H3	Bottom (1.5P)	3.543	0.500	1.377	0.381	0.286	0.438	3
1650502708	●	3/8 - 24 UNF	H3	Modified Bottom (2.5P)	3.543	0.500	1.377	0.381	0.286	0.438	3
1650511908	●	3/8 - 24 UNF	H4	Bottom (1.5P)	3.543	0.500	1.377	0.381	0.286	0.438	3
1650502608	●	3/8 - 24 UNF	H4	Modified Bottom (2.5P)	3.543	0.500	1.377	0.381	0.286	0.438	3
1650505908	●	3/8 - 32 UNEF	H3	Modified Bottom (2.5P)	3.543	0.500	1.377	0.381	0.286	0.438	3
1650512008	●	3/8 - 32 UNEF	H4	Bottom (1.5P)	3.543	0.500	1.377	0.381	0.286	0.438	3
1650512108	●	7/16 - 14 UNC	H3	Bottom (1.5P)	3.937	0.570	1.712	0.323	0.242	0.406	3
1650502908	●	7/16 - 14 UNC	H3	Modified Bottom (2.5P)	3.937	0.570	1.712	0.323	0.242	0.406	3
1650512208	●	7/16 - 14 UNC	H5	Bottom (1.5P)	3.937	0.570	1.712	0.323	0.242	0.406	3
1650502808	●	7/16 - 14 UNC	H5	Modified Bottom (2.5P)	3.937	0.570	1.712	0.323	0.242	0.406	3
1650512308	●	7/16 - 20 UNF	H3	Bottom (1.5P)	3.937	0.570	1.712	0.323	0.242	0.406	3
1650503108	●	7/16 - 20 UNF	H3	Modified Bottom (2.5P)	3.937	0.570	1.712	0.323	0.242	0.406	3
1650512408	●	7/16 - 20 UNF	H5	Bottom (1.5P)	3.937	0.570	1.712	0.323	0.242	0.406	3
1650503008	●	7/16 - 20 UNF	H5	Modified Bottom (2.5P)	3.937	0.570	1.712	0.323	0.242	0.406	3
1650512508	●	7/16 - 28 UNEF	H4	Bottom (1.5P)	3.543	0.570	1.712	0.323	0.242	0.406	3
1650506008	●	7/16 - 28 UNEF	H4	Modified Bottom (2.5P)	3.543	0.570	1.712	0.323	0.242	0.406	3
1650512608	●	1/2 - 13 UNC	H3	Bottom (1.5P)	4.331	0.614	1.933	0.367	0.275	0.438	3
1650503308	●	1/2 - 13 UNC	H3	Modified Bottom (2.5P)	4.331	0.614	1.933	0.367	0.275	0.438	3
1650512708	●	1/2 - 13 UNC	H5	Bottom (1.5P)	4.331	0.614	1.933	0.367	0.275	0.438	3
1650503208	●	1/2 - 13 UNC	H5	Modified Bottom (2.5P)	4.331	0.614	1.933	0.367	0.275	0.438	3
1650512808	●	1/2 - 20 UNF	H3	Bottom (1.5P)	3.937	0.614	1.933	0.367	0.275	0.438	3
1650503508	●	1/2 - 20 UNF	H3	Modified Bottom (2.5P)	3.937	0.614	1.933	0.367	0.275	0.438	3
1650512908	●	1/2 - 20 UNF	H5	Bottom (1.5P)	3.937	0.614	1.933	0.367	0.275	0.438	3
1650503408	●	1/2 - 20 UNF	H5	Modified Bottom (2.5P)	3.937	0.614	1.933	0.367	0.275	0.438	3
1650513008	●	1/2 - 28 UNEF	H4	Bottom (1.5P)	3.937	0.614	1.933	0.367	0.275	0.438	3
1650506108	●	1/2 - 28 UNEF	H4	Modified Bottom (2.5P)	3.937	0.614	1.933	0.367	0.275	0.438	3
1650503708	●	9/16 - 12 UNC	H3	Modified Bottom (2.5P)	4.331	0.665	1.972	0.429	0.322	0.500	3
1650503608	●	9/16 - 12 UNC	H5	Modified Bottom (2.5P)	4.331	0.665	1.972	0.429	0.322	0.500	3
1650503908	●	9/16 - 18 UNF	H3	Modified Bottom (2.5P)	3.937	0.665	1.972	0.429	0.322	0.500	3
1650503808	●	9/16 - 18 UNF	H5	Modified Bottom (2.5P)	3.937	0.665	1.972	0.429	0.322	0.500	3
1650506208	●	9/16 - 24 UNEF	H4	Modified Bottom (2.5P)	3.937	0.665	1.972	0.429	0.322	0.500	3
1650504108	●	5/8 - 11 UNC	H3	Modified Bottom (2.5P)	4.331	0.728	2.125	0.480	0.360	0.563	3
1650504008	●	5/8 - 11 UNC	H5	Modified Bottom (2.5P)	4.331	0.728	2.125	0.480	0.360	0.563	3
1650504308	●	5/8 - 18 UNF	H3	Modified Bottom (2.5P)	3.937	0.728	2.125	0.480	0.360	0.563	3
1650504208	●	5/8 - 18 UNF	H5	Modified Bottom (2.5P)	3.937	0.728	2.125	0.480	0.360	0.563	3
1650506308	●	5/8 - 24 UNEF	H4	Modified Bottom (2.5P)	3.937	0.728	2.125	0.480	0.360	0.563	3
1650506408	●	11/16 - 24 UNEF	H4	Modified Bottom (2.5P)	4.331	0.909	2.165	0.542	0.406	0.625	4
1650504508	●	3/4 - 10 UNC	H3	Modified Bottom (2.5P)	4.921	1.000	2.433	0.590	0.442	0.688	4
1650504408	●	3/4 - 10 UNC	H5	Modified Bottom (2.5P)	4.921	1.000	2.433	0.590	0.442	0.688	4
1650504708	●	3/4 - 16 UNF	H3	Modified Bottom (2.5P)	4.331	1.000	2.433	0.590	0.442	0.688	4
1650504608	●	3/4 - 16 UNF	H5	Modified Bottom (2.5P)	4.331	1.000	2.433	0.590	0.442	0.688	4
1650506508	●	3/4 - 20 UNEF	H5	Modified Bottom (2.5P)	4.331	1.000	2.433	0.590	0.442	0.688	4
1650506608	●	13/16 - 20 UNEF	H5	Modified Bottom (2.5P)	4.921	1.000	2.433	0.652	0.489	0.688	4

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details



CONTINUED ➔

P					M			K	N		S	H				
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel			
Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium				
Low	Medium	High							6061	Casting	Inconel	6Al4V (30 HRC)				
1010 1018	1035 1045	1065	4140 4340	Die Steel	300	400	17-4 PH	Cast Iron	6061 7075	Casting	Inconel	6Al4V (30 HRC)	~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC
◯	◯	◯	◯		◯	◯	◯		◯	◯	◯	◯	◯	◯	◯	◯
80-120 SFM	80-120 SFM	80-120 SFM	35-50 SFM	20-40 SFM	15-35 SFM	15-35 SFM	15-25 SFM	50-80 SFM	70-120 SFM	70-120 SFM			30-55 SFM			

○ Good ○ Best



A Brand A-SFT

Advanced Performance Taps for a Variety of Materials

List 16505 (Continued)

A BRAND A-SFT, DIN Overall Length



EDP Number		Thread Size	Thread Limit	Chamfer Type	Overall Length	Thread Length	Neck Length	Shank Dia.	Square Width	Square Length	Number of Flutes
					L (Inch)	Lc (Inch)	L1 (Inch)	d (Inch)	k (Inch)	lk (Inch)	
1650504908	●	7/8 - 9 UNC	H4	Modified Bottom (2.5P)	5.512	1.110	2.653	0.697	0.523	0.750	4
1650504808	●	7/8 - 9 UNC	H6	Modified Bottom (2.5P)	5.512	1.110	2.653	0.697	0.523	0.750	4
1650505108	●	7/8 - 14 UNF	H4	Modified Bottom (2.5P)	4.921	1.110	2.653	0.697	0.523	0.750	4
1650505008	●	7/8 - 14 UNF	H6	Modified Bottom (2.5P)	4.921	1.110	2.653	0.697	0.523	0.750	4
1650506708	●	7/8 - 20 UNEF	H5	Modified Bottom (2.5P)	4.921	1.110	2.653	0.697	0.523	0.750	4
1650506808	●	15/16 - 20 UNEF	H5	Modified Bottom (2.5P)	5.512	1.110	2.692	0.760	0.570	0.750	4
1650505308	●	1 - 8 UNC	H4	Modified Bottom (2.5P)	6.299	1.251	3.011	0.800	0.600	0.813	4
1650505208	●	1 - 8 UNC	H6	Modified Bottom (2.5P)	6.299	1.251	3.011	0.800	0.600	0.813	4
1650507008	●	1 - 8 UNC	H8	Modified Bottom (2.5P)	6.299	1.251	3.011	0.800	0.600	0.813	4
1650505508	●	1 - 12 UNF	H4	Modified Bottom (2.5P)	6.299	1.251	3.011	0.800	0.600	0.813	4
1650505408	●	1 - 12 UNF	H6	Modified Bottom (2.5P)	5.512	1.251	3.011	0.800	0.600	0.813	4
1650513308	●	1 - 14 UNS	H6	Modified Bottom (2.5P)	5.512	1.251	3.011	0.800	0.600	0.813	4
1650506908	●	1 - 20 UNEF	H5	Modified Bottom (2.5P)	5.512	1.251	3.011	0.800	0.600	0.813	4
1650507108	●	1- 1/8 - 7 UNC	H9	Modified Bottom (2.5P)	7.087	0.944	3.819	0.896	0.672	0.875	4
1650507208	●	1- 1/8 - 8 UN	H9	Modified Bottom (2.5P)	7.087	0.826	3.819	0.896	0.672	0.875	4
1650507308	●	1- 1/8 - 12 UNF	H8	Modified Bottom (2.5P)	5.906	0.826	3.071	0.896	0.672	0.875	4
1650507408	●	1- 1/4 - 7 UNC	H10	Modified Bottom (2.5P)	7.087	0.944	3.937	1.021	0.766	1.000	4
1650507508	●	1- 1/4 - 8 UN	H9	Modified Bottom (2.5P)	7.087	0.826	3.937	1.021	0.766	1.000	4
1650507608	●	1- 1/4 - 12 UNF	H8	Modified Bottom (2.5P)	5.906	0.826	3.071	1.021	0.766	1.000	4
1650507708	●	1- 3/8 - 6 UNC	H10	Modified Bottom (2.5P)	7.874	1.102	4.528	1.108	0.831	1.063	4
1650507808	●	1- 3/8 - 8 UN	H9	Modified Bottom (2.5P)	7.874	0.826	4.528	1.108	0.831	1.063	4
1650507908	●	1- 3/8 - 12 UNF	H8	Modified Bottom (2.5P)	6.693	0.826	3.583	1.108	0.831	1.063	4
1650508008	●	1- 1/2 - 6 UNC	H10	Modified Bottom (2.5P)	7.874	1.102	4.528	1.233	0.925	1.125	4
1650508108	●	1- 1/2 - 8 UN	H9	Modified Bottom (2.5P)	7.874	0.826	4.528	1.233	0.925	1.125	4
1650508208	●	1- 1/2 - 12 UNF	H8	Modified Bottom (2.5P)	6.693	0.826	3.583	1.233	0.925	1.125	4
1650508308	●	1- 5/8 - 8 UN	H10	Modified Bottom (2.5P)	7.874	0.826	4.331	1.305	0.979	1.125	4
1650508408	●	1- 3/4 - 5 UNC	H11	Modified Bottom (2.5P)	8.661	1.299	4.724	1.430	1.072	1.250	4
1650508508	●	1- 3/4 - 8 UN	H10	Modified Bottom (2.5P)	7.874	0.826	3.976	1.430	1.072	1.250	4
1650508608	●	1- 7/8 - 8 UN	H10	Modified Bottom (2.5P)	8.858	2.008	4.921	1.519	1.139	1.250	4
1650508708	●	2 - 4.5 UNC	H12	Modified Bottom (2.5P)	9.843	2.677	5.512	1.644	1.233	1.375	4
1650508808	●	2 - 8 UN	H10	Modified Bottom (2.5P)	8.858	2.008	4.803	1.644	1.233	1.375	4

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details



P					M			K	N		S	H					
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel				
Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium					
Low	Medium	High							1010 1018	1035 1045	1065	4140 4340	300	400	17-4 PH	6061 7075	Casting
○	○	○	○	○	○	○	○	○	○	○	○		○				
80-120 SFM	80-120 SFM	80-120 SFM	35-50 SFM	20-40 SFM	15-35 SFM	15-35 SFM	15-25 SFM	50-80 SFM	70-120 SFM	70-120 SFM			30-55 SFM				

○ Good ○ Best



List 16500

A BRAND A-SFT, DIN Overall Length



EDP Number		Thread Size	Thread Limit	Chamfer Type	Overall Length	Thread Length	Neck Length	Shank Dia.	Square Width	Square Length	Number of Flutes
					L (mm)	Lc (mm)	L1 (mm)	d (mm)	k (mm)	lk (mm)	
1650003008	●	M1.4 x 0.3	D2	Modified Bottom (2.5P)	40.00	6.00	11.50	3.58	2.79	4.76	2
1650003108	●	M1.6 x 0.35	D3	Modified Bottom (2.5P)	40.00	7.00	13.60	3.58	2.79	4.76	2
1650003208	●	M1.7 x 0.35	D3	Modified Bottom (2.5P)	40.00	8.00	13.40	3.58	2.79	4.76	2
1650003308	●	M2 x 0.25	D2	Modified Bottom (2.5P)	45.00	3.30	10.00	3.58	2.79	4.76	2
1650003408	●	M2 x 0.4	D3	Modified Bottom (2.5P)	45.00	3.30	10.00	3.58	2.79	4.76	2
1650003508	●	M2.2 x 0.25	D2	Modified Bottom (2.5P)	45.00	3.30	11.00	3.58	2.79	4.76	2
1650003608	●	M2.2 x 0.45	D3	Modified Bottom (2.5P)	45.00	3.30	11.00	3.58	2.79	4.76	2
1650003708	●	M2.3 x 0.4	D3	Modified Bottom (2.5P)	45.00	3.20	11.90	3.58	2.79	4.76	2
1650003808	●	M2.5 x 0.35	D3	Modified Bottom (2.5P)	50.00	3.70	13.00	3.58	2.79	4.76	2
1650003908	●	M2.5 x 0.45	D3	Modified Bottom (2.5P)	50.00	3.70	13.00	3.58	2.79	4.76	2
1650004008	●	M2.6 x 0.45	D3	Modified Bottom (2.5P)	50.00	3.70	13.00	3.58	2.79	4.76	2
1650009708	●	M3 x 0.35	D2	Bottom (1.5P)	56.00	4.00	18.00	3.58	2.79	4.76	3
1650004108	●	M3 x 0.35	D3	Modified Bottom (2.5P)	56.00	4.00	18.00	3.58	2.79	4.76	3
1650009808	●	M3 x 0.5	D3	Bottom (1.5P)	56.00	4.00	18.00	3.58	2.79	4.76	3
1650000108	●	M3 x 0.5	D3	Modified Bottom (2.5P)	56.00	4.00	18.00	3.58	2.79	4.76	3
1650009908	●	M3.5 x 0.35	D3	Bottom (1.5P)	56.00	4.80	20.00	3.58	2.79	4.76	3
1650004208	●	M3.5 x 0.35	D3	Modified Bottom (2.5P)	56.00	4.80	20.00	3.58	2.79	4.76	3
1650010008	●	M3.5 x 0.6	D3	Bottom (1.5P)	56.00	4.80	20.00	3.58	2.79	4.76	3
1650004308	●	M3.5 x 0.6	D3	Modified Bottom (2.5P)	56.00	4.80	20.00	3.58	2.79	4.76	3
1650010108	●	M4 x 0.5	D3	Bottom (1.5P)	63.00	5.60	20.90	4.27	3.33	6.35	3
1650000208	●	M4 x 0.5	D3	Modified Bottom (2.5P)	63.00	5.60	20.90	4.27	3.33	6.35	3
1650010208	●	M4 x 0.7	D4	Bottom (1.5P)	63.00	5.60	20.90	4.27	3.33	6.35	3
1650000308	●	M4 x 0.7	D4	Modified Bottom (2.5P)	63.00	5.60	20.90	4.27	3.33	6.35	3
1650010308	●	M4.5 x 0.5	D3	Bottom (1.5P)	70.00	6.10	24.90	4.93	3.86	6.35	3
1650004408	●	M4.5 x 0.5	D3	Modified Bottom (2.5P)	70.00	6.10	24.90	4.93	3.86	6.35	3
1650010408	●	M4.5 x 0.75	D4	Bottom (1.5P)	70.00	6.10	24.90	4.93	3.86	6.35	3
1650004508	●	M4.5 x 0.75	D4	Modified Bottom (2.5P)	70.00	6.10	24.90	4.93	3.86	6.35	3
1650010508	●	M5 x 0.5	D3	Bottom (1.5P)	70.00	6.40	25.10	4.93	3.86	6.35	3
1650000408	●	M5 x 0.5	D3	Modified Bottom (2.5P)	70.00	6.40	25.10	4.93	3.86	6.35	3
1650010608	●	M5 x 0.8	D4	Bottom (1.5P)	70.00	6.40	25.10	4.93	3.86	6.35	3
1650000508	●	M5 x 0.8	D4	Modified Bottom (2.5P)	70.00	6.40	25.10	4.93	3.86	6.35	3
1650010708	●	M5.5 x 0.5	D3	Bottom (1.5P)	80.00	7.30	30.10	5.59	4.19	7.14	3
1650004608	●	M5.5 x 0.5	D3	Modified Bottom (2.5P)	80.00	7.30	30.10	5.59	4.19	7.14	3
1650010808	●	M6 x 0.5	D3	Bottom (1.5P)	80.00	8.00	29.90	6.48	4.85	7.94	3
1650000608	●	M6 x 0.5	D3	Modified Bottom (2.5P)	80.00	8.00	29.90	6.48	4.85	7.94	3
1650010908	●	M6 x 0.75	D4	Bottom (1.5P)	80.00	8.00	29.90	6.48	4.85	7.94	3
1650000708	●	M6 x 0.75	D4	Modified Bottom (2.5P)	80.00	8.00	29.90	6.48	4.85	7.94	3
1650011008	●	M6 x 1	D5	Bottom (1.5P)	80.00	8.00	29.90	6.48	4.85	7.94	3
1650000808	●	M6 x 1	D5	Modified Bottom (2.5P)	80.00	8.00	29.90	6.48	4.85	7.94	3
1650011108	●	M7 x 0.75	D4	Bottom (1.5P)	80.00	8.00	30.00	8.08	6.05	9.53	3
1650004708	●	M7 x 0.75	D4	Modified Bottom (2.5P)	80.00	8.00	30.00	8.08	6.05	9.53	3
1650011208	●	M7 x 1	D5	Bottom (1.5P)	80.00	8.00	30.00	8.08	6.05	9.53	3

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details



CONTINUED ➔

P					M			K	N		S	H				
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel			
Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium				
Low	Medium	High							6061 7075	Casting	Inconel	6Al4V (30 HRC)				
1010 1018	1035 1045	1065	4140 4340	Die Steel	300	400	17-4 PH	Cast Iron	6061 7075	Casting	Inconel	6Al4V (30 HRC)	~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC
⊙	⊙	⊙	⊙		⊙	⊙	⊙		⊙	⊙	⊙	⊙	⊙	⊙		
80-120 SFM	80-120 SFM	80-120 SFM	35-50 SFM	20-40 SFM	15-35 SFM	15-35 SFM	15-25 SFM	50-80 SFM	70-120 SFM	70-120 SFM			30-55 SFM			

○ Good ○ Best

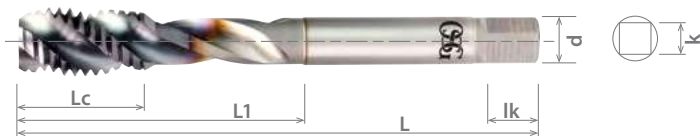


A Brand A-SFT

Advanced Performance Taps for a Variety of Materials

List 16500 (Continued)

A BRAND A-SFT, DIN Overall Length



EDP Number		Thread Size	Thread Limit	Chamfer Type	Overall Length	Thread Length	Neck Length	Shank Dia.	Square Width	Square Length	Number of Flutes
					L (mm)	Lc (mm)	L1 (mm)	d (mm)	k (mm)	lk (mm)	
1650004808	●	M7 x 1	D5	Modified Bottom (2.5P)	80.00	8.00	30.00	8.08	6.05	9.53	3
1650011308	●	M8 x 0.75	D4	Bottom (1.5P)	80.00	8.00	33.00	8.08	6.05	9.53	3
1650004908	●	M8 x 0.75	D4	Modified Bottom (2.5P)	80.00	8.00	33.00	8.08	6.05	9.53	3
1650011408	●	M8 x 1	D5	Bottom (1.5P)	90.00	10.00	35.00	8.08	6.05	9.53	3
1650000908	●	M8 x 1	D5	Modified Bottom (2.5P)	90.00	10.00	35.00	8.08	6.05	9.53	3
1650011508	●	M8 x 1.25	D5	Bottom (1.5P)	90.00	10.00	35.00	8.08	6.05	9.53	3
1650001008	●	M8 x 1.25	D5	Modified Bottom (2.5P)	90.00	10.00	35.00	8.08	6.05	9.53	3
1650011608	●	M9 x 0.75	D4	Bottom (1.5P)	90.00	8.00	35.00	9.68	7.26	11.11	3
1650005008	●	M9 x 0.75	D4	Modified Bottom (2.5P)	90.00	8.00	35.00	9.68	7.26	11.11	3
1650011708	●	M9 x 1	D5	Bottom (1.5P)	90.00	10.00	35.00	9.68	7.26	11.11	3
1650005108	●	M9 x 1	D5	Modified Bottom (2.5P)	90.00	10.00	35.00	9.68	7.26	11.11	3
1650011808	●	M9 x 1.25	D5	Bottom (1.5P)	90.00	10.00	35.00	9.68	7.26	11.11	3
1650005208	●	M9 x 1.25	D5	Modified Bottom (2.5P)	90.00	10.00	35.00	9.68	7.26	11.11	3
1650011908	●	M10 x 0.75	D4	Bottom (1.5P)	90.00	10.00	35.00	9.68	7.26	11.11	3
1650005308	●	M10 x 0.75	D4	Modified Bottom (2.5P)	90.00	10.00	35.00	9.68	7.26	11.11	3
1650012008	●	M10 x 1	D5	Bottom (1.5P)	90.00	10.00	35.00	9.68	7.26	11.11	3
1650001108	●	M10 x 1	D5	Modified Bottom (2.5P)	90.00	10.00	35.00	9.68	7.26	11.11	3
1650012108	●	M10 x 1.25	D5	Bottom (1.5P)	100.00	12.00	39.00	9.68	7.26	11.11	3
1650001208	●	M10 x 1.25	D5	Modified Bottom (2.5P)	100.00	12.00	39.00	9.68	7.26	11.11	3
1650012208	●	M10 x 1.5	D6	Bottom (1.5P)	100.00	12.00	39.00	9.68	7.26	11.11	3
1650001308	●	M10 x 1.5	D6	Modified Bottom (2.5P)	100.00	12.00	39.00	9.68	7.26	11.11	3
1650012308	●	M11 x 0.75	D4	Bottom (1.5P)	90.00	8.00	43.50	8.20	6.15	10.32	3
1650005408	●	M11 x 0.75	D4	Modified Bottom (2.5P)	90.00	8.00	43.50	8.20	6.15	10.32	3
1650012408	●	M11 x 1	D5	Bottom (1.5P)	90.00	12.00	43.50	8.20	6.15	10.32	3
1650005508	●	M11 x 1	D5	Modified Bottom (2.5P)	90.00	12.00	43.50	8.20	6.15	10.32	3
1650012508	●	M11 x 1.25	D5	Bottom (1.5P)	100.00	12.00	43.50	8.20	6.15	10.32	3
1650012608	●	M11 x 1.5	D6	Bottom (1.5P)	100.00	12.00	43.50	8.20	6.15	10.32	3
1650005608	●	M11 x 1.5	D6	Modified Bottom (2.5P)	100.00	12.00	43.50	8.20	6.15	10.32	3
1650012708	●	M12 x 1	D5	Bottom (1.5P)	100.00	12.00	49.10	9.32	6.99	11.11	3
1650001408	●	M12 x 1	D5	Modified Bottom (2.5P)	100.00	12.00	49.10	9.32	6.99	11.11	3
1650012808	●	M12 x 1.25	D6	Bottom (1.5P)	100.00	12.00	49.10	9.32	6.99	11.11	3
1650001508	●	M12 x 1.25	D6	Modified Bottom (2.5P)	100.00	12.00	49.10	9.32	6.99	11.11	3
1650012908	●	M12 x 1.5	D6	Bottom (1.5P)	100.00	14.00	49.10	9.32	6.99	11.11	3
1650001608	●	M12 x 1.5	D6	Modified Bottom (2.5P)	100.00	14.00	49.10	9.32	6.99	11.11	3
1650013008	●	M12 x 1.75	D6	Bottom (1.5P)	110.00	14.00	49.10	9.32	6.99	11.11	3
1650001708	●	M12 x 1.75	D6	Modified Bottom (2.5P)	110.00	14.00	49.10	9.32	6.99	11.11	3
1650005708	●	M14 x 1	D5	Modified Bottom (2.5P)	100.00	12.00	50.10	10.90	8.18	12.70	3
1650005808	●	M14 x 1.25	D6	Modified Bottom (2.5P)	100.00	12.00	50.10	10.90	8.18	12.70	3
1650001808	●	M14 x 1.5	D6	Modified Bottom (2.5P)	100.00	16.00	50.10	10.90	8.18	12.70	3
1650001908	●	M14 x 2	D7	Modified Bottom (2.5P)	110.00	16.00	50.10	10.90	8.18	12.70	3
1650005908	●	M15 x 1	D5	Modified Bottom (2.5P)	100.00	12.00	54.00	12.19	9.14	14.29	3
1650013208	●	M15 x 1.25	D6	Modified Bottom (2.5P)	100.00	12.00	54.00	12.19	9.14	14.29	3
1650006008	●	M15 x 1.5	D6	Modified Bottom (2.5P)	100.00	16.00	54.00	12.19	9.14	14.29	3
1650013108	●	M15 x 2	D7	Modified Bottom (2.5P)	110.00	16.00	54.00	12.19	9.14	14.29	3
1650006108	●	M16 x 1	D5	Modified Bottom (2.5P)	100.00	12.00	54.00	12.19	9.14	14.29	3
1650013308	●	M16 x 1.25	D6	Modified Bottom (2.5P)	100.00	12.00	54.00	12.19	9.14	14.29	3
1650002008	●	M16 x 1.5	D6	Modified Bottom (2.5P)	100.00	16.00	54.00	12.19	9.14	14.29	3
1650002108	●	M16 x 2	D7	Modified Bottom (2.5P)	110.00	16.00	54.00	12.19	9.14	14.29	3
1650006308	●	M17 x 1	D5	Modified Bottom (2.5P)	100.00	12.00	55.00	13.77	10.31	15.88	3
1650013408	●	M17 x 1.25	D6	Modified Bottom (2.5P)	100.00	12.00	55.00	13.77	10.31	15.88	3
1650006208	●	M17 x 1.5	D6	Modified Bottom (2.5P)	100.00	16.00	55.00	13.77	10.31	15.88	3
1650006408	●	M18 x 1	D5	Modified Bottom (2.5P)	100.00	16.00	55.00	13.77	10.31	15.88	4
1650013508	●	M18 x 1.25	D6	Modified Bottom (2.5P)	110.00	16.00	55.00	13.77	10.31	15.88	4

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details



List 16500 (Continued)

A BRAND A-SFT, DIN Overall Length



EDP Number		Thread Size	Thread Limit	Chamfer Type	Overall Length	Thread Length	Neck Length	Shank Dia.	Square Width	Square Length	Number of Flutes
					L (mm)	Lc (mm)	L1 (mm)	d (mm)	k (mm)	lk (mm)	
1650002208	●	M18 x 1.5	D6	Modified Bottom (2.5P)	110.00	16.00	55.00	13.77	10.31	15.88	4
1650006508	●	M18 x 2	D7	Modified Bottom (2.5P)	125.00	25.00	55.00	13.77	10.31	15.88	4
1650002308	●	M18 x 2.5	D7	Modified Bottom (2.5P)	125.00	25.00	55.00	13.77	10.31	15.88	4
1650006608	●	M20 x 1	D5	Modified Bottom (2.5P)	125.00	16.00	61.80	16.56	12.42	17.46	4

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details

ATP

P					M			K	N		S	H				
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel			
Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium				
Low	Medium	High														
1010	1035	1065	4140	Die Steel	300	400	17-4 PH		6061	Casting	Inconel	6Al4V	~35	35-45	45-50	50-70
1018	1045		4340					7075			(30 HRC)	HRC	HRC	HRC	HRC	
⊙	⊙	⊙	⊙	○	⊙	⊙	⊙	○	○			⊙				
80-120 SFM	80-120 SFM	80-120 SFM	35-50 SFM	20-40 SFM	15-35 SFM	15-35 SFM	15-25 SFM	50-80 SFM	70-120 SFM	70-120 SFM			30-55 SFM			

○ Good ○ Best

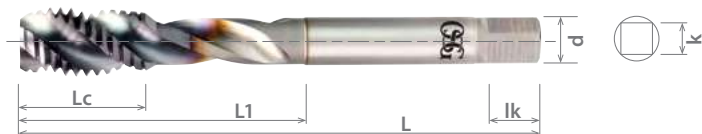


A Brand A-OIL-SFT

Advanced Performance Taps for a Variety of Materials

List 16545

A BRAND A-OIL-SFT, DIN Overall Length



EDP Number		Thread Size	Thread Limit	Overall Length	Thread Length	Neck Length	Shank Diameter	Square Width	Square Length	Number of Flutes
				L (Inch)	Lc (Inch)	L1 (Inch)	d (Inch)	k (Inch)	lk (Inch)	
1654500108	●	1/4 - 20 UNC	H5	3.150	0.402	1.181	0.255	0.191	0.313	3
1654500208	●	1/4 - 28 UNF	H4	3.150	0.402	1.181	0.255	0.191	0.313	3
1654500308	●	5/16 - 18 UNC	H5	3.543	0.445	1.378	0.318	0.238	0.375	3
1654500408	●	5/16 - 24 UNF	H4	3.543	0.445	1.378	0.318	0.238	0.375	3
1654500508	●	3/8 - 16 UNC	H5	3.937	0.500	1.535	0.381	0.286	0.438	3
1654500608	●	3/8 - 24 UNF	H4	3.543	0.500	1.378	0.381	0.286	0.438	3
1654500708	●	7/16 - 14 UNC	H5	3.937	0.571	1.713	0.323	0.242	0.406	3
1654500808	●	7/16 - 20 UNF	H5	3.937	0.571	1.713	0.323	0.242	0.406	3
1654500908	●	1/2 - 13 UNC	H5	4.331	0.614	1.933	0.367	0.275	0.438	3
1654501008	●	1/2 - 20 UNF	H5	3.937	0.614	1.933	0.367	0.275	0.438	3
1654501108	●	9/16 - 12 UNC	H5	4.331	0.665	1.972	0.429	0.322	0.500	3
1654501208	●	9/16 - 18 UNF	H5	3.937	0.665	1.972	0.429	0.322	0.500	3
1654501308	●	5/8 - 11 UNC	H5	4.331	0.728	2.126	0.480	0.360	0.563	3
1654501408	●	5/8 - 18 UNF	H5	3.937	0.728	2.126	0.480	0.360	0.563	3
1654501508	●	3/4 - 10 UNC	H5	4.921	1.000	2.433	0.590	0.442	0.688	4
1654501608	●	3/4 - 16 UNF	H5	4.331	1.000	2.433	0.590	0.442	0.688	4
1654501708	●	7/8 - 9 UNC	H6	5.512	1.110	2.654	0.697	0.523	0.750	4
1654501808	●	7/8 - 14 UNF	H6	4.921	1.110	2.654	0.697	0.523	0.750	4
1654501908	●	1 - 8 UNC	H6	6.299	1.252	3.012	0.800	0.600	0.813	4
1654502008	●	1 - 8 UNC	H8	6.299	1.252	3.012	0.800	0.600	0.813	4
1654502108	●	1 - 12 UNF	H6	5.512	1.252	3.012	0.800	0.600	0.813	4
1654502208	●	1- 1/8 - 7 UNC	H9	7.087	1.732	3.819	0.896	0.672	0.875	4
1654502308	●	1- 1/8 - 8 UN	H9	7.087	1.496	3.819	0.896	0.672	0.875	4
1654502408	●	1- 1/8 - 12 UNF	H8	5.906	1.496	3.071	0.896	0.672	0.875	4
1654502508	●	1- 1/4 - 7 UNC	H10	7.087	1.732	3.937	1.021	0.766	1.000	4
1654502608	●	1- 1/4 - 8 UN	H9	7.087	1.496	3.937	1.021	0.766	1.000	4
1654502708	●	1- 1/4 - 12 UNF	H8	5.906	1.496	3.071	1.021	0.766	1.000	4
1654502808	●	1- 3/8 - 6 UNC	H10	7.874	2.008	4.528	1.108	0.831	1.063	4
1654502908	●	1- 3/8 - 8 UN	H9	7.874	1.496	4.528	1.108	0.831	1.063	4
1654503008	●	1- 3/8 - 12 UNF	H8	6.693	1.496	3.583	1.108	0.831	1.063	4
1654503108	●	1- 1/2 - 6 UNC	H10	7.874	2.008	4.528	1.233	0.925	1.125	4
1654503208	●	1- 1/2 - 8 UN	H9	7.874	1.496	4.528	1.233	0.925	1.125	4
1654503308	●	1- 1/2 - 12 UNF	H8	6.693	1.496	3.583	1.233	0.925	1.125	4
1654503408	●	1- 5/8 - 8 UN	H10	7.874	1.496	4.331	1.305	0.979	1.125	4
1654503508	●	1- 3/4 - 5 UNC	H11	8.661	2.402	4.724	1.430	1.072	1.250	4
1654503608	●	1- 3/4 - 8 UN	H10	7.874	2.008	3.976	1.430	1.072	1.250	4
1654503708	●	1- 7/8 - 8 UN	H10	8.858	2.008	4.921	1.519	1.139	1.250	4
1654503808	●	2 - 4.5 UNC	H12	9.843	2.677	5.512	1.644	1.233	1.375	4
1654503908	●	2 - 8 UN	H10	8.858	2.008	4.803	1.644	1.233	1.375	4

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details

ATP

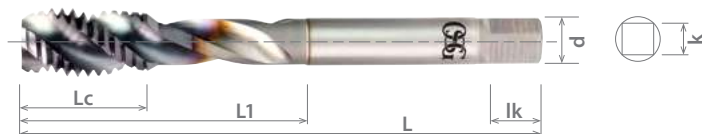
P					M			K	N		S		H			
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel			
Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium				
Low	Medium	High							6061 7075	Casting	Inconel	6Al4V (30 HRC)				
1010 1018	1035 1045	1065	4140 4340		300	400	17-4 PH						~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC
○	○	○	○	○	○	○	○	○	○	○			○			
100-200 SFM	100-200 SFM	100-200 SFM	50-100 SFM	40-80 SFM	25-70 SFM	25-70 SFM	25-50 SFM	60-150 SFM	90-220 SFM	90-220 SFM			50-100 SFM			

○ Good ○ Best



List 16540

A BRAND A-OIL-SFT, DIN Overall Length



EDP Number		Thread Size	Thread Limit	Overall Length	Thread Length	Neck Length	Shank Diameter	Square Width	Square Length	Number of Flutes
				L (mm)	Lc (mm)	L1 (mm)	d (mm)	k (mm)	lk (mm)	
1654000108	●	M6 x 0.75	D4	80.00	8.00	30.00	6.48	4.85	7.94	3
1654000208	●	M6 x 1	D5	80.00	8.00	30.00	6.48	4.85	7.94	3
1654000308	●	M7 x 1	D5	80.00	8.00	30.00	8.08	6.05	9.53	3
1654000408	●	M8 x 0.75	D4	80.00	8.00	33.00	8.08	6.05	9.53	3
1654000508	●	M8 x 1	D5	90.00	10.00	35.00	8.08	6.05	9.53	3
1654000608	●	M8 x 1.25	D5	90.00	10.00	35.00	8.08	6.05	9.53	3
1654000708	●	M9 x 1.25	D5	90.00	10.00	35.00	9.68	7.26	11.11	3
1654000808	●	M10 x 1	D5	90.00	10.00	35.00	9.68	7.26	11.11	3
1654000908	●	M10 x 1.25	D5	100.00	12.00	39.00	9.68	7.26	11.11	3
1654001008	●	M10 x 1.5	D6	100.00	12.00	39.00	9.68	7.26	11.11	3
1654001108	●	M11 x 1.5	D6	100.00	12.00	43.50	8.20	6.15	10.32	3
1654001208	●	M12 x 1	D5	100.00	12.00	49.10	9.32	6.99	11.11	3
1654001308	●	M12 x 1.25	D6	100.00	12.00	49.10	9.32	6.99	11.11	3
1654001408	●	M12 x 1.5	D6	100.00	14.00	49.10	9.32	6.99	11.11	3
1654001508	●	M12 x 1.75	D6	110.00	14.00	49.10	9.32	6.99	11.11	3
1654001608	●	M14 x 1.5	D6	100.00	16.00	50.10	10.90	8.18	12.70	3
1654001708	●	M14 x 2	D7	110.00	16.00	50.10	10.90	8.18	12.70	3
1654001808	●	M15 x 1.5	D6	100.00	16.00	54.00	12.19	9.14	14.29	3
1654001908	●	M16 x 1.5	D6	100.00	16.00	54.00	12.19	9.14	14.29	3
1654002008	●	M16 x 2	D7	110.00	16.00	54.00	12.19	9.14	14.29	3
1654002108	●	M17 x 1.5	D6	100.00	16.00	55.00	13.77	10.31	15.88	3
1654002208	●	M18 x 1.5	D6	110.00	16.00	55.00	13.77	10.31	15.88	4
1654002308	●	M18 x 2.5	D7	125.00	25.00	55.00	13.77	10.31	15.88	4
1654002408	●	M20 x 1.5	D6	125.00	16.00	61.80	16.56	12.42	17.46	4
1654002508	●	M20 x 2.5	D7	140.00	25.00	61.80	16.56	12.42	17.46	4
1654002608	●	M22 x 1.5	D6	125.00	16.00	67.40	17.70	13.28	19.05	4
1654002708	●	M22 x 2	D7	140.00	25.00	67.40	17.70	13.28	19.05	4
1654002808	●	M22 x 2.5	D7	140.00	25.00	67.40	17.70	13.28	19.05	4
1654002908	●	M24 x 1.5	D6	140.00	16.00	68.40	19.30	14.48	19.05	4
1654003008	●	M24 x 2	D7	140.00	30.00	68.40	19.30	14.48	19.05	4
1654003108	●	M24 x 3	D8	160.00	30.00	68.40	19.30	14.48	19.05	4
1654003208	●	M27 x 3	D10	160.00	36.00	80.00	22.76	17.07	22.23	4
1654003308	●	M30 x 3.5	D11	180.00	42.00	100.00	25.93	19.46	25.40	4
1654003408	●	M33 x 3.5	D11	180.00	42.00	95.00	28.14	21.11	26.99	4
1654003508	●	M36 x 4	D11	200.00	48.00	115.00	31.32	23.50	28.58	4
1654003608	●	M39 x 4	D11	200.00	48.00	110.00	33.15	24.87	28.58	4
1654003708	●	M42 x 4.5	D12	200.00	54.00	100.00	36.32	27.23	31.75	4
1654003808	●	M45 x 4.5	D12	220.00	54.00	120.00	38.58	28.93	31.75	4
1654003908	●	M48 x 5	D13	250.00	60.00	140.00	41.76	31.32	34.93	4
1654004008	●	M56 x 5.5	D14	250.00	66.00	130.00	48.11	36.07	36.51	4

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details



P					M			K	N		S	H				
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel			
Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium				
Low	Medium	High														
1010	1035	1065	4140	4340	300	400	17-4 PH		6061 7075	Casting	Inconel	6Al4V (30 HRC)	~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC
⊙	⊙	⊙	⊙		⊙	⊙	⊙	⊙	⊙	⊙			⊙			
100-200 SFM	100-200 SFM	100-200 SFM	50-100 SFM	40-80 SFM	25-70 SFM	25-70 SFM	25-50 SFM	60-150 SFM	90-220 SFM	90-220 SFM			50-100 SFM			

○ Good ○ Best



A Brand A-LT-SFT

Advanced Performance Taps for a Variety of Materials

List 16525

A BRAND A-LT-SFT, Long Shank



EDP Number		Thread Size	Thread Limit	Overall Length	Thread Length	Neck Length	Shank Diameter	Square Width	Square Length	Number of Flutes
				L (Inch)	Lc (Inch)	L1 (Inch)	d (Inch)	k (Inch)	lk (Inch)	
1652505608	●	No. 4 - 40 UNC	H2	3.150	0.197	0.750	0.141	0.110	0.188	2
1652505708	●	No. 4 - 48 UNF	H2	3.150	0.197	0.750	0.141	0.110	0.188	2
1652500308	●	No. 5 - 40 UNC	H2	3.937	0.201	0.760	0.141	0.110	0.188	2
1652505908	●	No. 5 - 44 UNF	H2	3.937	0.201	0.760	0.141	0.110	0.188	2
1652500608	●	No. 6 - 32 UNC	H3	4.724	0.248	0.783	0.141	0.110	0.188	2
1652500708	●	No. 6 - 40 UNF	H2	3.937	0.248	0.783	0.141	0.110	0.188	2
1652500908	●	No. 8 - 32 UNC	H3	4.724	0.252	0.827	0.168	0.131	0.250	2
1652501008	●	No. 8 - 36 UNF	H2	3.937	0.252	0.827	0.168	0.131	0.250	2
1652501108	●	No. 10 - 24 UNC	H3	4.921	0.327	0.976	0.194	0.152	0.250	2
1652501308	●	No. 10 - 32 UNF	H3	5.906	0.327	0.976	0.194	0.152	0.250	2
1652501408	●	No. 12 - 24 UNC	H3	4.921	0.331	1.177	0.220	0.165	0.281	2
1652501508	●	No. 12 - 28 UNF	H3	4.921	0.331	1.177	0.220	0.165	0.281	2
1652501708	●	1/4 - 20 UNC	H5	5.906	0.398	1.177	0.255	0.191	0.313	2
1652501908	●	1/4 - 28 UNF	H4	5.906	0.398	1.177	0.255	0.191	0.313	2
1652502108	●	5/16 - 18 UNC	H5	5.906	0.445	1.378	0.318	0.238	0.375	3
1652502308	●	5/16 - 24 UNF	H4	5.906	0.445	1.378	0.318	0.238	0.375	3
1652502508	●	3/8 - 16 UNC	H5	5.906	0.500	1.535	0.381	0.286	0.438	3
1652502708	●	3/8 - 24 UNF	H4	5.906	0.500	1.378	0.381	0.286	0.438	3
1652502908	●	7/16 - 14 UNC	H5	5.906	0.571	2.362	0.323	0.242	0.406	3
1652503108	●	7/16 - 20 UNF	H5	5.906	0.571	2.362	0.323	0.242	0.406	3
1652503308	●	1/2 - 13 UNC	H5	7.087	0.614	2.835	0.367	0.275	0.438	3
1652503508	●	1/2 - 20 UNF	H5	7.087	0.614	2.835	0.367	0.275	0.438	3
1652503708	●	9/16 - 12 UNC	H5	7.087	0.665	2.835	0.429	0.322	0.500	3
1652503908	●	9/16 - 18 UNF	H5	7.087	0.665	2.835	0.429	0.322	0.500	3
1652504108	●	5/8 - 11 UNC	H5	7.087	0.728	2.835	0.480	0.360	0.563	3
1652504308	●	5/8 - 18 UNF	H5	7.087	0.728	2.835	0.480	0.360	0.563	3
1652504508	●	3/4 - 10 UNC	H5	7.874	1.000	3.150	0.590	0.442	0.688	4
1652504708	●	3/4 - 16 UNF	H5	7.874	1.000	3.150	0.590	0.442	0.688	4
1652504908	●	7/8 - 9 UNC	H6	7.874	1.110	3.150	0.697	0.523	0.750	4
1652505108	●	7/8 - 14 UNF	H6	7.874	1.110	3.150	0.697	0.523	0.750	4
1652505308	●	1 - 8 UNC	H6	7.874	1.252	3.465	0.800	0.600	0.813	4
1652505508	●	1 - 12 UNF	H6	7.874	1.252	3.465	0.800	0.600	0.813	4

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details

ATP

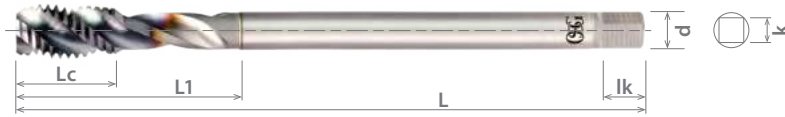
P					M			K	N		S		H			
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel			
Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium				
Low	Medium	High							6061 7075	Casting	Inconel	6Al4V (30 HRC)				
1010 1018	1035 1045	1065	4140 4340		300	400	17-4 PH						~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC
○	○	○	○	○	○	○	○	○	○	○			○			
80-120 SFM	80-120 SFM	80-120 SFM	35-50 SFM	20-40 SFM	15-35 SFM	15-35 SFM	15-25 SFM	50-80 SFM	70-120 SFM	70-120 SFM			30-55 SFM			

○ Good ○ Best



List 16520

A BRAND A-LT-SFT, Long Shank



EDP Number		Thread Size	Thread Limit	Overall Length	Thread Length	Neck Length	Shank Diameter	Square Width	Square Length	Number of Flutes
				L (mm)	Lc (mm)	L1 (mm)	d (mm)	k (mm)	lk (mm)	
1652001208	●	M3 x 0.35	D3	100.00	4.10	18.10	3.58	2.79	4.76	3
1652001308	●	M3 x 0.5	D3	100.00	4.10	18.10	3.58	2.79	4.76	3
1652001408	●	M3.5 x 0.35	D3	100.00	4.80	20.00	3.58	2.79	4.76	3
1652001508	●	M3.5 x 0.6	D3	100.00	4.80	20.00	3.58	2.79	4.76	3
1652001608	●	M4 x 0.5	D3	100.00	5.60	21.00	4.27	3.33	6.35	3
1652001708	●	M4 x 0.7	D4	100.00	5.60	21.00	4.27	3.33	6.35	3
1652001808	●	M4.5 x 0.5	D3	100.00	6.10	25.10	4.93	3.86	6.35	3
1652001908	●	M4.5 x 0.75	D4	100.00	6.10	25.10	4.93	3.86	6.35	3
1652002008	●	M5 x 0.5	D3	125.00	6.40	25.00	4.93	3.86	6.35	3
1652002108	●	M5 x 0.8	D4	125.00	6.40	25.00	4.93	3.86	6.35	3
1652002208	●	M5.5 x 0.5	D3	125.00	7.30	30.10	5.59	4.19	7.14	3
1652002308	●	M6 x 0.5	D3	125.00	8.00	30.00	6.48	4.85	7.94	3
1652002508	●	M6 x 0.75	D4	150.00	8.00	30.00	6.48	4.85	7.94	3
1652002708	●	M6 x 1	D5	150.00	8.00	30.00	6.48	4.85	7.94	3
1652003308	●	M8 x 0.75	D4	150.00	8.00	33.00	8.08	6.05	9.53	3
1652003508	●	M8 x 1	D5	150.00	10.00	35.00	8.08	6.05	9.53	3
1652003708	●	M8 x 1.25	D5	150.00	10.00	35.00	8.08	6.05	9.53	3
1652004508	●	M10 x 0.75	D4	150.00	10.00	35.00	9.68	7.26	11.11	3
1652004708	●	M10 x 1	D5	150.00	10.00	35.00	9.68	7.26	11.11	3
1652004908	●	M10 x 1.25	D5	150.00	12.00	39.00	9.68	7.26	11.11	3
1652005108	●	M10 x 1.5	D6	150.00	12.00	39.00	9.68	7.26	11.11	3
1652006108	●	M12 x 1	D5	180.00	12.00	72.00	9.32	6.99	11.11	3
1652006308	●	M12 x 1.25	D6	180.00	12.00	72.00	9.32	6.99	11.11	3
1652006508	●	M12 x 1.5	D6	180.00	14.00	72.00	9.32	6.99	11.11	3
1652006708	●	M12 x 1.75	D6	180.00	14.00	72.00	9.32	6.99	11.11	3
1652006808	●	M14 x 1	D5	150.00	12.00	60.00	10.90	8.18	12.70	3
1652006908	●	M14 x 1.25	D6	150.00	12.00	60.00	10.90	8.18	12.70	3
1652007008	●	M14 x 1.5	D6	150.00	16.00	60.00	10.90	8.18	12.70	3
1652007108	●	M14 x 2	D7	150.00	16.00	60.00	10.90	8.18	12.70	3
1652007208	●	M15 x 1	D5	160.00	12.00	64.00	12.19	9.14	14.29	3
1652007308	●	M15 x 1.5	D6	160.00	16.00	64.00	12.19	9.14	14.29	3
1652007408	●	M16 x 1	D5	160.00	12.00	64.00	12.19	9.14	14.29	3
1652007508	●	M16 x 1.5	D6	160.00	16.00	64.00	12.19	9.14	14.29	3
1652007708	●	M16 x 2	D7	180.00	16.00	72.00	12.19	9.14	14.29	3
1652008008	●	M18 x 1	D5	180.00	16.00	72.00	13.77	10.31	15.88	4
1652008108	●	M18 x 1.5	D6	180.00	16.00	72.00	13.77	10.31	15.88	4
1652008208	●	M18 x 2	D7	180.00	25.00	72.00	13.77	10.31	15.88	4
1652008308	●	M18 x 2.5	D7	180.00	25.00	72.00	13.77	10.31	15.88	4
1652008408	●	M20 x 1	D5	200.00	16.00	80.00	16.56	12.42	17.46	4
1652008508	●	M20 x 1.5	D6	200.00	16.00	80.00	16.56	12.42	17.46	4
1652008608	●	M20 x 2	D7	200.00	25.00	80.00	16.56	12.42	17.46	4
1652008708	●	M20 x 2.5	D7	200.00	25.00	80.00	16.56	12.42	17.46	4

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details

ATP

CONTINUED ➔

P					M			K	N		S	H				
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel			
Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium				
Low	Medium	High							6061	Casting	Inconel	6Al4V (30 HRC)				
1010	1035	1065	4140	Die Steel	300	400	17-4 PH	Cast Iron	6061	Casting	Inconel	6Al4V (30 HRC)	~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC
1018	1045		4340						7075							
○	○	○	○	○	○	○	○	○	○	○			○			
80-120 SFM	80-120 SFM	80-120 SFM	35-50 SFM	20-40 SFM	15-35 SFM	15-35 SFM	15-25 SFM	50-80 SFM	70-120 SFM	70-120 SFM			30-55 SFM			

○ Good ○ Best

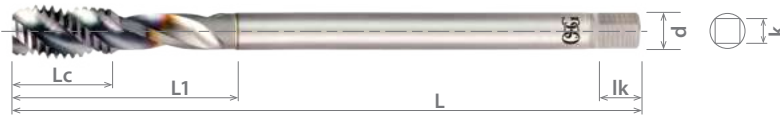


A Brand A-LT-SFT

Advanced Performance Taps for a Variety of Materials

List 16520 (Continued)

A BRAND A-LT-SFT, Long Shank



EDP Number		Thread Size	Thread Limit	Overall Length	Thread Length	Neck Length	Shank Diameter	Square Width	Square Length	Number of Flutes
				L (mm)	Lc (mm)	L1 (mm)	d (mm)	k (mm)	lk (mm)	
1652008808	●	M22 x 1	D5	200.00	16.00	80.00	17.70	13.28	19.05	4
1652008908	●	M22 x 1.5	D6	200.00	16.00	80.00	17.70	13.28	19.05	4
1652009008	●	M22 x 2	D7	200.00	25.00	80.00	17.70	13.28	19.05	4
1652009108	●	M22 x 2.5	D7	200.00	25.00	80.00	17.70	13.28	19.05	4
1652009208	●	M24 x 1	D5	200.00	16.00	83.00	19.30	14.48	19.05	4
1652009308	●	M24 x 1.5	D6	200.00	16.00	83.00	19.30	14.48	19.05	4
1652009408	●	M24 x 2	D7	200.00	30.00	83.00	19.30	14.48	19.05	4
1652009508	●	M24 x 3	D8	200.00	30.00	83.00	19.30	14.48	19.05	4

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details



P					M			K	N		S	H				
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel			
Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium				
Low	Medium	High							6061	Casting	Inconel	6Al4V (30 HRC)				
1010	1035	1065	4140	Die Steel	300	400	17-4 PH		6061	Casting	Inconel	6Al4V (30 HRC)	~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC
1018	1045	1065	4340													
⊙	⊙	⊙	⊙	○	⊙	⊙	⊙	○	○	○		⊙				
80-120 SFM	80-120 SFM	80-120 SFM	35-50 SFM	20-40 SFM	15-35 SFM	15-35 SFM	15-25 SFM	50-80 SFM	70-120 SFM	70-120 SFM			30-55 SFM			

○ Good ○ Best



List 16515

A BRAND A-POT, DIN Overall Length



EDP		Thread Size	Thread Limit	Overall Length	Thread Length	Neck Length	Shank Diameter	Square Width	Square Length	Number of Flutes
				L (Inch)	Lc (Inch)	L1 (Inch)	d (Inch)	k (Inch)	lk (Inch)	
1651505608	●	No. 2 - 56 UNC	H2	1.772	0.437	0.476	0.141	0.110	0.188	2
1651505708	●	No. 2 - 64 UNF	H2	1.772	0.437	0.476	0.141	0.110	0.188	2
1651505808	●	No. 3 - 48 UNC	H2	1.969	0.500	0.539	0.141	0.110	0.188	2
1651505908	●	No. 3 - 56 UNF	H2	1.969	0.500	0.539	0.141	0.110	0.188	2
1651500108	●	No. 4 - 40 UNC	H2	2.205	0.295	0.704	0.141	0.110	0.188	2
1651500208	●	No. 4 - 48 UNF	H2	2.205	0.295	0.704	0.141	0.110	0.188	2
1651500308	●	No. 6 - 40 UNC	H2	2.205	0.299	0.708	0.141	0.110	0.188	3
1651500408	●	No. 5 - 44 UNF	H2	2.205	0.299	0.708	0.141	0.110	0.188	3
1651500608	●	No. 6 - 32 UNC	H2	2.205	0.370	0.783	0.141	0.110	0.188	3
1651500508	●	No. 6 - 32 UNC	H3	2.205	0.370	0.783	0.141	0.110	0.188	3
1651500708	●	No. 6 - 40 UNF	H2	2.205	0.370	0.783	0.141	0.110	0.188	3
1651500908	●	No. 8 - 32 UNC	H2	2.480	0.374	0.826	0.168	0.131	0.250	3
1651500808	●	No. 8 - 32 UNC	H3	2.480	0.374	0.826	0.168	0.131	0.250	3
1651501008	●	No. 8 - 36 UNF	H2	2.480	0.374	0.826	0.168	0.131	0.250	3
1651501108	●	No. 10 - 24 UNC	H3	2.756	0.492	0.976	0.194	0.152	0.250	3
1651501308	●	No. 10 - 32 UNF	H2	2.756	0.492	0.976	0.194	0.152	0.250	3
1651501208	●	No. 10 - 32 UNF	H3	2.756	0.492	0.976	0.194	0.152	0.250	3
1651501408	●	No. 12 - 24 UNC	H3	3.150	0.496	1.177	0.220	0.165	0.281	3
1651501508	●	No. 12 - 28 UNF	H3	3.150	0.496	1.177	0.220	0.165	0.281	3
1651506008	●	No. 12 - 32 UNEF	H3	3.150	0.496	1.177	0.220	0.165	0.281	3
1651501708	●	1/4 - 20 UNC	H3	3.150	0.594	1.177	0.255	0.191	0.313	3
1651501608	●	1/4 - 20 UNC	H5	3.150	0.594	1.177	0.255	0.191	0.313	3
1651501908	●	1/4 - 28 UNF	H3	3.150	0.590	1.173	0.255	0.191	0.313	3
1651501808	●	1/4 - 28 UNF	H4	3.150	0.590	1.173	0.255	0.191	0.313	3
1651506108	●	1/4 - 32 UNEF	H3	3.150	0.586	1.169	0.255	0.191	0.313	3
1651502108	●	5/16 - 18 UNC	H3	3.543	0.665	1.377	0.318	0.238	0.375	3
1651502008	●	5/16 - 18 UNC	H5	3.543	0.665	1.377	0.318	0.238	0.375	3
1651502308	●	5/16 - 24 UNF	H3	3.543	0.661	1.374	0.318	0.238	0.375	3
1651502208	●	5/16 - 24 UNF	H4	3.543	0.661	1.374	0.318	0.238	0.375	3
1651506208	●	5/16 - 32 UNEF	H3	3.150	0.653	1.366	0.318	0.238	0.375	3
1651502508	●	3/8 - 16 UNC	H3	3.937	0.751	1.535	0.381	0.286	0.438	3
1651502408	●	3/8 - 16 UNC	H5	3.937	0.751	1.535	0.381	0.286	0.438	3
1651502708	●	3/8 - 24 UNF	H3	3.543	0.751	1.377	0.381	0.286	0.438	3
1651502608	●	3/8 - 24 UNF	H4	3.543	0.751	1.377	0.381	0.286	0.438	3
1651506308	●	3/8 - 32 UNEF	H3	3.543	0.744	1.370	0.381	0.286	0.438	3
1651502908	●	7/16 - 14 UNC	H3	3.937	0.858	1.291	0.323	0.242	0.406	3
1651502808	●	7/16 - 14 UNC	H5	3.937	0.858	1.291	0.323	0.242	0.406	3
1651503108	●	7/16 - 20 UNF	H3	3.937	0.858	1.291	0.323	0.242	0.406	3
1651503008	●	7/16 - 20 UNF	H5	3.937	0.858	1.291	0.323	0.242	0.406	3
1651506408	●	7/16 - 28 UNEF	H4	3.543	0.858	1.291	0.323	0.242	0.406	3
1651503308	●	1/2 - 13 UNC	H3	4.331	0.921	1.354	0.367	0.275	0.438	3
1651503208	●	1/2 - 13 UNC	H5	4.331	0.921	1.354	0.367	0.275	0.438	3
1651503508	●	1/2 - 20 UNF	H3	3.937	0.921	1.354	0.367	0.275	0.438	3

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details

ATP

CONTINUED

P					M			K	N		S	H				
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel			
Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium				
Low	Medium	High							6061	Casting	Inconel	6Al4V (30 HRC)				
1010	1035	1065	4140	Die Steel	300	400	17-4 PH		7075				~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC
1018	1045		4340													
○	○	○	○	○	○	○	○	○	○	○			○			
80-120 SFM	80-120 SFM	80-120 SFM	40-65 SFM	35-55 SFM	25-75 SFM	25-60 SFM	25-60 SFM	60-100 SFM	70-120 SFM	70-120 SFM			40-65 SFM			

○ Good ○ Best



A Brand A-POT

Advanced Performance Taps for a Variety of Materials

List 16515 (Continued)

A BRAND A-POT, DIN Overall Length



EDP		Thread Size	Thread Limit	Overall Length	Thread Length	Neck Length	Shank Diameter	Square Width	Square Length	Number of Flutes
				L (Inch)	Lc (Inch)	L1 (Inch)	d (Inch)	k (Inch)	lk (Inch)	
1651503408	●	1/2 - 20 UNF	H5	3.937	0.921	1.354	0.367	0.275	0.438	3
1651506508	●	1/2 - 28 UNEF	H4	3.937	0.921	1.354	0.367	0.275	0.438	3
1651503708	●	9/16 - 12 UNC	H3	4.331	1.000	1.472	0.429	0.322	0.500	3
1651503608	●	9/16 - 12 UNC	H5	4.331	1.000	1.472	0.429	0.322	0.500	3
1651503908	●	9/16 - 18 UNF	H3	3.937	1.000	1.472	0.429	0.322	0.500	3
1651503808	●	9/16 - 18 UNF	H5	3.937	1.000	1.472	0.429	0.322	0.500	3
1651506608	●	9/16 - 24 UNEF	H4	3.937	1.000	1.472	0.429	0.322	0.500	3
1651504108	●	5/8 - 11 UNC	H3	4.331	1.090	1.562	0.480	0.360	0.563	3
1651504008	●	5/8 - 11 UNC	H5	4.331	1.090	1.562	0.480	0.360	0.563	3
1651504308	●	5/8 - 18 UNF	H3	3.937	1.090	1.562	0.480	0.360	0.563	3
1651504208	●	5/8 - 18 UNF	H5	3.937	1.090	1.562	0.480	0.360	0.563	3
1651506708	●	5/8 - 24 UNEF	H4	3.937	1.090	1.562	0.480	0.360	0.563	3
1651506808	●	11/16 - 24 UNEF	H4	4.331	1.200	1.712	0.542	0.406	0.625	3
1651504508	●	3/4 - 10 UNC	H3	4.921	1.200	1.712	0.590	0.442	0.688	3
1651504408	●	3/4 - 10 UNC	H5	4.921	1.200	1.712	0.590	0.442	0.688	3
1651504708	●	3/4 - 16 UNF	H3	4.331	1.200	1.712	0.590	0.442	0.688	3
1651504608	●	3/4 - 16 UNF	H5	4.331	1.200	1.712	0.590	0.442	0.688	3
1651506908	●	3/4 - 20 UNEF	H5	4.331	1.200	1.712	0.590	0.442	0.688	3
1651507008	●	13/16 - 20 UNEF	H5	4.921	1.200	1.712	0.652	0.489	0.688	3
1651504908	●	7/8 - 9 UNC	H4	5.512	1.334	1.885	0.697	0.523	0.750	3
1651504808	●	7/8 - 9 UNC	H6	5.512	1.334	1.885	0.697	0.523	0.750	3
1651505108	●	7/8 - 14 UNF	H4	4.921	1.334	1.885	0.697	0.523	0.750	3
1651505008	●	7/8 - 14 UNF	H6	4.921	1.334	1.885	0.697	0.523	0.750	3
1651507108	●	7/8 - 20 UNEF	H5	4.921	1.334	1.885	0.697	0.523	0.750	3
1651507208	●	15/16 - 20 UNEF	H5	5.512	1.500	2.090	0.760	0.570	0.750	3
1651505308	●	1 - 8 UNC	H4	6.299	1.500	2.090	0.800	0.600	0.813	3
1651505208	●	1 - 8 UNC	H6	6.299	1.500	2.090	0.800	0.600	0.813	3
1651505508	●	1 - 12 UNF	H4	5.512	1.500	2.090	0.800	0.600	0.813	3
1651505408	●	1 - 12 UNF	H6	5.512	1.500	2.090	0.800	0.600	0.813	3
1651507408	●	1 - 14 UNS	H6	5.512	1.500	2.090	0.800	0.600	0.813	3
1651507308	●	1 - 20 UNEF	H5	5.512	1.500	2.090	0.800	0.600	0.813	3

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details

ATP

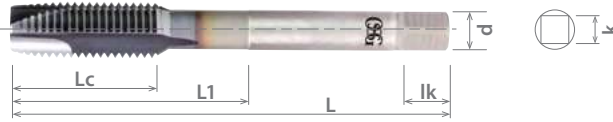
P					M			K	N		S		H			
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel			
Carbon Steel			Alloy Steel	Aluminum					Nickel Alloy	Titanium						
Low	Medium	High		Die Steel					6061 7075	Casting	Inconel	6Al4V (30 HRC)	~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC
1010	1035	1065	4140	Die Steel	300	400	17-4 PH	Cast Iron	6061 7075	Casting	Inconel	6Al4V (30 HRC)	~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC
1018	1045	4340	4340		300	400	17-4 PH		6061 7075	Casting	Inconel	6Al4V (30 HRC)	~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC
○	○	○	○	○	○	○	○	○	○	○		○	○			
80-120 SFM	80-120 SFM	80-120 SFM	40-65 SFM	35-55 SFM	25-75 SFM	25-60 SFM	25-60 SFM	60-100 SFM	70-120 SFM	70-120 SFM			40-65 SFM			

○ Good ○ Best



List 16510

A BRAND A-POT, DIN Overall Length



EDP		Thread Size	Thread Limit	Overall Length	Thread Length	Neck Length	Shank Diameter	Square Width	Square Length	Number of Flutes
				L (mm)	Lc (mm)	L1 (mm)	d (mm)	k (mm)	Ik (mm)	
1651003008	●	M1.4 x 0.3	D2	40.00	7.90	8.90	3.58	2.79	4.76	2
1651003108	●	M1.6 x 0.35	D3	40.00	7.90	8.90	3.58	2.79	4.76	2
1651003208	●	M1.7 x 0.35	D3	40.00	9.50	10.50	3.58	2.79	4.76	2
1651003308	●	M2 x 0.25	D2	45.00	11.10	12.10	3.58	2.79	4.76	2
1651003408	●	M2 x 0.4	D3	45.00	11.10	12.10	3.58	2.79	4.76	2
1651003508	●	M2.2 x 0.25	D2	45.00	11.10	12.10	3.58	2.79	4.76	2
1651003608	●	M2.2 x 0.45	D3	45.00	11.10	12.10	3.58	2.79	4.76	2
1651003708	●	M2.3 x 0.4	D3	45.00	11.10	12.10	3.58	2.79	4.76	2
1651003808	●	M2.5 x 0.35	D3	50.00	12.80	13.80	3.58	2.79	4.76	2
1651003908	●	M2.5 x 0.45	D3	50.00	12.80	13.80	3.58	2.79	4.76	2
1651004008	●	M2.6 x 0.45	D3	50.00	12.80	13.80	3.58	2.79	4.76	2
1651004108	●	M3 x 0.35	D3	56.00	6.10	18.10	3.58	2.79	4.76	3
1651000108	●	M3 x 0.5	D3	56.00	6.10	18.10	3.58	2.79	4.76	3
1651004208	●	M3.5 x 0.35	D3	56.00	7.20	19.80	3.58	2.79	4.76	3
1651004308	●	M3.5 x 0.6	D3	56.00	7.20	19.80	3.58	2.79	4.76	3
1651000208	●	M4 x 0.5	D3	63.00	8.40	21.00	4.27	3.33	6.35	3
1651000308	●	M4 x 0.7	D4	63.00	8.40	21.00	4.27	3.33	6.35	3
1651004408	●	M4.5 x 0.5	D3	70.00	9.10	24.80	4.93	3.86	6.35	3
1651004508	●	M4.5 x 0.75	D4	70.00	9.10	24.80	4.93	3.86	6.35	3
1651000408	●	M5 x 0.5	D3	70.00	9.10	24.80	4.93	3.86	6.35	3
1651000508	●	M5 x 0.8	D4	70.00	9.10	24.80	4.93	3.86	6.35	3
1651004608	●	M5.5 x 0.5	D3	80.00	10.80	29.70	5.59	4.19	7.14	3
1651000608	●	M6 x 0.5	D3	80.00	12.00	29.70	6.48	4.85	7.94	3
1651000708	●	M6 x 0.75	D4	80.00	12.00	29.70	6.48	4.85	7.94	3
1651000808	●	M6 x 1	D5	80.00	12.00	29.70	6.48	4.85	7.94	3
1651004708	●	M7 x 0.75	D4	80.00	12.10	29.70	8.08	6.05	9.53	3
1651004808	●	M7 x 1	D5	80.00	12.10	29.70	8.08	6.05	9.53	3
1651004908	●	M8 x 0.75	D4	80.00	15.40	30.00	8.08	6.05	9.53	3
1651000908	●	M8 x 1	D5	90.00	15.40	34.80	8.08	6.05	9.53	3
1651001008	●	M8 x 1.25	D5	90.00	15.40	34.80	8.08	6.05	9.53	3
1651005008	●	M9 x 0.75	D4	90.00	14.00	34.70	9.68	7.26	11.11	3
1651005108	●	M9 x 1	D5	90.00	14.00	34.70	9.68	7.26	11.11	3
1651005208	●	M9 x 1.25	D5	90.00	15.40	34.70	9.68	7.26	11.11	3
1651005308	●	M10 x 0.75	D4	90.00	17.00	34.80	9.68	7.26	11.11	3
1651001108	●	M10 x 1	D5	90.00	18.00	34.80	9.68	7.26	11.11	3
1651001208	●	M10 x 1.25	D5	100.00	17.00	38.90	9.68	7.26	11.11	3
1651001308	●	M10 x 1.5	D6	100.00	18.00	38.90	9.68	7.26	11.11	3
1651005408	●	M11 x 0.75	D4	90.00	18.00	29.00	8.20	6.15	10.32	3
1651005508	●	M11 x 1	D5	90.00	18.00	29.00	8.20	6.15	10.32	3
1651005608	●	M11 x 1.5	D6	100.00	18.00	29.00	8.20	6.15	10.32	3
1651001408	●	M12 x 1	D5	100.00	21.00	32.00	9.32	6.99	11.11	3
1651001508	●	M12 x 1.25	D6	100.00	21.00	32.00	9.32	6.99	11.11	3
1651001608	●	M12 x 1.5	D6	100.00	21.00	32.00	9.32	6.99	11.11	3

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details

ATP

CONTINUED ➔

P					M			K	N		S		H			
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel			
Carbon Steel			Alloy Steel	Titanium												
Low	Medium	High														
1010	1035	1065	4140	Die Steel	300	400	17-4 PH		6061	Casting	Inconel	6Al4V (30 HRC)	~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC
1018	1045		4340					7075								
⊙	⊙	⊙	⊙	○	⊙	⊙	⊙	○	○		⊙					
80-120 SFM	80-120 SFM	80-120 SFM	40-65 SFM	35-55 SFM	25-75 SFM	25-60 SFM	25-60 SFM	60-100 SFM	70-120 SFM	70-120 SFM			40-65 SFM			

○ Good ○ Best



A Brand A-POT

Advanced Performance Taps for a Variety of Materials

List 16510 (Continued)

A BRAND A-POT, DIN Overall Length



EDP		Thread Size	Thread Limit	Overall Length	Thread Length	Neck Length	Shank Diameter	Square Width	Square Length	Number of Flutes
				L (mm)	Lc (mm)	L1 (mm)	d (mm)	k (mm)	lk (mm)	
1651001708	●	M12 x 1.75	D6	110.00	21.00	32.00	9.32	6.99	11.11	3
1651005708	●	M14 x 1	D5	100.00	24.00	36.00	10.90	8.18	12.70	4
1651005808	●	M14 x 1.25	D6	100.00	24.00	36.00	10.90	8.18	12.70	4
1651001808	●	M14 x 1.5	D6	100.00	24.00	36.00	10.90	8.18	12.70	4
1651001908	●	M14 x 2	D7	110.00	24.00	36.00	10.90	8.18	12.70	3
1651005908	●	M15 x 1	D5	100.00	24.00	36.00	12.19	9.14	14.29	4
1651007308	●	M15 x 1.25	D6	100.00	24.00	36.00	12.19	9.14	14.29	4
1651006008	●	M15 x 1.5	D6	100.00	24.00	36.00	12.19	9.14	14.29	4
1651007208	●	M15 x 2	D7	110.00	24.00	36.00	12.19	9.14	14.29	3
1651006108	●	M16 x 1	D5	100.00	24.00	36.00	12.19	9.14	14.29	4
1651007408	●	M16 x 1.25	D6	100.00	24.00	36.00	12.19	9.14	14.29	4
1651002008	●	M16 x 1.5	D6	100.00	24.00	36.00	12.19	9.14	14.29	4
1651002108	●	M16 x 2	D7	110.00	24.00	36.00	12.19	9.14	14.29	3
1651006208	●	M17 x 1	D5	100.00	24.00	36.00	13.77	10.31	15.88	4
1651007508	●	M17 x 1.25	D6	100.00	24.00	36.00	13.77	10.31	15.88	4
1651006308	●	M17 x 1.5	D6	100.00	24.00	36.00	13.77	10.31	15.88	4
1651006408	●	M18 x 1	D5	110.00	30.00	43.00	13.77	10.31	15.88	4
1651007608	●	M18 x 1.25	D6	110.00	30.00	43.00	13.77	10.31	15.88	4
1651002208	●	M18 x 1.5	D6	110.00	30.00	43.00	13.77	10.31	15.88	4
1651006508	●	M18 x 2	D7	125.00	30.00	43.00	13.77	10.31	15.88	4
1651002308	●	M18 x 2.5	D7	125.00	30.00	43.00	13.77	10.31	15.88	3
1651006608	●	M20 x 1	D5	125.00	30.00	44.00	16.56	12.42	17.46	4
1651002408	●	M20 x 1.5	D6	125.00	30.00	44.00	16.56	12.42	17.46	4
1651006708	●	M20 x 2	D7	140.00	30.00	44.00	16.56	12.42	17.46	4
1651002508	●	M20 x 2.5	D7	140.00	30.00	44.00	16.56	12.42	17.46	3
1651006808	●	M22 x 1	D5	125.00	30.00	44.00	17.70	13.28	19.05	4
1651002608	●	M22 x 1.5	D6	125.00	30.00	44.00	17.70	13.28	19.05	4
1651006908	●	M22 x 2	D7	140.00	30.00	44.00	17.70	13.28	19.05	4
1651002708	●	M22 x 2.5	D7	140.00	30.00	44.00	17.70	13.28	19.05	3
1651007008	●	M24 x 1	D5	140.00	36.00	51.00	19.30	14.48	19.05	4
1651002808	●	M24 x 1.5	D6	140.00	36.00	51.00	19.30	14.48	19.05	4
1651007108	●	M24 x 2	D7	140.00	36.00	51.00	19.30	14.48	19.05	4
1651002908	●	M24 x 3	D8	160.00	36.00	51.00	19.30	14.48	19.05	3

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details



P					M			K	N		S		H				
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel				
Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium					
Low	Medium	High							1010	1035	1065	4140	4340	6061	7075	Casting	Inconel
1010	1035	1065	4140	4340	300	400	17-4 PH										
1018	1045																
80-120 SFM	80-120 SFM	80-120 SFM	40-65 SFM	35-55 SFM	25-75 SFM	25-60 SFM	25-60 SFM	60-100 SFM	70-120 SFM	70-120 SFM				40-65 SFM			

○ Good ○ Best



List 16555

A BRAND A-OIL-POT, DIN Overall Length



EDP		Thread Size	Thread Limit	Overall Length	Thread Length	Neck Length	Shank Diameter	Square Width	Square Length	Number of Flutes
				L (Inch)	Lc (Inch)	L1 (Inch)	d (Inch)	k (Inch)	lk (Inch)	
1655500108	●	1/4 - 20 UNC	H5	3.150	0.598	1.181	0.255	0.191	0.313	3
1655500208	●	1/4 - 28 UNF	H4	3.150	0.598	1.181	0.255	0.191	0.313	3
1655500308	●	5/16 - 18 UNC	H5	3.543	0.665	1.377	0.318	0.238	0.375	3
1655500408	●	5/16 - 24 UNF	H4	3.543	0.665	1.377	0.318	0.238	0.375	3
1655500508	●	3/8 - 16 UNC	H5	3.937	0.751	1.535	0.381	0.286	0.438	3
1655500608	●	3/8 - 24 UNF	H4	3.543	0.751	1.377	0.381	0.286	0.438	3
1655500708	●	7/16 - 14 UNC	H5	3.937	0.858	1.291	0.323	0.242	0.406	3
1655500808	●	7/16 - 20 UNF	H5	3.937	0.858	1.291	0.323	0.242	0.406	3
1655500908	●	1/2 - 13 UNC	H5	4.331	0.921	1.354	0.367	0.275	0.438	3
1655501008	●	1/2 - 20 UNF	H5	3.937	0.921	1.354	0.367	0.275	0.438	3
1655501108	●	9/16 - 12 UNC	H5	4.331	1.000	1.472	0.429	0.322	0.500	3
1655501208	●	9/16 - 18 UNF	H5	3.937	1.000	1.472	0.429	0.322	0.500	3
1655501308	●	5/8 - 11 UNC	H5	4.331	1.090	1.562	0.480	0.360	0.563	3
1655501408	●	5/8 - 18 UNF	H5	3.937	1.090	1.562	0.480	0.360	0.563	3
1655501508	●	3/4 - 10 UNC	H5	4.921	1.200	1.712	0.590	0.442	0.688	3
1655501608	●	3/4 - 16 UNF	H5	4.331	1.200	1.712	0.590	0.442	0.688	3
1655501708	●	7/8 - 9 UNC	H6	5.512	1.334	1.885	0.697	0.523	0.750	3
1655501808	●	7/8 - 14 UNF	H6	4.921	1.334	1.885	0.697	0.523	0.750	3
1655501908	●	1 - 8 UNC	H6	6.299	1.500	2.090	0.800	0.600	0.813	3
1655502008	●	1 - 12 UNF	H6	5.512	1.500	2.090	0.800	0.600	0.813	3

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details



P					M			K	N		S	H				
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel			
Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium				
Low	Medium	High														
1010	1035	1065	4140	Die Steel	300	400	17-4 PH	6061	Casting	Inconel	6Al4V	~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC	
1018	1045		4340					7075			(30 HRC)					
⊙	⊙	⊙	⊙	○	⊙	⊙	⊙	○	○			⊙				
100-200 SFM	100-200 SFM	100-200 SFM	50-120 SFM	45-110 SFM	40-120 SFM	40-120 SFM	40-100 SFM	80-160 SFM	90-220 SFM	90-220 SFM		60-120 SFM				

○ Good ○ Best



A Brand A-OIL-POT

Advanced Performance Taps for a Variety of Materials

List 16550

A BRAND A-OIL-POT, DIN Overall Length



EDP		Thread Size	Thread Limit	Overall Length	Thread Length	Neck Length	Shank Diameter	Square Width	Square Length	Number of Flutes
				L (mm)	Lc (mm)	L1 (mm)	d (mm)	k (mm)	lk (mm)	
1655000108	●	M6 x 0.75	D4	80.00	12.00	30.00	6.48	4.85	7.94	3
1655000208	●	M6 x 1	D5	80.00	12.00	30.00	6.48	4.85	7.94	3
1655000308	●	M7 x 1	D5	80.00	12.00	30.00	8.08	6.05	9.53	3
1655000408	●	M8 x 0.75	D4	80.00	15.00	30.00	8.08	6.05	9.53	3
1655000508	●	M8 x 1	D5	90.00	15.00	35.00	8.08	6.05	9.53	3
1655000608	●	M8 x 1.25	D5	90.00	15.00	35.00	8.08	6.05	9.53	3
1655000708	●	M9 x 1.25	D5	90.00	15.00	35.00	9.68	7.26	11.11	3
1655000808	●	M10 x 1	D5	90.00	18.00	35.00	9.68	7.26	11.11	3
1655000908	●	M10 x 1.25	D5	100.00	18.00	39.00	9.68	7.26	11.11	3
1655001008	●	M10 x 1.5	D6	100.00	18.00	39.00	9.68	7.26	11.11	3
1655001108	●	M11 x 1.5	D5	100.00	18.00	29.00	8.20	6.15	10.32	3
1655001208	●	M12 x 1	D5	100.00	21.00	32.00	9.32	6.99	11.11	3
1655001308	●	M12 x 1.25	D6	100.00	21.00	32.00	9.32	6.99	11.11	3
1655001408	●	M12 x 1.5	D6	100.00	21.00	32.00	9.32	6.99	11.11	3
1655001508	●	M12 x 1.75	D6	110.00	21.00	32.00	9.32	6.99	11.11	3
1655001608	●	M14 x 1.5	D6	100.00	24.00	36.00	10.90	8.18	12.70	4
1655001708	●	M14 x 2	D7	110.00	24.00	36.00	10.90	8.18	12.70	3
1655001808	●	M15 x 1.5	D6	100.00	24.00	36.00	12.19	9.14	14.29	4
1655001908	●	M16 x 1.5	D6	100.00	24.00	36.00	12.19	9.14	14.29	4
1655002008	●	M16 x 2	D7	110.00	24.00	36.00	12.19	9.14	14.29	3
1655002108	●	M17 x 1.5	D6	100.00	24.00	36.00	13.77	10.31	15.88	4
1655002208	●	M18 x 1.5	D6	110.00	30.00	43.00	13.77	10.31	15.88	4
1655002308	●	M18 x 2.5	D7	125.00	30.00	43.00	13.77	10.31	15.88	3
1655002408	●	M20 x 1.5	D6	125.00	30.00	44.00	16.56	12.42	17.46	4
1655002508	●	M20 x 2.5	D7	140.00	30.00	44.00	16.56	12.42	17.46	3
1655002608	●	M22 x 1.5	D6	125.00	30.00	44.00	17.70	13.28	19.05	4
1655002708	●	M22 x 2	D7	140.00	30.00	44.00	17.70	13.28	19.05	4
1655002808	●	M22 x 2.5	D7	140.00	30.00	44.00	17.70	13.28	19.05	3
1655002908	●	M24 x 1.5	D6	140.00	36.00	51.00	19.30	14.48	19.05	4
1655003008	●	M24 x 2	D7	140.00	36.00	51.00	19.30	14.48	19.05	4
1655003108	●	M24 x 3	D8	160.00	36.00	51.00	19.30	14.48	19.05	3

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details



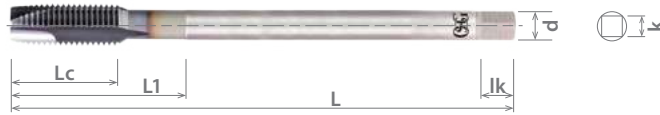
P					M			K	N		S	H					
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel				
Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium					
Low	Medium	High							1010 1018	1035 1045	1065	4140 4340	300	400	17-4 PH	6061 7075	Casting
⊙	⊙	⊙	⊙	○	⊙	⊙	⊙	○	○	○			⊙				
100-200 SFM	100-200 SFM	100-200 SFM	50-120 SFM	45-110 SFM	40-120 SFM	40-120 SFM	40-100 SFM	80-160 SFM	90-220 SFM	90-220 SFM			60-120 SFM				

○ Good ○ Best



List 16535

A BRAND A-LT-POT, Long Shank



EDP		Thread Size	Thread Limit	Overall Length	Thread Length	Neck Length	Shank Diameter	Square Width	Square Length	Number of Flutes
				L (Inch)	Lc (Inch)	L1 (Inch)	d (Inch)	k (Inch)	lk (Inch)	
1653506008	●	No. 4 - 40 UNC	H2	3.149	0.342	0.751	0.141	0.110	0.188	2
1653506108	●	No. 4 - 48 UNF	H2	3.149	0.342	0.751	0.141	0.110	0.188	2
1653500708	●	No. 5 - 40 UNC	H2	3.937	0.350	0.759	0.141	0.110	0.188	3
1653506308	●	No. 5 - 44 UNF	H2	3.937	0.350	0.759	0.141	0.110	0.188	3
1653501008	●	No. 6 - 32 UNC	H3	4.724	0.429	0.842	0.141	0.110	0.188	3
1653501108	●	No. 6 - 40 UNF	H2	3.937	0.433	0.846	0.141	0.110	0.188	3
1653501308	●	No. 8 - 32 UNC	H3	4.724	0.444	0.897	0.168	0.131	0.250	3
1653501408	●	No. 8 - 36 UNF	H2	3.937	0.444	0.897	0.168	0.131	0.250	3
1653501508	●	No. 10 - 24 UNC	H3	4.921	0.574	1.059	0.194	0.152	0.250	3
1653501708	●	No. 10 - 32 UNF	H3	5.906	0.582	1.066	0.194	0.152	0.250	3
1653501808	●	No. 12 - 24 UNC	H3	4.921	0.590	1.271	0.220	0.165	0.280	3
1653501908	●	No. 12 - 28 UNF	H3	4.921	0.590	1.271	0.220	0.165	0.280	3
1653502108	●	1/4 - 20 UNC	H5	5.906	0.704	1.366	0.255	0.191	0.287	3
1653502308	●	1/4 - 28 UNF	H4	5.906	0.704	1.366	0.255	0.191	0.287	3
1653502508	●	5/16 - 18 UNC	H5	5.906	0.803	1.633	0.318	0.238	0.343	3
1653502708	●	5/16 - 24 UNF	H4	5.906	0.803	1.633	0.318	0.238	0.343	3
1653502908	●	3/8 - 16 UNC	H5	5.906	0.917	1.897	0.381	0.286	0.398	3
1653503108	●	3/8 - 24 UNF	H4	5.906	0.929	1.897	0.381	0.286	0.398	3
1653503308	●	7/16 - 14 UNC	H5	5.906	0.858	2.362	0.323	0.242	0.406	3
1653503508	●	7/16 - 20 UNF	H5	5.906	0.858	2.362	0.323	0.242	0.406	3
1653503708	●	1/2 - 13 UNC	H5	7.087	0.921	2.834	0.367	0.275	0.438	3
1653503908	●	1/2 - 20 UNF	H5	7.087	0.921	2.834	0.367	0.275	0.438	3
1653504108	●	9/16 - 12 UNC	H5	7.087	1.000	2.834	0.429	0.322	0.500	3
1653504308	●	9/16 - 18 UNF	H5	7.087	1.000	2.834	0.429	0.322	0.500	3
1653504508	●	5/8 - 11 UNC	H5	7.087	1.090	2.834	0.480	0.360	0.563	3
1653504708	●	5/8 - 18 UNF	H5	7.087	1.090	2.834	0.480	0.360	0.563	3
1653504908	●	3/4 - 10 UNC	H5	7.874	1.200	3.149	0.590	0.442	0.688	3
1653505108	●	3/4 - 16 UNF	H5	7.874	1.200	3.149	0.590	0.442	0.688	3
1653505308	●	7/8 - 9 UNC	H6	7.874	1.334	3.149	0.697	0.523	0.750	3
1653505508	●	7/8 - 14 UNF	H6	7.874	1.334	3.149	0.697	0.523	0.750	3
1653505708	●	1 - 8 UNC	H6	7.874	1.500	3.149	0.800	0.600	0.813	3
1653505908	●	1 - 12 UNF	H6	7.874	1.500	3.149	0.800	0.600	0.813	3

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details

ATP

P					M			K	N		S	H				
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel			
Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium				
Low	Medium	High							6061	Casting	Inconel	6Al4V (30 HRC)				
1010	1035	1065	4140	Die Steel	300	400	17-4 PH	○	6061	Casting	Inconel	6Al4V (30 HRC)	~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC
1018	1045	1065	4340		7075											
○	○	○	○	○	○	○	○	○	○			○				
80-120 SFM	80-120 SFM	80-120 SFM	40-65 SFM	35-55 SFM	25-75 SFM	25-60 SFM	25-60 SFM	60-100 SFM	70-120 SFM	70-120 SFM			40-65 SFM			

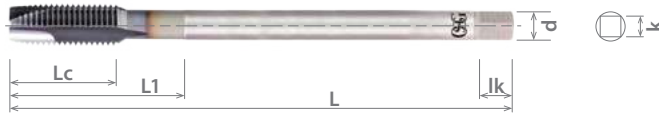
○ Good ○ Best

A Brand A-LT-POT

Advanced Performance Taps for a Variety of Materials

List 16530

A BRAND A-LT-POT, Long Shank



EDP		Thread Size	Thread Limit	Overall Length	Thread Length	Neck Length	Shank Diameter	Square Width	Square Length	Number of Flutes
				L (mm)	Lc (mm)	L1 (mm)	d (mm)	k (mm)	lk (mm)	
1653001208	●	M3 x 0.35	D3	100.00	6.00	20.00	3.58	2.79	4.76	3
1653001308	●	M3 x 0.5	D3	100.00	6.00	20.00	3.58	2.79	4.76	3
1653001408	●	M3.5 x 0.35	D3	100.00	7.00	23.00	3.58	2.79	4.76	3
1653001508	●	M3.5 x 0.6	D3	100.00	7.00	23.00	3.58	2.79	4.76	3
1653001608	●	M4 x 0.5	D3	100.00	8.00	27.00	4.27	3.33	6.35	3
1653001708	●	M4 x 0.7	D4	100.00	8.00	27.00	4.27	3.33	6.35	3
1653001808	●	M4.5 x 0.5	D4	100.00	9.00	30.00	4.93	3.86	6.35	3
1653001908	●	M4.5 x 0.75	D4	100.00	9.00	30.00	4.93	3.86	6.35	3
1653002008	●	M5 x 0.5	D3	125.00	9.00	32.90	4.93	3.86	6.35	3
1653002108	●	M5 x 0.8	D4	125.00	9.00	32.90	4.93	3.86	6.35	3
1653002208	●	M5.5 x 0.5	D3	125.00	10.00	35.90	5.59	4.19	7.14	3
1653002308	●	M6 x 0.5	D3	125.00	11.00	40.00	6.48	4.85	7.94	3
1653002508	●	M6 x 0.75	D4	150.00	11.00	40.00	6.48	4.85	7.94	3
1653002708	●	M6 x 1	D5	150.00	11.00	40.00	6.48	4.85	7.94	3
1653003308	●	M8 x 0.75	D4	150.00	15.00	51.90	8.08	6.05	9.53	3
1653003508	●	M8 x 1	D5	150.00	15.00	51.90	8.08	6.05	9.53	3
1653003708	●	M8 x 1.25	D5	150.00	15.00	51.90	8.08	6.05	9.53	3
1653004508	●	M10 x 0.75	D4	150.00	18.00	59.90	9.68	7.26	11.11	3
1653004708	●	M10 x 1	D5	150.00	18.00	59.90	9.68	7.26	11.11	3
1653004908	●	M10 x 1.25	D5	150.00	18.00	59.90	9.68	7.26	11.11	3
1653005108	●	M10 x 1.5	D6	150.00	18.00	59.90	9.68	7.26	11.11	3
1653006108	●	M12 x 1	D5	180.00	21.00	72.00	9.32	6.99	11.11	3
1653006308	●	M12 x 1.25	D6	180.00	21.00	72.00	9.32	6.99	11.11	3
1653006508	●	M12 x 1.5	D6	180.00	21.00	72.00	9.32	6.99	11.11	3
1653006708	●	M12 x 1.75	D6	180.00	21.00	72.00	9.32	6.99	11.11	3
1653006808	●	M14 x 1	D5	150.00	24.00	59.90	10.90	8.18	12.70	4
1653006908	●	M14 x 1.25	D6	150.00	24.00	59.90	10.90	8.18	12.70	4
1653007008	●	M14 x 1.5	D6	150.00	24.00	59.90	10.90	8.18	12.70	4
1653007108	●	M14 x 2	D7	150.00	24.00	59.90	10.90	8.18	12.70	3
1653007208	●	M15 x 1	D5	160.00	24.00	64.00	12.19	9.14	14.29	4
1653007308	●	M15 x 1.5	D6	160.00	24.00	64.00	12.19	9.14	14.29	4
1653007408	●	M16 x 1	D4	160.00	24.00	64.00	12.19	9.14	14.29	3
1653007508	●	M16 x 1.5	D6	160.00	24.00	64.00	12.19	9.14	14.29	3
1653007708	●	M16 x 2	D7	160.00	24.00	72.00	12.19	9.14	14.29	3
1653008008	●	M18 x 1	D5	180.00	29.00	72.00	13.77	10.31	15.88	4
1653008108	●	M18 x 1.5	D6	180.00	29.00	72.00	13.77	10.31	15.88	4
1653008208	●	M18 x 2	D7	180.00	29.00	72.00	13.77	10.31	15.88	4
1653008308	●	M18 x 2.5	D7	180.00	29.00	72.00	13.77	10.31	15.88	3
1653008408	●	M20 x 1	D5	200.00	29.00	80.00	16.56	12.42	17.46	4
1653008508	●	M20 x 1.5	D6	200.00	29.00	80.00	16.56	12.42	17.46	4
1653008608	●	M20 x 2	D7	200.00	29.00	80.00	16.56	12.42	17.46	4
1653008708	●	M20 x 2.5	D7	200.00	29.00	80.00	16.56	12.42	17.46	3
1653008808	●	M22 x 1	D5	200.00	29.00	80.00	17.70	13.28	19.05	4
1653008908	●	M22 x 1.5	D6	200.00	29.00	80.00	17.70	13.28	19.05	4
1653009008	●	M22 x 2	D7	200.00	29.00	80.00	17.70	13.28	19.05	4
1653009108	●	M22 x 2.5	D7	200.00	29.00	80.00	17.70	13.28	19.05	3

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details



List 16530 (Continued)

A BRAND A-LT-POT, Long Shank



EDP		Thread Size	Thread Limit	Overall Length	Thread Length	Neck Length	Shank Diameter	Square Width	Square Length	Number of Flutes
				L (mm)	Lc (mm)	L1 (mm)	d (mm)	k (mm)	lk (mm)	
1653009208	●	M24 x 1	D5	200.00	35.00	80.00	19.30	14.48	19.05	4
1653009308	●	M24 x 1.5	D6	200.00	35.00	80.00	19.30	14.48	19.05	4
1653009408	●	M24 x 2	D7	200.00	35.00	80.00	19.30	14.48	19.05	4
1653009508	●	M24 x 3	D8	200.00	35.00	80.00	19.30	14.48	19.05	3

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details



P					M			K	N		S	H				
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel			
Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium				
Low	Medium	High							6061 7075	Casting	Inconel	6Al4V (30 HRC)				
1010	1035	1065	4140	Die Steel	300	400	17-4 PH	○	○	○			~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC
1018	1045	1065	4340		○	○	○		○	○	○			○		
80-120 SFM	80-120 SFM	80-120 SFM	40-65 SFM	35-55 SFM	25-75 SFM	25-60 SFM	25-60 SFM	60-100 SFM	70-120 SFM	70-120 SFM			40-65 SFM			

○ Good ○ Best



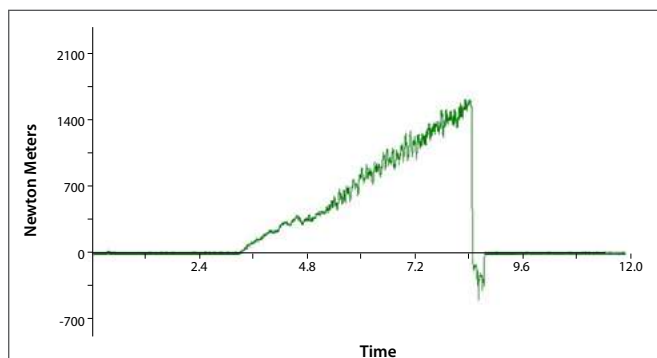
A Brand A-Pipe

Features & Benefits

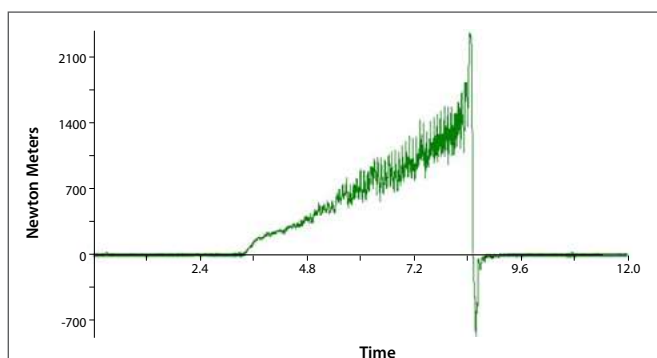
Stabilized Cutting Torque

Comparison

The A Brand A-NPT tap demonstrates more consistent torque while producing threads than the competitor, resulting in better tool life and thread quality.



A-NPT



Competitor

Interrupted Thread

for reduced cutting torque

Variable Lead Flute

accelerates chip evacuation

Enhanced Cutting Geometry

to eliminate galling

V Coating

for exceptional wear resistance

HSSE Substrate

for high wear resistance and toughness

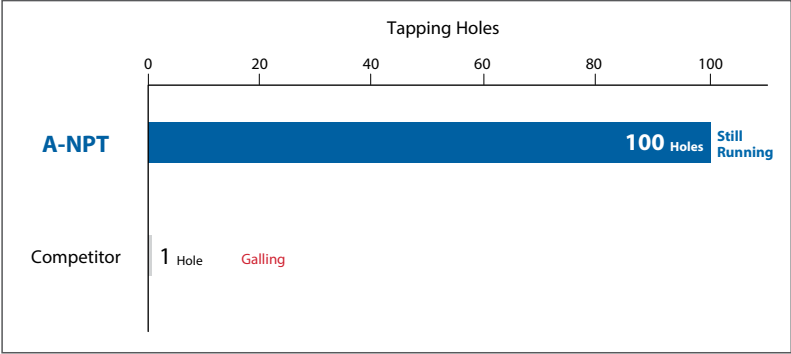


Processing with Taper Pipe Taps

A36 Steel

The A-Pipe taps are able to achieve stable performance beyond 100 holes while the competitor’s tool failed to successfully process a single hole.

Tool	A-NPT	Competitor
Tool Size	PT 1/8-28 2.5P	
Work Material	A36 Steel	
Pre-Drilled Hole	Ø0.32" x 0.62" (Through)	
Gage Plane	0.51"	
Cutting Speed	23 SFM (272 RPM)	
Coolant	Water-soluble Chlorine-Free (10%)	
Machine	Horizontal Machining Center	



Minimal Wear in Multiple Materials

A36 Steel • Cast Iron • 304 Stainless Steel

The A-NPT showed minimal wear and can continue to be used even after successfully tapping 100 holes in various work materials.

Tool	A-NPT		
Tool Size	PT 1/8-28 2.5P		
Work Material	A36 Steel	Cast Iron	304 Stainless Steel
Pre-Drilled Hole	Ø0.32" x 0.62" (Through)		
Gage Plane	0.51"		
Cutting Speed	16 SFM (190 RPM)		
Coolant	Water-soluble Chlorine-Free (10%)		
Machine	Vertical Machining Center		



A36 Steel



Cast Iron



304 Stainless Steel

List 16570

A BRAND A-NPT, Interrupted Thread



EDP		Thread Size	Overall Length	Thread Length	Neck Length	Shank Diameter	Square Width	Square Length	Number of Flutes
			L (Inch)	Lc (Inch)	L1 (Inch)	d (Inch)	k (Inch)	lk (Inch)	
1657001008	●	1/16 - 27 NPT	3.543	0.689	1.417	0.313	0.234	0.375	3
1657002008	●	1/8 - 27 NPT	3.543	0.752	1.457	0.313	0.234	0.375	3
1657003008	●	1/8 - 27 NPT	3.543	0.752	1.457	0.438	0.328	0.375	3
1657004008	●	1/4 - 18 NPT	3.937	1.063	1.929	0.563	0.421	0.438	3
1657005008	●	3/8 - 18 NPT	3.937	1.063	1.969	0.700	0.531	0.500	4
1657006008	●	1/2 - 14 NPT	4.921	1.374	2.362	0.688	0.515	0.625	4
1657007008	●	3/4 - 14 NPT	5.511	1.374	2.913	0.906	0.679	0.688	4
1657008008	●	1 - 11.5 NPT	6.299	1.752	3.150	1.125	0.843	0.813	4

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details



P					M			K	N		S		H			
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel			
Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium				
Low	Medium	High							6061 7075	Casting						
1010	1035	1065	4140	Die Steel	300	400	17-4 PH		6061 7075				~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC
1018	1045	1065	4340													
○	○	○	○	○	○	○		○		○		○	○			
5-35 SFM	5-35 SFM	5-35 SFM	5-20 SFM	5-20 SFM	5-20 SFM	5-20 SFM		5-20 SFM		5-35 SFM		5-10 SFM	5-20 SFM			

○ Good ○ Best



A Brand A-Pipe

Advanced Performance Pipe Taps

List 16575

A BRAND A-LT-NPT, Long Shank, NPT, Interrupted Thread



EDP		Thread Size	Overall Length	Thread Length	Neck Length	Shank Diameter	Square Width	Square Length	Number of Flutes
			L (Inch)	Lc (Inch)	L1 (Inch)	d (Inch)	k (Inch)	lk (Inch)	
1657501008	●	1/16 - 27 NPT	4.000	0.689	1.614	0.313	0.234	0.375	3
1657502008	●	1/16 - 27 NPT	6.000	0.689	2.402	0.313	0.234	0.375	3
1657503008	●	1/8 - 27 NPT	4.000	0.752	1.614	0.313	0.234	0.375	3
1657504008	●	1/8 - 27 NPT	6.000	0.752	2.402	0.313	0.234	0.375	3
1657505008	●	1/8 - 27 NPT	4.000	0.752	1.614	0.438	0.328	0.375	3
1657506008	●	1/8 - 27 NPT	6.000	0.752	2.402	0.438	0.328	0.375	3
1657507008	●	1/4 - 18 NPT	4.000	1.063	1.929	0.563	0.421	0.438	3
1657508008	●	1/4 - 18 NPT	6.000	1.063	2.402	0.563	0.421	0.438	3
1657509008	●	3/8 - 18 NPT	4.000	1.063	1.969	0.700	0.531	0.500	4
1657510008	●	3/8 - 18 NPT	6.000	1.063	2.402	0.700	0.531	0.500	4
1657511008	●	1/2 - 14 NPT	4.000	1.374	2.362	0.688	0.515	0.625	4
1657512008	●	1/2 - 14 NPT	6.000	1.374	2.402	0.688	0.515	0.625	4
1657513008	●	3/4 - 14 NPT	4.000	1.374	2.504	0.906	0.679	0.688	4
1657514008	●	3/4 - 14 NPT	6.000	1.374	2.913	0.906	0.679	0.688	4
1657515008	●	1 - 11.5 NPT	4.000	1.752	2.504	1.125	0.843	0.813	4
1657516008	●	1 - 11.5 NPT	6.000	1.752	3.150	1.125	0.843	0.813	4

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details

ATP

P					M			K	N		S		H			
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel			
Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium				
Low	Medium	High							6061 7075	Casting						
1010 1018	1035 1045	1065	4140 4340	Die Steel	300	400	17-4 PH				Inconel	6Al4V (30 HRC)	~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC
○	○	○	○		○	○		○				○	○			
5-35 SFM	5-35 SFM	5-35 SFM	5-20 SFM	5-20 SFM	5-20 SFM	5-20 SFM		5-20 SFM		5-35 SFM		5-10 SFM	5-20 SFM			

○ Good ○ Best



List 16590

A BRAND A-NPS



EDP		Thread Size	Overall Length	Thread Length	Neck Length	Shank Diameter	Square Width	Square Length	Number of Flutes
			L (Inch)	Lc (Inch)	L1 (Inch)	d (Inch)	k (Inch)	lk (Inch)	
1659001008	●	1/16 - 27 NPS	3.543	0.551	1.417	0.313	0.234	0.375	3
1659002008	●	1/8 - 27 NPS	3.543	0.551	1.457	0.313	0.234	0.375	3
1659003008	●	1/8 - 27 NPS	3.543	0.551	1.457	0.438	0.328	0.375	3
1659004008	●	1/4 - 18 NPS	3.937	0.748	1.929	0.563	0.421	0.438	3
1659005008	●	3/8 - 18 NPS	3.937	0.827	1.969	0.700	0.531	0.500	4
1659006008	●	1/2 - 14 NPS	4.921	1.024	2.362	0.688	0.515	0.625	4
1659007008	●	3/4 - 14 NPS	5.511	1.102	2.913	0.906	0.679	0.688	4
1659008008	●	1 - 11.5 NPS	6.299	1.299	3.150	1.125	0.843	0.813	4

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details



P					M			K	N		S		H			
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel			
Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium				
Low	Medium	High							6061 7075	Casting	Inconel	6Al4V (30 HRC)				
1010	1035	1065	4140	Die Steel	300	400	17-4 PH						~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC
1018	1045		4340													
⊙	⊙	⊙	⊙	○	○	○		○		⊙		○	⊙			
5-35 SFM	5-35 SFM	5-35 SFM	5-20 SFM	5-20 SFM	5-20 SFM	5-20 SFM		5-20 SFM		5-35 SFM		5-10 SFM	5-20 SFM			

○ Good ○ Best



A Brand A-Pipe

Advanced Performance Pipe Taps

List 16585

A BRAND A-BSPT, Interrupted Thread



EDP		Thread Size	Overall Length	Thread Length	Neck Length	Shank Diameter	Square Width	Square Length	Number of Flutes
			L (Inch)	Lc (Inch)	L1 (Inch)	d (Inch)	k (Inch)	lk (Inch)	
1658501008	●	1/8 - 28 BSPT	3.543	0.591	1.457	0.313	0.234	0.375	3
1658502008	●	1/4 - 19 BSPT	3.937	0.748	1.929	0.563	0.421	0.438	3
1658503008	●	3/8 - 19 BSPT	3.937	0.827	1.969	0.700	0.531	0.500	4
1658504008	●	1/2 - 14 BSPT	4.921	1.024	2.362	0.688	0.515	0.625	4
1658505008	●	3/4 - 14 BSPT	5.511	1.102	2.913	0.906	0.679	0.688	4
1658506008	●	1 - 11 BSPT	6.299	1.299	3.150	1.125	0.843	0.813	4

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details

ATP

P					M			K	N		S		H			
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel			
Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium				
Low	Medium	High							6061 7075	Casting						
1010	1035	1065	4140	Die Steel	300	400	17-4 PH	○					~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC
1018	1045		4340													
○	○	○	○	○	○					○			○	○		
5-35 SFM	5-35 SFM	5-35 SFM	5-20 SFM	5-20 SFM	5-20 SFM	5-20 SFM		5-20 SFM		5-35 SFM		5-10 SFM	5-20 SFM			

○ Good ○ Best



List 16580

A BRAND A-BSPP-RP, Made to RP Spec.



EDP		Thread Size	Overall Length	Thread Length	Neck Length	Shank Diameter	Square Width	Square Length	Number of Flutes
			L (Inch)	Lc (Inch)	L1 (Inch)	d (Inch)	k (Inch)	lk (Inch)	
1658001008	●	1/8 - 28 BSPP	3.543	0.591	1.457	0.313	0.234	0.375	3
1658002008	●	1/4 - 19 BSPP	3.937	0.748	1.929	0.563	0.421	0.438	3
1658003008	●	3/8 - 19 BSPP	3.937	0.827	1.969	0.700	0.531	0.500	4
1658004008	●	1/2 - 14 BSPP	4.921	1.024	2.362	0.688	0.515	0.625	4
1658005008	●	3/4 - 14 BSPP	5.511	1.102	2.913	0.906	0.679	0.688	4
1658006008	●	1 - 11 BSPP	6.299	1.299	3.150	1.125	0.843	0.813	4

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details

Note: A Brand A-BSPP-RP is made to a ISO-7 R(p) standards - cylindrical female with internal threads rather than ISO 228, therefore the pitch diameter tolerance of ISO-7 extends lower than that of ISO 228 which can lead to tight or non-gaging fit. Please contact our customer service department should you require assistance.



P					M			K	N		S	H				
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel			
Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium				
Low	Medium	High							6061	Casting	Inconel	6Al4V (30 HRC)				
1010	1035	1065	4140	Die Steel	300	400	17-4 PH		6061 7075				~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC
1018	1045		4340													
○	○	○	○	○	○	○		○		○		○	○			
5-35 SFM	5-35 SFM	5-35 SFM	5-20 SFM	5-20 SFM	5-20 SFM	5-20 SFM		5-20 SFM		5-35 SFM		5-10 SFM	5-20 SFM			

○ Good ○ Best



A Brand A-Pipe

Advanced Performance Pipe Taps

List 16581

A BRAND A-BSPP-G, Made to G Spec.



EDP		Thread Size	Overall Length	Thread Length	Neck Length	Shank Diameter	Square Width	Square Length	Number of Flutes
			L (Inch)	Lc (Inch)	L1 (Inch)	d (Inch)	k (Inch)	lk (Inch)	
1658101008	●	1/8 - 28 BSPP	3.543	0.591	1.457	0.313	0.234	0.375	3
1658102008	●	1/4 - 19 BSPP	3.937	0.748	1.929	0.563	0.421	0.438	3
1658103008	●	3/8 - 19 BSPP	3.937	0.827	1.969	0.700	0.531	0.500	4
1658104008	●	1/2 - 14 BSPP	4.921	1.024	2.362	0.688	0.515	0.625	4
1658105008	●	3/4 - 14 BSPP	5.511	1.102	2.913	0.906	0.679	0.688	4
1658106008	●	1 - 11 BSPP	6.299	1.299	3.150	1.125	0.843	0.813	4

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details

Note: A Brand A-BSPP-G is made to ISO 228 standard.

ATP

P					M			K	N		S		H			
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel			
Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium				
Low	Medium	High							6061 7075	Casting						
1010 1018	1035 1045	1065	4140 4340		300	400	17-4 PH						~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC
○	○	○	○		○	○		○		○		○		○		
5-35 SFM	5-35 SFM	5-35 SFM	5-20 SFM	5-20 SFM	5-20 SFM	5-20 SFM		5-20 SFM		5-35 SFM		5-10 SFM	5-20 SFM			

○ Good ○ Best



List 16571

A BRAND A-NPTF, Interrupted Thread



EDP		Thread Size	Overall Length	Thread Length	Neck Length	Shank Diameter	Square Width	Square Length	Number of Flutes
			L (Inch)	Lc (Inch)	L1 (Inch)	d (Inch)	k (Inch)	lk (Inch)	
1657101008	●	1/16 - 27 NPT	3.543	0.689	1.417	0.313	0.234	0.375	3
1657102008	●	1/8 - 27 NPT	3.543	0.752	1.457	0.313	0.234	0.375	3
1657103008	●	1/8 - 27 NPT	3.543	0.752	1.457	0.438	0.328	0.375	3
1657104008	●	1/4 - 18 NPT	3.937	1.063	1.929	0.563	0.421	0.438	3
1657105008	●	3/8 - 18 NPT	3.937	1.063	1.969	0.700	0.531	0.500	4
1657106008	●	1/2 - 14 NPT	4.921	1.374	2.362	0.688	0.515	0.625	4
1657107008	●	3/4 - 14 NPT	5.511	1.374	2.913	0.906	0.679	0.688	4
1657108008	●	1 - 11.5 NPT	6.299	1.752	3.150	1.125	0.843	0.813	4

● Stocked ▲ Globally Stocked ○ Made to Order; contact an OSG representative for details



P					M			K	N		S	H				
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel			
Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium				
Low	Medium	High							4140 4340	300	400	17-4 PH	6061 7075	Casting	Inconel	6Al4V (30 HRC)
1010 1018	1035 1045	1065	4140 4340		300	400	17-4 PH									
○	○	○	○	○	○	○		○		○			○			
5-35 SFM	5-35 SFM	5-35 SFM	5-20 SFM	5-20 SFM	5-20 SFM	5-20 SFM		5-20 SFM		5-35 SFM		5-10 SFM	5-20 SFM			

○ Good ○ Best





shaping your dreams

 Safe use of cutting tools

- Use safety cover, safety glasses and safety shoes during operation.
- Do not touch cutting edges with bare hands.
- Do not touch cutting chips with bare hands. Chips will be hot after cutting.
- Stop cutting when the tool becomes dull.
- Stop cutting operation immediately if you hear any abnormal cutting sounds.
- Do not modify tools.
- Please use appropriate tools for the operation. Check dimensions to ensure proper selection.

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