



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

VP(O)-DC-MT SERIES

Volume 2



KEY FEATURE: VP(O)-DC-MT SERIES



1 Synchro taps when speed can be > 30 m/min

2 Highly wear resistant powder metal substrate

3 Straight flute, high rigidity

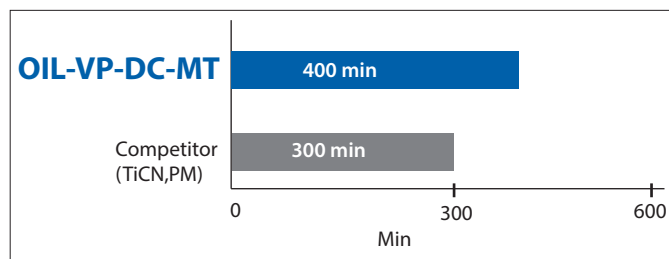
4 Also available with oil hole

PERFORMANCE

■ GGG40 Emulsion

Tool	OIL-VP-DC-MT (M16x1,5)
Tapping Length	26 mm (Blind & Through holes)
Tapping Speed	40 m/min (800U/min)
Coolant	Emulsion
Machine	Vertical Machining Center

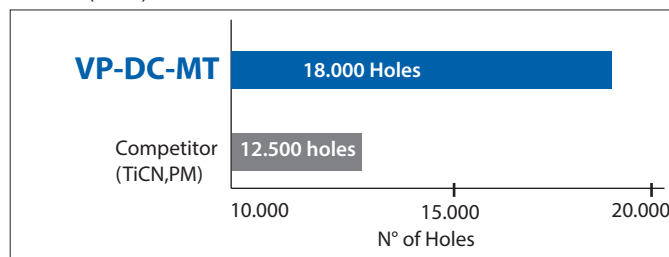
Tool Life



■ GG25 Dry Tapping

Tool	VP-DC-MT (M10x1,5)
Tapping Length	18 mm
Tapping Speed	49 m/min (1.560U/min)
Coolant	Dry
Machine	Vertical Machining Center

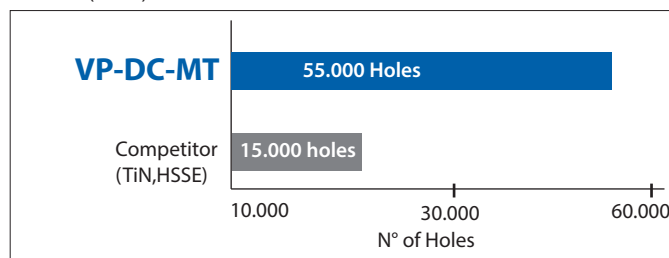
Tool Life (holes)



■ ADC Emulsion

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

Tool Life (holes)

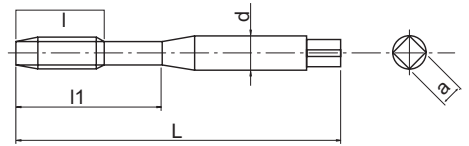


VP-DC-MT NEW SIZES

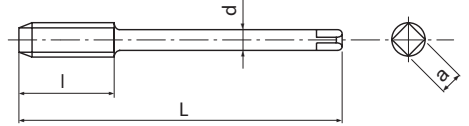
Threading | Cutting taps | Metric



Type 1



Type 2



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

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

M	PM	V	ISO 2 6HX				DIN 371	DIN 376
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EDP	M	P	L	l	l1	d	a	Z	Type	DIN	Price
48020125 <small>NEW</small>	2	0,4	45			2,8	2,1	3	1	DIN371	
48020133 <small>NEW</small>	2,5	0,45	50	12	30	7	5,5	3	1	DIN371	
48020138	3	0,5	56	-	18	3,5	2,7	3	1	DIN371	
48020142 <small>NEW</small>	3,5	0,6	56	18	-	8	6,2	4	2	DIN371	
48020144	4	0,7	63	-	21	4,5	3,4	3	1	DIN371	
48020149	5	0,8	70	-	25	6	4,9	3	1	DIN371	
48020155	6	1	80	-	30	6	4,9	3	1	DIN371	
48020158 <small>NEW</small>	7	1	80	30	-	18	14,5	5	2	DIN371	
48020161	8	1,25	90	-	35	8	6,2	4	1	DIN371	
48020169	10	1,5	100	-	39	10	8	4	1	DIN371	
48020175 <small>NEW</small>	11	1,5	100	36	-	18	14,5	5	1	DIN371	
48020179	12	1,75	110	21	-	9	7	4	2	DIN376	
48022191	14	2	110	24	-	11	9	4	2	DIN376	
48022202	16	2	110	24	-	12	9	4	2	DIN376	
48022214	18	2,5	125	30	-	14	11	4	2	DIN376	
48022228	20	2,5	140	30	-	16	12	4	2	DIN376	
48020238 <small>NEW</small>	22	2,5	140	42	-	22	18	6	2	DIN376	
48020247 <small>NEW</small>	24	3	160	-	-	-	-	-	2	DIN376	
48020271 <small>NEW</small>	30	3,5	180	-	-	-	-	-	2	DIN376	

Threading | Cutting taps

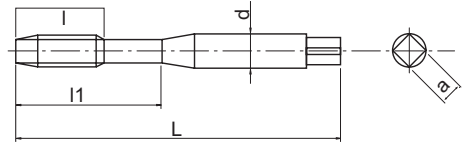
Metric

VP-DC-MT FORM E NEW SIZES

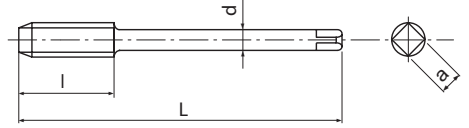
Threading | Cutting taps | Metric



Type 1



Type 2



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

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

M	PM	V	ISO 2 6HX						
				E/1,5	≥2D		DIN 371	DIN 376	

EDP	M	P	L	l	l1	d	a	Z	Type	DIN	Price
48037138	3	0,5	56	-	18	3,5	2,7	3	1	DIN371	
48037144	4	0,7	63	-	21	4,5	3,4	3	1	DIN371	
48037149	5	0,8	70	-	25	6	4,9	3	1	DIN371	
48037155	6	1	80	-	30	6	4,9	3	1	DIN371	
48037161	8	1,25	90	-	35	8	6,2	4	1	DIN371	
48037169	10	1,5	100	-	39	10	8	4	1	DIN371	
48037179	12	1,75	110	21	-	9	7	4	2	DIN376	
48037191	14	2	110	24	-	11	9	4	2	DIN376	
48037202	16	2	110	24	-	12	9	4	2	DIN376	
48037214 <small>NEW</small>	18	2,5	125	30	-	14	11	4	2	DIN376	
48037228 <small>NEW</small>	20	2,5	140	30	-	16	12	4	2	DIN376	
48037238 <small>NEW</small>	22	2,5	140	30	-	18	14,5	5	2	DIN376	
48037247 <small>NEW</small>	24	3	160	36	-	18	14,5	5	2	DIN376	

Threading | Cutting taps

Metric

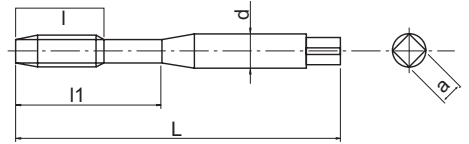


VPO-DC-MT Center NEW SIZES

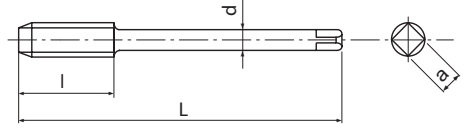
Threading | Cutting taps | Metric



Type 1



Type 2



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

Threading | Cutting taps

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

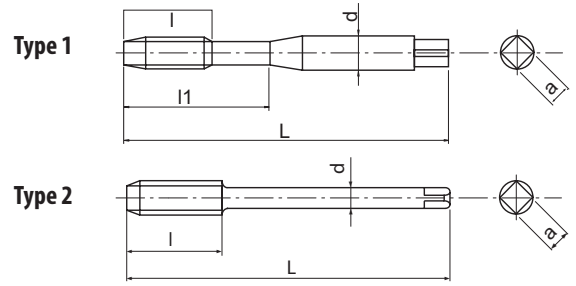
M	PM	V	ISO 2 6HX	C/2,5	≥2D		DIN 371	DIN 376
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EDP	M	P	L	l	l1	d	a	Z	Type	DIN	Price
48021155	6	1	80	-	30	6	4,9	3	1	DIN371	
48021161	8	1,25	90	-	35	8	6,2	4	1	DIN371	
48021169	10	1,5	100	-	39	10	8	4	1	DIN371	
48300179 <small>NEW</small>	12	1,75	110	28	-	9	7	3	2	DIN376	
48300191 <small>NEW</small>	14	2	110	24	-	11	9	3	2	DIN376	
48300202 <small>NEW</small>	16	2	110	24	-	12	9	3	2	DIN376	
48300214 <small>NEW</small>	18	2,5	125	30	-	14	11	4	2	DIN376	
48300228 <small>NEW</small>	20	2,5	140	30	-	16	12	4	2	DIN376	

Metric

VPO-DC-MT Side NEW SIZES

Threading | Cutting taps | Metric



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

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

M	PM	V	ISO 2 6HX	C/2,5			DIN 371	DIN 376
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EDP	M	P	L	l	l1	d	a	Z	Type	DIN	Price
48299155 <small>NEW</small>	6	1	80	8	30	6	4,9	3	1	DIN371	
48299161 <small>NEW</small>	8	1,25	90	10	35	8	6,2	4	1	DIN371	
48299169 <small>NEW</small>	10	1,5	100	12	39	10	8	4	1	DIN371	
48021179	12	1,75	110	21	-	9	7	4	2	DIN376	
48024191	14	2	110	24	-	11	9	4	2	DIN376	
48024202	16	2	110	24	-	12	9	4	2	DIN376	
48024214	18	2,5	125	30	-	14	11	4	2	DIN376	
48024228	20	2,5	140	30	-	16	12	4	2	DIN376	

Threading | Cutting taps

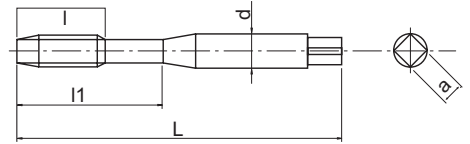


VPO-DC-MT FORM E NEW SIZES

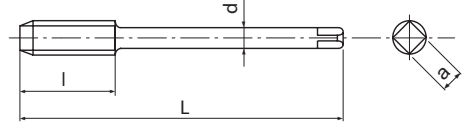
Threading | Cutting taps | Metric



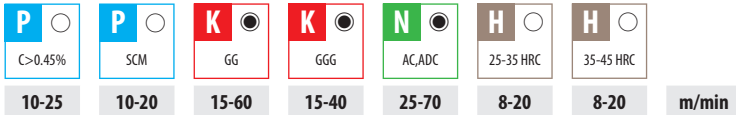
Type 1



Type 2



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

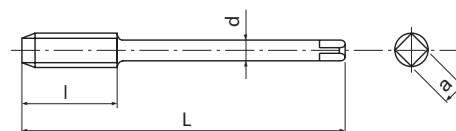


EDP	M	P	L	l	l1	d	a	Z	Type	DIN	Price
48038155	6	1	80	-	30	6	4,9	3	1	DIN371	
48038161	8	1,25	90	-	35	8	6,2	4	1	DIN371	
48038169	10	1,5	100	-	39	10	8	4	1	DIN371	
48038179	12	1,75	110	21	-	9	7	4	2	DIN376	
48038191	14	2	110	24	-	11	9	4	2	DIN376	
48038202	16	2	110	24	-	12	9	4	2	DIN376	
48038214 <small>NEW</small>	18	2,5	125	30	-	14	11	4	2	DIN376	
48038228 <small>NEW</small>	20	2,5	140	30	-	16	12	4	2	DIN376	
48038238 <small>NEW</small>	22	2,5	140	30	-	18	14,5	5	2	DIN376	
48038247 <small>NEW</small>	24	3	160	36	-	18	14,5	5	2	DIN376	

Threading | Cutting taps
Metric

VP-DC-MT

Threading | Cutting taps | Metric Fine



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

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

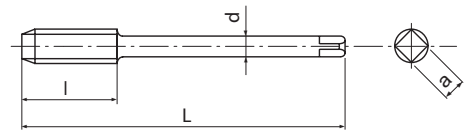
MF	PM	V	ISO 2 6HX	C/2,5			DIN 374
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EDP	MF	P	L	l	d	a	Z	DIN	Price
48023140	3	0,35	56	8	2,2	-	3	DIN374	
48023145	4	0,5	63	9	2,8	2,1	3	DIN374	
48023151	5	0,5	70	10	3,5	2,7	3	DIN374	
48023156	6	0,75	80	12	4,5	3,4	3	DIN374	
48023157	6	0,5	80	12	4,5	3,4	3	DIN374	
48023163	8	0,75	80	15	6	4,9	4	DIN374	
48023162	8	1	90	15	6	4,9	4	DIN374	
48023171	10	1	90	18	7	5,5	4	DIN374	
48023170	10	1,25	100	18	7	5,5	4	DIN374	
48023182	12	1	100	21	9	7	4	DIN374	
48023181	12	1,25	100	21	9	7	4	DIN374	
48023180	12	1,5	100	21	9	7	4	DIN374	
48023192	14	1,5	100	24	11	9	4	DIN374	
48023203	16	1,5	100	24	12	9	4	DIN374	
48023216	18	1,5	110	30	14	11	4	DIN374	
48023230	20	1,5	125	30	16	12	4	DIN374	
48023240	22	1,5	125	20	18	14,5	5	DIN374	
48023250	24	1,5	140	24	18	14,5	5	DIN374	

Threading | Cutting taps
Metric Fine

VPO-DC-MT Center NEW SIZES

Threading | Cutting taps | Metric Fine



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

Threading | Cutting taps

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

MF	PM	V	ISO 2 6HX	C/2,5	≥2D	DIN 374
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EDP	MF	P	L	l	d	a	Z	DIN	Price
48024162	8	1	90	15	6	4,9	4	DIN374	
48024171	10	1	90	18	7	5,5	4	DIN374	
48024170	10	1,25	100	18	7	5,5	4	DIN374	
48300181	12	1,25	100	21	9	7	4	DIN374	
48300180	12	1,5	100	21	9	7	4	DIN374	
48300192	14	1,5	100	24	11	9	4	DIN374	
48300203	16	1,5	100	24	12	9	4	DIN374	
48300216	18	1,5	110	30	14	11	4	DIN374	
48300230	20	1,5	125	30	16	12	4	DIN374	

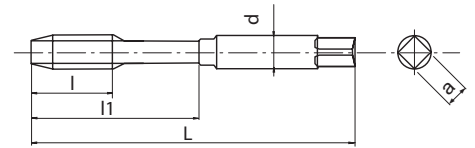
Metric Fine

VP-DC-MT NEW

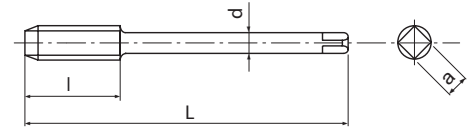
Threading | Cutting taps | UNC



Type 1



Type 2



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

Threading | Cutting taps

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

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

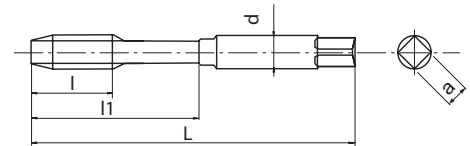
EDP	UNC	P	L	l	l1	d	a	Z	Type	DIN	Price
48020453	2	56	45	9		2,8	2,1	3	1	DIN2184-1	
48020455	3	48	50	9		2,8	2,1	3	1	DIN2184-1	
48020457	4	40	56	8	18	3,5	2,7	3	1	DIN2184-1	
48020459	5	40	56	8	18	3,5	2,7	3	1	DIN2184-1	
48020461	6	32	56	10	20	4	3	3	1	DIN2184-1	
48020464	8	32	63	10	21	4,5	3,4	3	1	DIN2184-1	
48020466	10	24	70	13	25	6	4,9	3	1	DIN2184-1	
48020468	12	24	80	13	30	6	4,9	3	1	DIN2184-1	
48020471	1/4	20	80	16	30	7	5,5	3	1	DIN2184-1	
48020474	5/16	18	90	17	35	8	6,2	4	1	DIN2184-1	
48020479	3/8	16	100	20	39	10	8	4	1	DIN2184-1	
48020484	7/16	14	100	22	-	8	6,2	4	2	DIN2184-1	
48020489	1/2	13	110	24	-	9	7	4	2	DIN2184-1	
48020494	9/16	12	110	26	-	11	9	4	2	DIN2184-1	
48020501	5/8	11	110	28	-	12	9	4	2	DIN2184-1	
48020515	3/4	10	125	31	-	14	11	4	2	DIN2184-1	
48020526	7/8	9	140	34	-	18	14,5	5	2	DIN2184-1	
48020538	1	8	160	38	-	18	14,5	5	2	DIN2184-1	

VP-DC-MT NEW

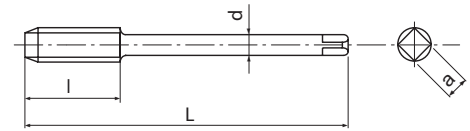
Threading | Cutting taps | UNF



Type 1



Type 2



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

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

UNF	PM	V	ANSI 2BX	C/2,5			DIN 2184-1	DIN 2184-1
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EDP	UNF	P	L	l	l1	d	a	Z	Type	DIN	Price
48020454	2	64	45	9	-	2,8	2,1	3	1	DIN2184-1	
48020456	3	56	50	9	-	2,8	2,1	3	1	DIN2184-1	
48020458	4	48	56	8	18	3,5	2,7	3	1	DIN2184-1	
48020460	5	44	56	8	18	3,5	2,7	3	1	DIN2184-1	
48020462	6	40	56	10	20	4	3	3	1	DIN2184-1	
48020465	8	36	63	10	21	4,5	3,4	3	1	DIN2184-1	
48020467	10	32	70	13	25	6	4,9	3	1	DIN2184-1	
48020469	12	28	80	13	30	6	4,9	3	1	DIN2184-1	
48020472	1/4	28	80	16	30	7	5,5	3	1	DIN2184-1	
48020476	5/16	24	90	17	35	8	6,2	4	1	DIN2184-1	
48020481	3/8	24	90	20	35	10	8	4	1	DIN2184-1	
48020486	7/16	20	100	22	-	8	6,2	4	2	DIN2184-1	
48020491	1/2	20	100	24	-	9	7	4	2	DIN2184-1	
48020496	9/16	18	100	26	-	11	9	4	2	DIN2184-1	
48020504	5/8	18	100	28	-	12	9	4	2	DIN2184-1	
48020517	3/4	16	110	31	-	14	11	4	2	DIN2184-1	
48020528	7/8	14	125	23	-	18	14,5	5	2	DIN2184-1	
48020539	1	12	140	25	-	18	14,5	5	2	DIN2184-1	

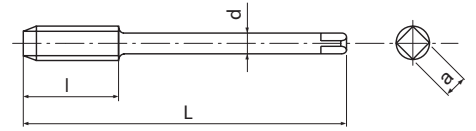
Threading | Cutting taps



UNF

VP-DC-MT NEW

Threading | Cutting taps | G (BSP)



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

Threading | Cutting taps

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

G	PM	V	C/2,5			DIN 5156
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G (BSP)

EDP	G	P	L	l	d	a	Z	DIN	Price
48020837	1/16	28	90	11	6	4,9	4	DIN5156	
48020838	1/8	28	90	11	7	5,5	4	DIN5156	
48020839	1/4	19	100	16	11	9	4	DIN5156	
48020840	3/8	19	100	16	12	9	4	DIN5156	
48020841	1/2	14	125	22	16	12	5	DIN5156	
48020842	5/8	14	125	22	18	14,5	5	DIN5156	
48020843	3/4	14	140	22	20	16	5	DIN5156	
48020844	7/8	14	150	22	22	18	5	DIN5156	
48020845	1	11	160	28	25	20	6	DIN5156	
48020846	1 1/8	11	170	28	28	22	6	DIN5156	
48020847	1 1/4	11	170	28	32	24	6	DIN5156	
48020849	1 1/2	11	190	28	36	29	6	DIN5156	
48020850	1 3/4	11	190	28	40	32	6	DIN5156	
48020851	2	11	220	28	45	35	6	DIN5156	



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