



shaping your dreams



OSG GROUP COMPANY

J U N E 2 0 2 3 V 3 S O M T A C A T A L O G U E

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03E Set	160	1AQ Set	8	359	186	575	241	911	257
03F	160	1BB	28	363	190	576	226	912	257
03G	161	1BB Set	8	366	191	577	246	913	257
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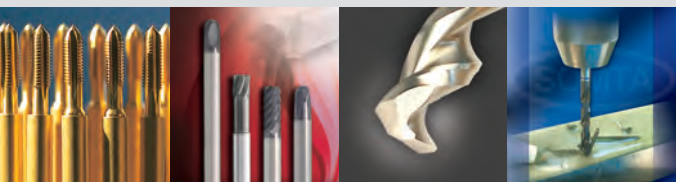
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Manufacturers & Suppliers of Drills, Reamers, End Mills, Bore Cutters, Taps & Dies, Toolbits, Solid Carbide Tooling, Carbide Insert Tooling, Custom Tools and Surface Coatings

Somta Tools specialises in the design and manufacture of standard and custom tools for the industrial and "do it yourself" markets. Product categories can be summarised as drills, cutters, reamers, threading tools and toolbits, which are made in a wide range of sizes, using various materials (HSS and Solid Carbide) and PVD surface coatings to extend wear life.

From humble beginnings in 1954 with 20 employees, Somta has grown into the largest cutting tool manufacturer in the southern hemisphere, operating from offices and modern manufacturing facilities laid out over 3 hectares with a complement of over 250 employees.

The factory in Pietermaritzburg manufactures over 7 000 standard & application products and a further 6 000 made-to-order items to serve local markets and export markets in over 70 countries worldwide.

It has separate factories for Blank Prep, Heat Treatment, Drills, End Mills, Taps, Reamers, Specials, Carbide and Coating all on one site. The employees in each factory become product specialists.

The Somta National Distribution centre situated in Gauteng stocks all standard & application products and is able to offer same day delivery within the Gauteng region, and next day delivery to all other provinces within South Africa.

Somta's Vision

The company's vision of "To manufacture and supply superior cutting tools, driven by a culture of service excellence, to global and domestic markets" is supported by ISO accreditation which was first achieved in 1991 and still remains in place today.



WORLD CLASS CUTTING TOOLS
PROUDLY MANUFACTURED IN
SOUTH AFRICA SINCE 1954



Somta Partners with Global Cutting Tool Leader, OSG

In 2016 Somta partnered with global cutting tool giants OSG, with OSG becoming the majority stakeholder. As a result Somta gained access and support to OSG technologies and expertise on a global scale, and can now offer OSG cutting tools to the South African market.



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Somta investing in the future















In 2018 to 2020, R60 million was invested in new machinery and technology. Included in this investment were 2 x 3 Axis CNC Clearance Grinders, an OTC-1 Long Tool Image Analyser, an AeroLap YT3000, a Fischerscope X-Ray XDLM 237, a DMG MORI NLX 1500 universal CNC mill turn machine, a Haas VF2 SS CNC milling machine, an ANCA MX 7 Linear, a floating carriage, a Zoller Genius 3 and Smart Check 420, a TGT Accudress wheel truing and profiling machine complete with a camera system, 2 x 5-axis TGT V2 Advance Maxima CNC tool and cutter grinders, a Micromatic SM40 CNC Cylindrical Grinder, a PerformCoat PfC540 PVD coating machine and lastly a PerformDrag PfD550 polishing and honing machine.

The USA-designed and manufactured PerformCoat PfC540 PVD coating machine has been developed in conjunction with OSG Japan and it now allows us to implement coating layers with adjustable properties for toughness, hot hardness, wear resistance, oxidation resistance and colour. These include mono, multi, nano and gradient coating structure.





SOMTA Icon Legend & Descriptions

MEASURE	mm	Metric	inch	Imperial	wire	Wire
	letter	Letter				
MATERIAL	HSS	High Speed Steel	HSS Co5	5% Cobalt High Speed Steel	HSS Co8	8% Cobalt High Speed Steel
	HSSE	2-3% Vanadium High Speed Steel	SOLID CARBIDE	9-10% Cobalt, 0.2-0.8 µm Grain size	CARBON STEEL	Carbon Steel
FINISH	BRIGHT FINISH	No Surface Treatment	BLUE FINISH	Steam (HOMO) Temper	GOLD OXIDE FINISH	Steam (HOMO) Temper Straw Colour
	COATED	PVD Surface coating specially adapted to suit application.	UNCOATED	Uncoated	TIAIN	Titanium Aluminium Nitride (Black Finish)
	TIN	Titanium Nitride (Gold Finish)	BRIGHT FINISH WITH TIN TIP	Bright Finish with TIN Tip	RAINBOW COATED	PVD Surface coating specially adapted to suit application.
TYPE	TYPE N	Type N Standard	TYPE W	Type W For Soft Materials	TYPE H	Type H For Hard Materials
	TYPE VA	Type VA For Stainless Materials and steels of higher tensile strength	TYPE UNI	Type UNI For Universal Use	TYPE GG	Type GG For Cast Iron
	TYPE FS	Parabolic Flute Strong Core	CBA	Colour Band Application		
MILLING PROFILE		Fine Pitch Knuckle Type Roughing Profile		Coarse Pitch Knuckle Type Roughing Profile		Fine Pitch Flat Crest Rough Semi-finishing Profile
		Coarse Pitch Flat Crest Rough Semi-finishing Profile		Staggered Teeth		
STANDARD	ISO 529	ISO Standard 529	BASED ON ISO 3292	Based on ISO Standard 3292	DIN 371	DIN Standard 371
	WORKS STD.	Factory Specifications	RF	Refined Flute	QS	Quick Spiral
	H7	Reamer to produce H7 Tolerance				
SHANK		Flatted Shank h6 Tolerance		Plain Shank h7 Tolerance		Threaded Shank h8 Tolerance
		Morse Taper Shank 1 - 4				
POINT ANGLE		118° Drill Point Angle		Countersink Angles		
LENGTHS		Drills Stub		Drills Jobber		Drills Long Series

Continued on next page...











SOMTA Icon Legend & Descriptions... from previous page

LENGTHS		Drills Extra Length				
		End Mills Stub		End Mills Regular Length		End Mills Long Series
FLUTE HELIX ANGLE		30° Right hand helix		10° Left hand helix	STRAIGHT FLUTE	Straight Flute
		Gun Nose Spiral Point	FLUTELESS	Fluteless		
CENTRE DRILLS		Form A Standard		Form B Protected		Form R Radius
		To Suit 1 in 10 Taper				
THREADS	M	Metric Coarse	MF	Metric Fine	BSW	British Standard Whitworth
	BSF	British Standard Whitworth Fine	UNC	Unified National Coarse	UNF	Unified National Fine
	BSP	British Standard Pipe (Fine) "G" Series	BSPT	British Standard Pipe Taper "Rc" Series	NPS	National Pipe Straight
	NPT	National Pipe Taper	BA	British Association	BSB	British Standard Brass
		Thread Form - with 60° flank angle				
TOLERANCE				Tolerance on cutting Diameter		Slitting Saw Tolerance
		Corner Rounding Tolerance		Woodruff Tolerance		Side & Face Cutter Tolerance
		T-Slot Tolerance				
CHAMFER FORM		ISO 2 6H				
		Chamfer Form C 2.5 Threads				
MILLING PROFILE		Direction of Cut		Internal Coolant		Through Hole Tapping
		Blind Hole Tapping		Taper, Through & Blind Hole		Right Hand Cutting
		Left Hand Cutting		Hand Reamer / Tap		

OSG Icon Legend & Descriptions

High Performance Drilling | High Performance Threading

Thread type

 M	Metric	 MF	Metric fine	 UNC	UNC	 UNF	UNF
 BSW	BSW	 BSF	BSF	 BA	BA	 G	G
 Rc (PT)	Rc (PT)	 NPT	NPT				







Tool material

 CARBIDE	Carbide	 PM	Powder metallurgy HSS (PM-T15) (Co5 + V5)
--	---------	---	--

Helix angle

 30°	Helix angle
---	-------------

Coating / surface treatment

 V	Multilayer coating TiCN	 WXL	Multilayer coating WXL	 WDI	Multilayer coating WDI	 TiN	Coating TiN
 IchAda	Ichada coating	 EgiAs	EgiAs coating				

Tool tolerance

 h8	Tool tolerance	 ISO 2 6H	Tool tolerance	 6H +0.1	Oversized +0,1 mm thread tolerance
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Chamfer length

 B/5	Form B (5 pitch)	 C/3	Form C (3 pitch)	 E/1,5	Form E (1,5 pitch)
--	---------------------	--	---------------------	--	-----------------------

Point angle

 140°	Point angle
--	-------------

Shank

 h7	Shank diameter tolerance	 SHRINK FIT	Suitable for Shrink fit system	 DIN 371	Reinforced shank	 DIN 376	Straight shank
 HB	Weldon shank						

Hole specification / thread depth

 Blind hole	For blind holes	 Through hole	For through holes
---	-----------------	---	-------------------

Standard DIN

 DIN 371	Standard DIN
--	--------------

 LH	Left-hand threads
--	-------------------




Coolant

 Internal coolant	Internal coolant	 Centre through	Centre through	 Side through	Side through
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A-Brand

 A	A-Brand product
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SOMTA Material Overview



Recommended



Suitable

P	Steel	Hardness
1.1	Free Cutting Steel	< 120 HB
1.2	Structural Steel	< 200 HB
1.3	Plain Carbon Steel	< 250 HB
1.4	Alloy Steel	< 250 HB
1.5	Low Alloy Steel	250 - 350 HB
1.6	Low Alloy Steel	> 350 HB
M	Stainless Steel	Hardness
2.1	Free Machining Stainless Steel	< 250 HB
2.2	Austenitic Stainless Steel	< 320 HB
2.3	Ferritic and Martensitic Stainless Steel	< 300 HB
2.4	Precipitation Hardened Stainless Steel	320 - 410 HB
K	Cast Iron	Hardness
3.1	Lamellar Graphite Cast Iron	< 150 HB
3.2	Lamellar Graphite Cast Iron	150 - 300 HB
3.3	Nodular Graphite, Malleable Cast Iron	< 200 HB
3.4	Nodular Graphite, Malleable Cast Iron	200 - 300 HB
Ti	Titanium	Hardness
4.1	Titanium unalloyed	< 200 HB
4.2	Titanium alloyed	< 270 HB
4.3	Titanium alloyed	270 - 350 HB
Ni	Nickel	Hardness
5.1	Nickel unalloyed	< 150 HB
5.2	Nickel alloyed	< 270 HB
5.3	Nickel alloyed	270 - 350 HB

Cu	Copper	Hardness
6.1	Copper	< 100 HB
6.2	Beta Brass, Bronze	< 200 HB
6.3	Alpha Brass	< 200 HB
6.4	High Strength Bronze	< 470 HB
N	Aluminium	Hardness
7.1	Aluminium Magnesium unalloyed	< 100 HB
7.2	Aluminium Alloy < 5% Si	< 150 HB
7.3	Aluminium Alloy 5 to 10% Si	< 120 HB
7.4	Aluminium Alloy > 10% Si	
Syn	Synthetic	Hardness
8.1	Duroplastics (short chipping)	
8.2	Thermoplastics (long chipping)	
8.3	Fibre Reinforced Synthetic Materials	
H	Hardened Steel	Hardness
9.1	Hardened Steel	< 32 HRC
9.2	Hardened Steel	33 - 41 HRC
9.3	Hardened Steel	42 - 50 HRC
9.4	Hardened Steel	51 - 63 HRC



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IV

JUNE 2023 V3 SOMTA CATALOGUE

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OSG Material Overview

High Performance Drilling | High Performance Threading



Steel
Full recommendation



Steel
Suitable



Non-ferrous materials
Full recommendation



Non-ferrous materials
Suitable



Stainless steel
Full recommendation



Stainless steel
Suitable



Super alloys
Full recommendation



Super alloys
Suitable



Cast iron
Full recommendation



Cast iron
Suitable



Hardened material
Full recommendation



Hardened material
Suitable

Work Material			DIN
P	C: ≤0,2%	Low carbon steel	1.0116 (S235J2G3) 1.0401 (C15)
	C: 0,25-0,45%	Medium carbon steel	1.0501 (C35)
	C: ≥0,45%	High carbon steel	1.0535 (C55) 1.0553 (S355J0)
	SCM	Alloy steel	1.7225 (42CrMo4)
M	INOX	Stainless steel	1.4301 (X5CrNi18-10)
K	GG	Cast iron	0.6025 (EN-GJL-250/GG25)
	GGG	Ductile cast iron	0.7040 (EN-GJS-400-15/GGG-40)
N	Al	Aluminium	3.0205 (Al99)
	AC, ADC	Cast aluminium alloys	3.2581 (G-ALSi12)
S	Ti	Titanium	3.7164 (Ti6Al4V)
	Ni	Nickel alloys	2.4816 (NiCr15Fe/Inconel® 600)
H	25-35HRC	Hardened steel	
	35-45HRC		
	45-52HRC		
	52-62HRC		
CFRP		CFRP	
Honeycomb		Honeycomb	
Graphite		Graphite	



Index / Selection Guide

STRAIGHT SHANK DRILLS

Product		Code	Spec.	Range
Solid Carbide Coolant Feed MultiForce Jobber Drills - Rainbow Coated High production drilling in multiple materials.		MFD 05C	WORKS STD.	3-12
Solid Carbide Coolant Feed MultiForce Stub Drills - Rainbow Coated High production drilling in multiple materials.		MFD 03C	WORKS STD.	3-12
Solid Carbide Coolant Feed MultiForce Long Series Drills - Rainbow Coated High production drilling in multiple materials.		MFD 08C	WORKS STD.	3-12
Solid Carbide Jobber Drills - Coated and Uncoated High production drilling.		01J	DIN 6537L	1-14
Solid Carbide Stub Drills - Coated and Uncoated High production drilling.		01S	DIN 6537K	1-14
Coolant Feed Solid Carbide Jobber Drills Coated and Uncoated High production drilling.		0CJ	DIN 6537L	6-13.5
Coolant Feed Solid Carbide Stub Drills Coated and Uncoated High production drilling.		0CS	DIN 6537K	6-13.5
Straight Shank Jobber Drill Sets and Counter Dispensers - HSS / HSS-Co5 For various drilling applications.		101 106 - 107 1AQ, 1TT 1X1, 1X5 164, 177 1BB, 1G7 1R5	DIN 338	1-13 1/16-1/2
X-Ratio Straight Shank Jobber Drills Standard Point - HSS - Bright Finish For general purpose drilling.		1X1	DIN 338	1-20 3/64-5/8
X-Ratio Straight Shank Jobber Drills Split Point - HSS - Blue Finish For general purpose drilling.		1X2, 1X5	DIN 338	1-20 3/64-5/8
X-Ratio Straight Shank Jobber Drills Split Point - HSS - Bright Finish with TiN Tip For general purpose drilling.		1X3, 1X6	DIN 338	1-13 3/32-5/32
Straight Shank Jobber Drills Split Point - HSS - Blue Finish For precision drilling.		101 102	DIN 338	0.3-20 1/64-5/8
Straight Shank Jobber Drills Split Point - HSS - Bright Finish with TiN Tip For precision drilling.		1TT	DIN 338	1-16
Straight Shank MultiForce Jobber Drills HSS-Co5 - Rainbow Coated For precision drilling in multiple materials.		MFD 1J	DIN 338	3-12



	P						M				K				Ti			Ni			Cu				N				Syn			H				
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2	●	●	●	●	●	○	●	●	●		●	●	●	●	○	○	○				●	●	●	○	○	○	○					○	○	○	○	
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STRAIGHT SHANK DRILLS... from previous page

Product		Code	Spec.	Range
NDX Jobber Drills - Heavy Duty - HSS-Co5 - Gold Oxide Finish For drilling high tensile steels and other difficult materials.		177	DIN 338	1-13 1/16-1/2
Straight Shank Jobber Drills - HSS-Co5 - Gold Oxide Finish For drilling high tensile steels and other difficult materials.		112	DIN 338	2.1-11.7 1/16-3/8
Straight Shank Stub Drills - Split Point - HSS - Blue Finish A robust drill suited to portable drill application.		140	DIN 1897	1-13 1/16-1/2
Straight Shank Stub Drills - Standard Point - HSS - Blue Finish A robust drill suited to portable drill application.		141	DIN 1897	1.5-25
Double Ended Sheet Metal / Body Drills - HSS - Blue Finish Double ended self centering drill designed to produce accurate holes in thin materials.		151	WORKS STD.	1.5-8
CBA - Yellow Band Quick Spiral Jobber Drills HSS - Bright Finish for drilling Aluminium For drilling materials of low tensile strength.		1AQ	DIN 338	0.9-13
CBA - Blue Band RF Jobber Drills - HSS-Co5 TiAlN Coated for drilling Stainless Steel (VA) Ideal for use on CNC machines where high productivity and accurate holes are required.		1BB	DIN 338	1-13
CBA - Green Band NDX Jobber Drills - HSS-Co5 TiN Coated for drilling Carbon Steel Ideal for use on CNC machines where high productivity and accurate holes are required.		1G7	DIN 338	1-13
CBA - Red Band UDS Jobber Drills - HSS-Co5 TiAlN Coated for drilling Tough Treatable Steel Ideal for use on CNC machines where high productivity and accurate holes are required.		1R5	DIN 338	1-13
CBA - White Band UDC Jobber Drills - HSS-Co5 TiAlN Coated for drilling Cast Iron Ideal for use on CNC machines where high productivity and accurate holes are required.		1W6	DIN 338	2.5-12
Reduced Shank (Electricians) Drills HSS - Blue Finish For general purpose drilling.		175 176	WORKS STD.	11-25 1/2-1"
Straight Shank Long Series Drills HSS - Blue Finish For long reach drilling.		116 117	DIN 340	1-16 1/16-5/8
Straight Shank Extra Length Drills HSS - Blue Finish For extra deep hole drilling.		121-126 132-136	BASED ON ISO 3292	1.5-13 1/8-1/2
UDL Jobber Drills - Split Point - HSS-Co5 Bright Finish and TiAlN Coated Ideal for use on CNC machines where high productivity and accurate holes are required.		164	DIN 338	1-13 3/64-1/2 No.60-1 LTR.A-U
UDL Jobber Drills - UX Point - HSS-Co5 - Bright Finish Ideal for use on CNC machines where high productivity and accurate holes are required.		154	DIN 338	3.3-10



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VIII

JUNE 2023 V3 SOMTA CATALOGUE

Note: Red denotes Somta Premium Products

	P						M				K				Ti			Ni			Cu				N				Syn			H				
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STRAIGHT SHANK DRILLS... from previous page

Product	Code	Spec.	Range
UDL Stub Drills - Split Point - HSS-Co5 - Bright Finish and TiAlN Coated Ideal for use on CNC machines where high productivity and accurate holes are required.	 163	DIN 1897	1-13 3/64-1/2 No.60-1 LTR.A-Z
UDL Long Series Drills - Split Point - HSS-Co5 - Bright Finish Ideal for use on CNC machines where high productivity and accurate holes are required. High performance deep hole drilling.	 110	DIN 340	1-10
UDL Long Series Drills - UX Point - HSS-Co5 - Bright Finish Ideal for use on CNC machines where high productivity and accurate holes are required. High performance deep hole drilling.	 109	DIN 340	3.1-9.6
UDL Extra Length Drills - HSS-Co5 - Bright Finish Ideal for use on CNC machines where high productivity and accurate holes are required. High performance extra deep hole drilling.	 118 119 120	DIN 1869 SERIES 1.2.3	2-16 3-16 4-13
Straight Shank Oil Tube Chipbreaker Jobber Drills - HSS-Co5 - TiAlN Coated High performance production drilling.	 10F	WORKS STD.	12-20
Straight Shank Oil Tube Chipbreaker Long Series Drills - HSS-Co5 - TiAlN Coated High performance production drilling.	 10L	WORKS STD.	12-20
NC Spotting Drills - HSS-Co5 - TiAlN Coated and Bright Finish For accurate positioning of holes. Ideal for CNC lathes. Alternative to using Centre drills.	 184 185	DIN 1897	3-20
Centre Drills - American Standard - HSS - Bright Finish For general centering operations on workpieces requiring additional machining between centres.	 1NA	ANSI	No.1-7
Centre Drills - Form A - HSS - Bright Finish and TiN Coated For general centering operations on workpieces requiring additional machining between centres.	 114 115	DIN 333 BS 328	0.8-10 BS1-BS7
Centre Drills - Form B - HSS - Bright Finish For centering operations as in Type A, but to produce a protected centre.	 138	DIN 333	1-5
Centre Drills - Form R - HSS - Bright Finish Same as Type A, but produces a radius centre suitable for a variety of male centre angles.	 139	DIN 333	1.25-8
Hi-Cut Masonry Drills - Carbide Tipped For drilling concrete, brick and tile.	 186 187 188	-	3-25 10-13 25
Sorgers - HSS - Bright Finish A wood auger for drilling all types of wood.	 291 292 295	WORKS STD.	15-22 17.5 17.5-19
Straight Shank Drills Cutting Data General Information	-	-	-



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55-70 310-312																																			



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MORSE TAPER SHANK DRILLS

Product		Code	Spec.	Range
X-Ratio Morse Taper Shank Drills HSS - Bright Finish Shank and Point For general purpose drilling.		2X1-2X4	DIN 345	6-32
Morse Taper Shank Drills HSS - Bright Finish Shank and Point For precision drilling.		201-205 211-214	DIN 345	3-76 1/4-2"
Heavy Duty MTS Drills - HSS-Co5 - Gold Oxide Finish For drilling high tensile steels and other difficult materials.		208	DIN 345	14-38
MTS Chipbreaker Drills - HSS - Blue Finish High performance production drilling.		2A1	DIN 345	10-50 7/16-1.3/4
MTS Oil Tube Chipbreaker Drills Cross Hole Feed - HSS - Blue Finish High performance production drilling.		2A2	WORKS STD.	12-26 5/8
MTS Oil Tube Chipbreaker Drills Cross Hole Feed - HSS-Co5 - Gold Oxide Finish High performance production drilling.		2A7	WORKS STD.	9/16-1.3/16
MTS Armour Piercing Drills - HSS-Co8 - Blue Finish Heavy duty drilling in work hardening and heat treated steels.		261	WORKS STD.	10-50 9/16
MTS Extra Length Drills HSS - Bright Finish Shank and Point For extra deep hole drilling.		242 244-245	WORKS STD.	10-50
MTS Core Drills - HSS - Blue Finish For enlarging diameters of existing holes whether drilled, punched or cast.		221-224	DIN 343	14-42
MTS Rail Drills - HSS-Co8 - Blue Finish For drilling manganese rails and other tough steels.		279	WORKS STD.	22-35
Morse Taper Shank Drills Cutting Data General Information		-	-	-



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SOCKETS & SLEEVES

Product		Code	Spec.	Range
Extension Sockets For extending spindle to take larger, smaller or the same size Morse Taper Shank.		282	DIN 228	1-5
Reduction Sleeves To reduce the machine taper to suit smaller Morse Taper Shank on tool in use.		283	DIN 228	0-5
General Information		-	-	-



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HIGH PERFORMANCE DRILLING

Product		Coating	A-Brand	Range
HYP-HP-SC-3D Carbide step drill. General purpose. For tap drill holes.		EgiAs		2,5-10,2
HYP-HPO-SC-3D Carbide step drill. General purpose. For tap drill holes.		EgiAs		3,3-10,2
HYP-HPO-3D Carbide drill with internal coolant. General purpose.		WDI		3-20
HYP-HPO-5D Carbide drill with internal coolant. General purpose.		WDI		1-20
HYP-HPO-8D Carbide drill with internal coolant. General purpose.		WDI		3-20
ADO-MICRO 2D 2 flute carbide drill with internal coolant.		IchAda	A	0,7-2
ADO-MICRO 5D 2 flute carbide drill with internal coolant.		IchAda	A	0,7-2
ADO-MICRO 12D / 15D 2 flute carbide drill with internal coolant.		IchAda	A	1-2 2
ADO-MICRO 20D / 25D 2 flute carbide drill with internal coolant.		IchAda	A	1-2 2
ADO-MICRO 30D 2 flute carbide drill with internal coolant.		IchAda	A	1-2
ADF-2D Carbide drill. Flat drilling application.		EgiAs	A	0,2-20
ADFLS-2D Carbide drill. For deep reach flat drilling application.		EgiAs	A	3-20
ADFO-3D Carbide drill with internal coolant. Flat drilling application.		EgiAs	A	3-20
AD-2D Carbide drill. For general purpose steels and cast iron.		EgiAs	A	2-20
AD-4D Carbide drill. For general purpose steels and cast iron.		EgiAs	A	2-20
ADO-SUS-3D Carbide drill with internal coolant. Designed for stainless steel and titanium alloys.		WXL	A	2-20
ADO-SUS-5D Carbide drill with internal coolant. Designed for stainless steel and titanium alloys.		WXL	A	2-20
ADO-SUS-8D Carbide drill with internal coolant. Designed for stainless steel and titanium alloys.		WXL	A	2-12



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













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Product	Coating	A-Brand	Range
ADO-PLT Carbide pilot drill with internal coolant. For general purpose steels and cast iron.		A	3,03-12,03
ADO-3D Carbide drill with internal coolant. For general purpose steels and cast iron.		A	2-20
ADO-5D Carbide drill with internal coolant. For general purpose steels and cast iron.		A	2-20
ADO-10D Carbide drill with internal coolant. For general purpose steels and cast iron.		A	2-12,5
ADO-15D Carbide drill with internal coolant. For general purpose steels and cast iron.		A	2,5-12,5
ADO-20D Carbide drill with internal coolant. For general purpose steels and cast iron.		A	2,5-12,5
ADO-25D Carbide drill with internal coolant. For general purpose steels and cast iron.		A	2,5-12
ADO-30D Carbide drill with internal coolant. For general purpose steels and cast iron.		A	2,5-10
ADO-40D 2 flute carbide drill with internal coolant.		A	3-10
ADO-50D 2 flute carbide drill with internal coolant.		A	3-8
AD-LDS Carbide drill. Carbide starter drill.		A	3-12
AD-LS-LDS Carbide drill, Carbide long shank starter drill.		A	3-12
ADO-TRS-3D 3 flute carbide drill with internal coolant. Allows high feed 1.000mm/min process in steel and cast iron.		A	3-20
ADO-TRS-5D 3 flute carbide drill with internal coolant. Allows high feed 1.000mm/min process in steel and cast iron.		A	3-20
TRS-HO-10D 3 flute carbide drill with internal coolant. Allows high feed 1.000mm/min process in steel and cast iron.		A	5-12



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Product	Coating	A-Brand	Range
P2D BODY Indexable drill with internal coolant. 			12-63
P3D BODY Indexable drill with internal coolant. 			12-63
P4D BODY Indexable drill with internal coolant. 			12-63
P5D BODY Indexable drill with internal coolant. 			12-63
P2D • P3D • P4D • P5D INSERTS Applicable inserts for PD drill. 			
High Performance Drilling Cutting Conditions General Information	-	-	-



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REAMERS, COUNTERSINKS & COUNTERBORES

Product	Code	Spec.	Range
Parallel Shank Countersinks - HSS-Co5 Uncoated and TiN Coated To produce a countersink suitable for countersunk head screws, also used as a deburring tool. 	761 763	DIN 334C DIN 335C	6.3-25
MTS Countersinks - HSS-Co5 To produce a countersink suitable for countersunk head screws, also used as a deburring tool. 	771 773	DIN 334D DIN 335D	16-80
Parallel Shank Counterbores - HSS For counterboring holes to suit capscrew heads. 	774	BS 328 ISO 4206 DIN 373	M3-M12
MTS Counterbores - HSS For counterboring holes to suit capscrew heads. 	775	ISO 4207 DIN 375	M22
Parallel Hand Reamers - HSS General hand reaming. 	701 702	BS 328 ISO 236/1 DIN 206	1.5-38 1/16-1.1/2
MTS Parallel Machine Reamers - HSS General machine reaming. 	711 712	BS 328 ISO 236/11	6-50 3/8-1.7/8
MTS Taper Bridge Machine Reamers - HSS For opening out existing holes for alignment on structural steel work. 	721	BS 328 ISO 2238 DIN 311	13-38



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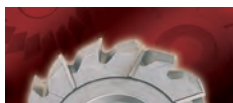
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REAMERS, COUNTERSINKS & COUNTERBORES... from previous page

Product	Code	Spec.	Range
MTS Machine Chucking Reamers - HSS-Co5 General machine reaming.	741	DIN 208	6-32
Parallel Shank Machine Chucking Reamers - HSS-Co5 General machine reaming.	751 752	DIN 212	2-20 1/8-3/4
Hand Taper Pin Reamers - Straight Flute - HSS Reaming holes to suit standard taper pins.	731 732	DIN 9 BS 328	2-25 5/64-7/8
Hand Taper Pin Reamers - Spiral Flute - HSS Reaming holes to suit standard taper pins.	733	DIN 9	4
Reamers, Countersinks & Counterbores Cutting Data General Information	-	-	-



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BORE CUTTERS

Product	Code	Spec.	Range
Slitting Saws - Fine Pitch - HSS Narrow slotting and sawing applications in thin materials.	440-441	DIN 1837A	32-200
Side & Face Cutters Staggered Tooth - HSS-Co5 Designed for heavy duty slotting operations in steel and in most soft materials.	401	DIN 885A	63
Bore Cutters Cutting Data General Information	-	-	-



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SHANK CUTTERS

Product	Code	Spec.	Range
Solid Carbide 2 Flute End Mills - Regular Length Plain Shank - Uncoated for Aluminium Milling keyways and slots to size in one cut. Designed for plunging operations.	02A	WORKS STD.	1-16
Solid Carbide 3 Flute End Mills - Regular Length Plain Shank - Uncoated for Aluminium Multi-purpose tool used for slotting and profiling.	02R	WORKS STD.	2-16



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Note: Red denotes Somta Premium Products

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SHANK CUTTERS... from previous page

Product		Code	Spec.	Range
Solid Carbide 3 Flute Ball Nose End Mills - Regular Length Plain Shank - Uncoated for Aluminium For finishing of contours at high feed rates where a superior finish is required.		02S	WORKS STD.	3-16
Solid Carbide Single Flute End Mills - Regular Length Plain Shank - Uncoated for Aluminium For dry machining of soft materials.		02T	WORKS STD.	3-12
Solid Carbide 3 Flute Toroidal End Mills - Regular Length Plain Shank - Uncoated for Aluminium For minimum vibration in heavy profile machining.		02U	WORKS STD.	3-16
Solid Carbide 3 Flute Roughing End Mills Regular Length - Knuckle Form - Coarse Pitch Flatted Shank - Uncoated for Aluminium Maximum stock removal at high feed rates in profiling applications.		03C	WORKS STD.	6-20
Solid Carbide 3 Flute Roughing End Mills - Regular Length Flat Crest - Coarse Pitch - Flatted Shank - Coated Maximum stock removal at high feed rates in profiling applications.		03D	WORKS STD.	10-20
Solid Carbide 4 Flute Roughing End Mills - Regular Length Knuckle Form - Fine Pitch - Flatted Shank - Coated Maximum stock removal at high feed rates in profiling applications.		03E	WORKS STD.	6-20
Solid Carbide 4 Flute Roughing End Mills - Regular Length Flat Crest - Fine Pitch - Flatted Shank - Coated Maximum stock removal at high feed rates in profiling applications.		03F	WORKS STD.	6-20
Solid Carbide 6 Flute Finishing End Mills Regular Length - Plain Shank - Coated Designed for peripheral milling as a finishing operation.		03G	WORKS STD.	6-20
Solid Carbide 6 Flute Hi-Feed End Mills Regular Length - Plain Shank - Coated Designed for peripheral milling of contours and complex shapes in hard materials.		03H	WORKS STD.	6-20
Solid Carbide 2 Flute Ball Nose Finishing End Mills Regular Length - Plain Shank - Coated Designed for peripheral milling of contours and complex shapes in hard materials.		03I	WORKS STD.	16-20
Solid Carbide 2 Flute Ball Nose Finishing End Mills Long Series - Plain Shank - Coated Designed for peripheral milling of contours and complex shapes in hard materials.		03J	WORKS STD.	4-20
Solid Carbide 4 Flute MultiForce End Mills Regular Length - Flatted Shank - Rainbow Coated For roughing and finishing with high metal removal rates in multiple materials eliminating the use of multiple tools.		MFM-0	DIN 6527L	5-20
Solid Carbide 4 Flute Stub VariCut End Mills - Flatted Shank - Coated For roughing and finishing with high metal removal rates eliminating the use of multiple tools. Designed for tougher materials including Stainless steel and Titanium.		04V	DIN 6527K	5-20



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Note: Red denotes Somta Premium Products

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Product		Code	Spec.	Range
Solid Carbide 4 Flute VariCut End Mills Regular Length - Plain and Flatted Shank - Coated For roughing and finishing with high metal removal rates eliminating the use of multiple tools. Designed for tougher materials including Stainless steel and Titanium.		03V	DIN 6527L	5-20
Solid Carbide 5 Flute VariCut End Mills Regular Length - Plain and Flatted Shank - Coated For roughing and finishing with high metal removal rates eliminating the use of multiple tools. Designed for tougher materials including Stainless steel and Titanium.		05V	DIN 6527L	5-20
Solid Carbide 2 Flute End Mills Regular Length - Plain Shank - Coated and Uncoated Milling keyways and slots to size in one cut. Designed for plunging operations. High tensile steels and other difficult materials.		03A	WORKS STD.	1-20
Solid Carbide 2 Flute End Mills Long Series - Plain Shank - Coated and Uncoated Milling keyways and slots to size in one cut. Designed for plunging operations. High tensile steels and other difficult materials.		03B	WORKS STD.	3-20
Solid Carbide 4 Flute End Mills Regular Length - Plain Shank - Coated and Uncoated For profile milling, high tensile steels and other difficult materials.		03K	WORKS STD.	1-20
Solid Carbide 4 Flute End Mills Long Series - Plain Shank - Coated and Uncoated For profile milling, high tensile steels and other difficult materials.		03L	WORKS STD.	3-20
Solid Carbide 2 Flute Ball Nose End Mills Regular Length - Plain Shank - Coated and Uncoated Milling keyways and slots to size in one cut. Designed for plunging operations & contouring. Produces a radius at the bottom of the cut.		03M	WORKS STD.	1-20
Solid Carbide 2 Flute Ball Nose End Mills Long Series - Plain Shank - Coated and Uncoated Milling keyways and slots to size in one cut. Designed for plunging operations & contouring. Produces a radius at the bottom of the cut.		03N	WORKS STD.	3-20
Solid Carbide 4 Flute Ball Nose End Mills Regular Length - Plain Shank - Coated and Uncoated For profile milling, high tensile steels and other difficult materials.		03P	WORKS STD.	1-20
2 Flute End Mills (Slot Drills) - Regular Length - Threaded Shank - HSS Milling keyways and slots to size. Designed for plunging operations.		321 323	DIN 327 BS 122	1.5-50 1/4-3/4
2 Flute End Mills (Slot Drills) Long Series - Threaded Shank - HSS Milling keyways and slots to size. Designed for plunging operations.		326	BS 122	2-20
2 Flute End Mills (Slot Drills) - Regular Length Threaded Shank - HSS-Co8 - Uncoated and TiAIN Coated Milling keyways and slots to size in one cut. Designed for plunging operations. High tensile steels and other difficult materials.		348 349	DIN 327 BS 122	1.5-50 1/16-2"



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Note: Red denotes Somta Premium Products

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Product		Code	Spec.	Range
2 Flute End Mills (Slot Drills) - Long Series Threaded Shank - HSS-Co8 - Uncoated and TiAlN Coated Milling keyways and slots to size in one cut. Designed for plunging operations. High tensile steels and other difficult materials.		350	BS 122	2-20
2 Flute End Mills (Slot Drills) - Regular Length Flatted Shank - HSS-Co8 - Uncoated and TiAlN Coated Milling keyways and slots to size in one cut. Designed for plunging operations. High tensile steels and other difficult materials.		305	DIN 327	2-24
2 Flute End Mills (Slot Drills) - Regular Length Plain Shank - HSS-Co8 - Uncoated and TiAlN Coated Milling keyways and slots to size in one cut. Designed for plunging operations. High tensile steels and other difficult materials.		310	DIN 327	2-19
2 Flute Ball Nose End Mills - Regular Length Threaded Shank - HSS-Co8 - Uncoated and TiAlN Coated Milling keyways and slots to size in one cut. Designed for plunging operations & contouring. Produces a radius at the bottom of the cut.		340	DIN 327	2-25
2 Flute Ball Nose End Mills - Regular Length Flatted Shank - HSS-Co8 - Uncoated and TiAlN Coated Milling keyways and slots to size in one cut. Designed for plunging operations & contouring. Produces a radius at the bottom of the cut.		337	DIN 327	5-24
2 Flute Ball Nose End Mills - Regular Length Plain Shank - HSS-Co8 - Uncoated and TiAlN Coated Milling keyways and slots to size in one cut. Designed for plunging operations & contouring. Produces a radius at the bottom of the cut.		312	DIN 327	2-24
3 Flute End Mills - Regular Length Threaded Shank - HSS-Co8 - Uncoated and TiAlN Coated Multi-purpose tool used for slotting and profiling. High tensile steels and other difficult materials.		342	BS 122	4-19
Multi-Flute End Mills - Regular Length - Threaded Shank - HSS For profile milling.		301 303	BS 122	2.5-50 1/8-1.7/8
Multi-Flute End Mills - Long Series - Threaded Shank - HSS For profile milling.		306	BS 122	15-19
Multi-Flute End Mills - Regular Length Threaded Shank - HSS-Co8 - Uncoated and TiAlN Coated For profile milling, high tensile steels and other difficult materials.		344 345	BS 122	2.5-50 1/8-3/4
Multi-Flute End Mills - Long Series Threaded Shank - HSS-Co8 - Uncoated and TiAlN Coated For profile milling, high tensile steels and other difficult materials.		346	BS 122	3-32
Multi-Flute End Mills - Regular Length Flatted Shank - HSS-Co8 - Uncoated and TiAlN Coated For profile milling, high tensile steels and other difficult materials.		359	DIN 844	3-25



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Note: Red denotes Somta Premium Products

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Product		Code	Spec.	Range
Multi-Flute End Mills - Regular Length Plain Shank - HSS-Co8 - Uncoated and TiAlN Coated For profile milling, high tensile steels and other difficult materials.		314	DIN 844	3-25
Roughing End Mills - Regular Length - Threaded Shank Knuckle Form - Coarse Pitch - HSS-Co8 - TiAlN Coated Maximum stock removal at high feed rates in profiling applications.		316	BS 122	6-20
Roughing End Mills - Long Series - Threaded Shank Knuckle Form - Coarse Pitch - HSS-Co8 - TiAlN Coated Maximum stock removal at high feed rates in profiling applications.		318	BS 122	10-20
Roughing End Mills - Regular Length - Flatted Shank Knuckle Form - Coarse Pitch - HSS-Co8 Maximum stock removal at high feed rates in profiling applications.		330	DIN 844	6
Roughing End Mills - Regular Length - Flatted Shank Flat Crest - Coarse Pitch - HSS-Co8 Maximum stock removal at high feed rates in profiling applications.		368	DIN 844	12-40
Corner Rounding Cutters - Threaded Shank - HSS-Co8 To produce a true radius up to a quarter of a circle application.		363	DIN 6518 FORM D	2-20
Corner Rounding Cutters - Flatted Shank - HSS-Co8 To produce a true radius up to a quarter of a circle application.		363	DIN 6518 FORM B	2-20
Woodruff Cutter Threaded Shank - HSS-Co5 To produce a keyway to suit woodruff keys.		366	BASED ON DIN 850 TO SUIT DIN 6888 KEY	10.5-45.5
		367	BASED ON BS 122	204-1210
Woodruff Cutter Flatted Shank - HSS-Co5 To produce a keyway to suit woodruff keys.		374	DIN 850	10.5-45.5
T-Slot Cutters - Threaded Shank - HSS-Co5 For opening out the bottom of previously milled slot to form a T-slot.		371	BASED ON ISO 3337 DIN 851	6-16
T- Slot Cutters - Flatted Shank - HSS-Co5 For opening out the bottom of previously milled slot to form a T-slot.		385	DIN 851	6-16
Dovetail Cutters Threaded Shank - HSS-Co5 To produce dovetail slides for machine tool tables, jigs and fixtures.		376	BASED ON DIN 1833 ISO 3859	16-40
Dovetail Cutters Flatted Shank - HSS-Co5 To produce dovetail slides for machine tool tables, jigs and fixtures.		386	DIN 1833 FORM C	16-40
Inverted Dovetail Cutters Threaded Shank - HSS-Co5 To produce opposite section of dovetail slide to Dovetail cutter.		378	BASED ON DIN 1833 ISO 3859	16-40



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Note: Red denotes Somta Premium Products


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Product	Code	Spec.	Range
Inverted Dovetail Cutters Flatted Shank - HSS-Co5 To produce opposite section of dovetail slide to Dovetail cutter.	 389	DIN 1833 FORM D	16-32
Shank Cutters Cutting Data General Information	-	-	-



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THREADING TOOLS

Product	Code	Spec.	Range
Short Hand Taps - Metric Coarse - HSS For general hand tapping.	 501	ISO 529	M1-M68
Left Hand Short Hand Taps - Metric Coarse - HSS For general hand tapping.	 519	ISO 529	M3-M36
Serial Hand Taps - Metric Coarse - HSSE For tapping in tougher materials.	 518	DIN 352	M3-M24
Gun Nose Short Machine Taps - Metric Coarse - HSSE For machine tapping of through holes.	 508	ISO 529	M2-M36
15° Spiral Flute Short Machine Taps - Metric Coarse - HSSE For machine tapping of blind holes.	 509	ISO 529	M3-M24
35° Spiral Flute Short Machine Taps - Metric Coarse - HSSE For machine tapping of blind holes.	 510	ISO 529	M3-M24
MultiForce Gun Nose Tap Metric Coarse - HSSE - Uncoated and Rainbow Coated For machine tapping of through holes in multiple materials.	 MFT 5SP	DIN 371 DIN 376	M3-M10 M12-M20
MultiForce Spiral Flute Tap Metric Coarse - HSSE - Uncoated and Rainbow Coated For machine tapping of blind holes in multiple materials.	 MFT 5SF	DIN 371 DIN 376	M3-M10 M12-M20
CBA - Yellow Band Gun Nose Taps Metric Coarse - HSSE - Bright Finish For machine tapping of through holes in soft materials eg. Aluminium.	 538	DIN 371	M3-M10
	 548	DIN 376	M12-M16
CBA - Yellow Band Spiral Flute Taps Metric Coarse - HSSE - Bright Finish For machine tapping of blind holes in soft materials eg. Aluminium.	 558	DIN 371	M3-M10
	 569	DIN 376	M16-M22
CBA - Yellow Band Fluteless Taps - Metric Coarse - HSSE - TiN Coated For cold forming threads in ductile materials.	 512	DIN 371 DIN 376	M5-M10 M12



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Product		Code	Spec.	Range
CBA - Blue Band Gun Nose Taps Metric Coarse - HSSE - TiAlN Coated For machine tapping of through holes in tough materials eg. Stainless Steel.		539	DIN 371	M3-M10
		549	DIN 376	M12-M24
CBA - Blue Band Spiral Flute Taps Metric Coarse - HSSE - TiAlN Coated For machine tapping of blind holes in tough materials eg. Stainless Steel.		559	DIN 371	M3-M10
		570	DIN 376	M12-M24
CBA - Green Band Gun Nose Taps Metric Coarse - HSSE - TiN Coated For machine tapping of through holes in carbon steels.		561	DIN 371	M3-M10
		566	DIN 376	M3.5-M24
CBA - Green Band 15° Spiral Flute Taps Metric Coarse - HSSE - TiN Coated For machine tapping of blind holes in carbon steels.		562	DIN 371	M3-M10
		567	DIN 376	M4-M8
CBA - Green Band 35° Spiral Flute Taps Metric Coarse - HSSE - TiN Coated For machine tapping of blind holes in carbon steels.		563	DIN 371	M3-M10
		568	DIN 376	M3.5-M24
CBA - Red Band Gun Nose Taps Metric Coarse - HSSE - TiAlN Coated For machine tapping of through holes in high tensile materials eg. Tool Steel.		540	DIN 371	M3-M10
		550	DIN 376	M12-M24
CBA - Red Band Spiral Flute Taps Metric Coarse - HSSE - TiAlN Coated For machine tapping of blind holes in high tensile materials eg. Tool Steel.		564	DIN 371	M3-M10
		576	DIN 376	M12-M24
CBA - White Band Spiral Flute Taps Metric Coarse - HSSE - TiAlN Coated For machine tapping of blind holes or through holes in Cast Iron.		578	DIN 371	M3-M10
		579	DIN 376	M14-M22
Short Hand Taps - Metric Fine - HSS For general hand tapping.		511	ISO 529	MF3-MF52
Gun Nose Short Machine Taps - Metric Fine - HSSE For machine tapping of through holes.		515	ISO 529	MF4-MF24
Short Hand Taps - BSW - HSS For general hand tapping.		521	ISO 529	1/16-2"
Gun Nose Short Machine Taps - BSW - HSSE For machine tapping of through holes.		526	ISO 529	1/8-1"
Spiral Flute Short Machine Taps - BSW - HSSE For machine tapping of blind holes.		528	ISO 529	1/8-1"
Short Hand Taps - BSF - HSS For general hand tapping.		531	ISO 529	3/16-2"



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Note: Red denotes Somta Premium Products

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Product		Code	Spec.	Range
Short Hand Taps - UNC - HSS For general hand tapping.		541	ISO 529	No.4-2"
Gun Nose Short Machine Taps - UNC - HSSE For machine tapping of through holes.		545	ISO 529	No.6-1"
Spiral Flute Short Machine Taps - UNC - HSSE For machine tapping of blind holes.		546	ISO 529	No.6-1"
Short Hand Taps - UNF - HSS For general hand tapping.		551	ISO 529	No.4-1.1/2"
Gun Nose Short Machine Taps - UNF - HSSE For machine tapping of through holes.		555	ISO 529	No.4-1"
Spiral Flute Short Machine Taps - UNF - HSSE For machine tapping of blind holes.		556	ISO 529	No.4-1"
Parallel Pipe Taps - BSP - HSS For hand or machine tapping of through or blind holes.		571	ISO 2284	1/8-3"
Gun Nose Short Machine Pipe Taps - BSP - HSSE For machine tapping of through holes.		573	ISO 2284	1/8-3/4"
Taper Pipe Hand Taps - BSPT - HSS For hand or machine tapping of through or blind holes.		575	ISO 2284	1/8-2"
Parallel Pipe Taps - NPS - HSS For hand or machine tapping of through or blind holes.		581	ISO 2284	1/8-2"
Taper Pipe Taps - NPT - HSS For hand or machine tapping of through or blind holes.		585	ISO 2284	1/8-2"
Short Hand Taps - BA - HSS For general hand tapping.		591	ISO 529	No.9-0
Short Hand Taps - BSB - HSS For general hand tapping.		595	ISO 529	1/4-1"
Circular Solid Dies - Metric Coarse - HSS For production of components 3 x D in length.		580	DIN 223	M1-M48
Circular Solid Dies - Metric Fine - HSS For production of components 3 x D in length.		582	DIN 223	MF2.2-MF52
Circular Solid Dies - BSP - HSS For production of components 3 x D in length.		587	DIN 223	3/8-1.3/4"
Die Nuts - Metric Coarse - HSS For general purpose repairing or cleaning of threads.		507	DIN 382	M3-M36



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Note: Red denotes Somta Premium Products














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Product		Code	Spec.	Range
Die Nuts - Metric Fine - HSS For general purpose repairing or cleaning of threads.		577	DIN 382	MF3-MF36
Die Nuts - BSW - HSS For general purpose repairing or cleaning of threads.		527	DIN 382	1/8-2"
Die Nuts - BSF - HSS For general purpose repairing or cleaning of threads.		537	DIN 382	1/4-2"
Die Nuts - UNC - HSS For general purpose repairing or cleaning of threads.		547	DIN 382	1/4-1.1/2
Die Nuts - UNF - HSS For general purpose repairing or cleaning of threads.		557	DIN 382	1/4-1.1/2
Die Nuts - BSP - HSS For general purpose repairing or cleaning of threads.		574	DIN 382	1/8-2"
Adjustable Tap Wrenches For direct application of hand taps.		588	DIN 1814	TW1-TW6 T1-T2 TL3-TL4
Die Stocks For direct application of circular solid dies - DIN 223 without capsule.		589	DIN 225	0-9A
Somta Tapping, Reaming and Drilling Fluid For improving tool life and reducing tool wear.		5AU	-	300ml
MultiForce HSS-Co5 Jobber Drill and Tap Sets For precision drilling and machine tapping in multiple materials.		MFS	-	4.2 - 10.2 M5-M12
CBA - Colour Band Jobber Drill and Gun Nose Tap Sets For machine tapping of through holes in tough materials eg. Stainless Steel, carbon steels or high tensile materials eg. Tool Steel.		5BB 5G7 5R5	-	4.2 - 10.2 M5-M12
Drill and Tap Sets in Metal Index Cases - Metric Coarse - HSS For general hand tapping or machine tapping of through or blind holes.		598	-	2.5 - 10.2 M3-M12
Tap & Die Cased Sets - HSS For general hand tapping.		5A1	-	-



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Note: Red denotes Somta Premium Products

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Product		Code	Spec.	Range
Hi-Cut Carbon Steel Short Hand Tap Sets - Metric Coarse For general hand tapping (cleaning threads).		901	BS 949: 1951	M2-M36
Hi-Cut Carbon Steel Short Hand Tap Sets - Metric Fine For general hand tapping (cleaning threads).		902	BS 949: 1951	MF4-MF24
Hi-Cut Carbon Steel Short Hand Tap Sets - BSW For general hand tapping (cleaning threads).		903	BS 949: 1951	1/8-1.1/4
Hi-Cut Carbon Steel Short Hand Tap Sets - BSF For general hand tapping (cleaning threads).		904	BS 949: 1951	5/16
Hi-Cut Carbon Steel Short Hand Tap Sets - UNC For general hand tapping (cleaning threads).		905	BS 949: 1951	1/4-1"
Hi-Cut Carbon Steel Short Hand Tap Sets - UNF For general hand tapping (cleaning threads).		906	BS 949: 1951	1/4-1"
Hi-Cut Carbon Steel Parallel Pipe Tap Sets - BSP For hand or machine tapping of through or blind holes (cleaning threads).		907	BS 949: 1951	1/8-2"
Hi-Cut Carbon Steel Short Hand Tap Sets - BA For general hand tapping (cleaning threads).		908	BS 949: 1951	No.5-1
Hi-Cut Carbon Steel Die Nuts - Metric Coarse For general purpose cleaning of threads.		911	BS 1127: 1974	M4-M39
Hi-Cut Carbon Steel Die Nuts - Metric Fine For general purpose cleaning of threads.		912	BS 1127: 1974	MF8-MF24
Hi-Cut Carbon Steel Die Nuts - BSW For general purpose cleaning of threads.		913	BS 1127: 1974	1/4-1.1/8
Hi-Cut Carbon Steel Die Nuts - BSF For general purpose cleaning of threads.		914	BS 1127: 1974	1/2-1.1/8
Hi-Cut Carbon Steel Die Nuts - UNC For general purpose cleaning of threads.		915	BS 1127: 1974	1.1/4-1.3/8
Hi-Cut Carbon Steel Die Nuts - BA For general purpose cleaning of threads.		918	BS 1127: 1974	No.0-6
Hi-Cut Carbon Steel Tap & Die Cased Sets For general hand tapping (cleaning threads).		970-974	-	-
General Information		-	-	-



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






















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HIGH PERFORMANCE THREADING

Product	Coating	A-Brand	Range
M-NRT Powder metal forming tap for through & blind holes. For general steel, stainless steels and aluminum.			M1-M24
M-OIL-NRT Powder metal forming tap for through & blind holes. For general steel, stainless steels and aluminum. Side through coolant.			M5-M24
M-NRT 6GX Powder metal forming tap for through & blind holes. For general steel, stainless steels and aluminum. For 6G internal thread tolerance.			M2-M16
M-NRT FORM E Powder metal forming tap for through & blind holes. For general steel, stainless steels and aluminum. Chamfer Form E.			M2-M16
M-OIL-NRT FORM E Powder metal forming tap for blind holes. For general steel, stainless steels and aluminum. Chamfer Form E. Center through coolant.			M5-M16
M-NRT Powder metal forming tap for through & blind holes. For general steel, stainless steels and aluminum.			MF4-MF24
M-NRT Powder metal forming tap for through & blind holes. For general steel, stainless steels and aluminum.			1/8-3/4 G (BSP)
A-XPf Powder metal forming tap for through & blind holes. High speed tapping in general steels, aluminium, stainless steels.			M3-M30
S-XPf HSSE forming tap for through & blind holes. For general steels, stainless steels, aluminium.			M1-M30
A-OIL-XPf Powder metal forming tap for through & blind holes. High speed tapping in general steels, aluminium, stainless steels. Side through coolant.			M5-M45
S-OIL-XPf HSSE forming tap for through & blind holes. For general steels, stainless steels, aluminium. Side through coolant.			M5-M45
A-XPf Powder metal forming tap for through & blind holes. High speed tapping in general steels, aluminium, stainless steels.			MF8-MF24
S-XPf HSSE forming tap for through & blind holes. For general steels, stainless steels, aluminium.			MF4-MF24



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











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Product	Coating	A-Brand	Range
A-OIL-XPFF Powder metal forming tap for through & blind holes. High speed tapping in general steels, aluminium, stainless steels. Side through coolant.		A	MF8-MF24
S-OIL-XPFF HSSE forming tap for through & blind holes. For general steels, stainless steels, aluminium. Side through coolant.		A	MF8-MF24
S-XPFF HSSE forming tap for through & blind holes. For general steels, stainless steels, aluminium.		A	No.6-1" UNF
S-OIL-XPFF HSSE forming tap for through & blind holes. For general steels, stainless steels, aluminium. Side through coolant.		A	1/4-1" UNF
M-SFT-DUPLEX Powder metal spiral-fluted cutting tap for blind holes. For difficult materials such as 304L, 316L, 15-5PH & 17-4PH, Super Duplex 1.4410, Inconel 625.			M2-M24
M-SFT-DUPLEX Powder metal spiral-fluted cutting tap for blind holes. For difficult materials such as 304L, 316L, 15-5PH & 17-4PH, Super Duplex 1.4410, Inconel 625.			1/8-1" G (BSP)
A-SFT Powder metal spiral-fluted cutting tap for blind holes. High speed tapping in general steels, aluminium, stainless steels.		A	M1-M24
A-POT Powder metal spiral-point cutting tap for through holes. High speed tapping in general steels, aluminium, stainless steels.		A	M1-M24
A-OIL-SFT Powder metal spiral-fluted cutting tap for blind holes. High speed tapping in general steels, aluminium, stainless steels. Centre through coolant.		A	M6-M56
A-OIL-POT Powder metal spiral-point cutting tap for through holes. High speed tapping in general steels, aluminium, stainless steels. Side through coolant.		A	M6-M24
A-SFT 6GX Powder metal spiral-fluted cutting tap for blind holes. High speed tapping in general steels, aluminium, stainless steels. For 6G internal thread tolerance.		A	M2-M16
A-POT 6GX Powder metal spiral-point cutting tap for through holes. High speed tapping in general steels, aluminium, stainless steels. For 6G internal thread tolerance.		A	M2-M16



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Product	Coating	A-Brand	Range
A-SFT 7GX Powder metal spiral-fluted cutting tap for blind holes. High speed tapping in general steels, aluminium, stainless steels. For 7G internal thread tolerance.		A	M2-M16
A-POT 7GX Powder metal spiral-point cutting tap for through holes. High speed tapping in general steels, aluminium, stainless steels. For 7G internal thread tolerance.		A	M2-M16
A-SFT FORM E Powder metal spiral-fluted cutting tap for blind holes. High speed tapping in general steels, aluminium, stainless steels. Form E chamfer.		A	M3-M16
A-SFT+0.1 Powder metal spiral-fluted cutting tap for blind holes. High speed tapping in general steels, aluminium, stainless steels. Oversized tap for 6H +0,1mm thread tolerance.		A	M3-M16
A-POT+0.1 Powder metal spiral-point cutting tap for through holes. High speed tapping in general steels, aluminium, stainless steels. Oversized tap for 6H +0,1mm thread tolerance.		A	M3-M16
A-LT-SFT Powder metal spiral-fluted cutting tap for blind holes. High speed tapping in general steels, aluminium, stainless steels. With long shank for long reach threading.		A	M2-M20
A-LT-POT Powder metal spiral-point cutting tap for through holes. High speed tapping in general steels, aluminium, stainless steels. With long shank for long reach threading.		A	M2-M20
A-SFT-LH Powder metal spiral-fluted cutting tap for blind holes. High speed tapping in general steels, aluminium, stainless steels. For left-hand threads.		A	M3-M24
A-POT-LH Powder metal spiral-point cutting tap for through holes. High speed tapping in general steels, aluminium, stainless steels. For left-hand threads.		A	M3-M24
A-SFT-HB Weldon Powder metal spiral-fluted cutting tap for blind holes. High speed tapping in general steels, aluminium, stainless steels. With weldon shank.		A	M3-M16
A-POT-HB Weldon Powder metal spiral-point cutting tap for through holes. High speed tapping in general steels, aluminium, stainless steels. With weldon shank.		A	M3-M16



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Product		Coating	A-Brand	Range
A-SFT Powder metal spiral-fluted cutting tap for blind holes. High speed tapping in general steels, aluminium, stainless steels.		V	A	MF2,5-MF24
A-POT Powder metal spiral-point cutting tap for through holes. High speed tapping in general steels, aluminium, stainless steels.		V	A	MF2,5-MF24
A-OIL-SFT Powder metal spiral-fluted cutting tap for blind holes. High speed tapping in general steels, aluminium, stainless steels. Centre through coolant.		V	A	MF8-MF20
A-OIL-POT Powder metal spiral-point cutting tap for through holes. High speed tapping in general steels, aluminium, stainless steels. Side through coolant.		V	A	MF8-MF20
A-SFT 6GX Powder metal spiral-fluted cutting tap for blind holes. High speed tapping in general steels, aluminium, stainless steels. For 6G internal thread tolerance.		V	A	MF6-MF24
A-POT 6GX Powder metal spiral-point cutting tap for through holes. High speed tapping in general steels, aluminium, stainless steels. For 6G internal thread tolerance.		V	A	MF6-MF24
A-SFT Powder metal spiral-fluted cutting tap for blind holes. High speed tapping in general steels, aluminium, stainless steels.		V	A	No.2-1" UNC
A-POT Powder metal spiral-point cutting tap for through holes. High speed tapping in general steels, aluminium, stainless steels.		V	A	No.2-1" UNC
A-SFT Powder metal spiral-fluted cutting tap for blind holes. High speed tapping in general steels, aluminium, stainless steels.		V	A	No.2-1" UNF
A-POT Powder metal spiral-point cutting tap for through holes. High speed tapping in general steels, aluminium, stainless steels.		V	A	No.2-1" UNF
A-SFT Powder metal spiral-fluted cutting tap for blind holes. High speed tapping in general steels, aluminium, stainless steels.		V	A	1/8-1" G (BSP)
A-POT Powder metal spiral-point cutting tap for through holes. High speed tapping in general steels, aluminium, stainless steels.		V	A	1/8-1" G (BSP)
A-SFT Powder metal spiral-fluted cutting tap for blind holes. High speed tapping in general steels, aluminium, stainless steels.		V	A	1/8-1" BSW



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Product		Coating	A-Brand	Range
A-POT Powder metal spiral-point cutting tap for through holes. High speed tapping in general steels, aluminium, stainless steels.		V	A	1/8-1" BSW
A-SFT Powder metal spiral-fluted cutting tap for blind holes. High speed tapping in general steels, aluminium, stainless steels.		V	A	1/4-1" BSF
A-POT Powder metal spiral-point cutting tap for through holes. High speed tapping in general steels, aluminium, stainless steels.		V	A	1/4-1" BSF
A-SFT Powder metal spiral-fluted cutting tap for blind holes. High speed tapping in general steels, aluminium, stainless steels.		V	A	No.0-12 BA
A-POT Powder metal spiral-point cutting tap for through holes. High speed tapping in general steels, aluminium, stainless steels.		V	A	No.0-12 BA
A-TPT Powder metal straight flute cutting tap for through & blind holes. High speed tapping in general steels and aluminium. RC (BSPT) tapered 1:16.		V	A	1/8-1" Rc (PT)
A-SFT Rc Powder metal spiral flute cutting tap for blind holes. High speed tapping in general steels and aluminium. RC (BSPT) tapered 1:16.		V	A	1/16-1" Rc (PT)
A-SFT NPT Powder metal spiral flute cutting tap for blind holes. High speed tapping in general steels and aluminium. NPT tapered 1:16.		V	A	1/16-1" NPT
General Information		-	-	-



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TOOLBITS & MISCELLANEOUS

Product		Code	Spec.	Range
Square Toolbits - HSS Blanks for the manufacture of tools for high tensile and heat resistant steels where high temperatures and abrasion may be expected during machining, 10° bevel at both ends.		601 602	BASED ON ISO 5421	4-25 3/16-3/4
Square Toolbits - HSS-Co8 Blanks for the manufacture of tools for high tensile and heat resistant steels where high temperatures and abrasion may be expected during machining, 10° bevel at both ends.		621 622	BASED ON ISO 5421	5-25 3/16-1"



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TOOLBITS & MISCELLANEOUS... from previous page

Product		Code	Spec.	Range
Round Toolbits - HSS Blanks for the manufacture of tools for high tensile and heat resistant steels where high temperatures and abrasion may be expected during machining.		605 606	BASED ON ISO 5421	4-20 1/4-5/8
Round Toolbits - HSS-Co8 Blanks for the manufacture of tools for high tensile and heat resistant steels where high temperatures and abrasion may be expected during machining.		625	BASED ON ISO 5421	4-25
Double Bevel Parting Blades - HSS-Co8 For parting off and slotting applications, with increased wear resistance.		644 647	ISO 5421	3-4 3/32-3/16
Hi-Cut Chassis Punches Used for punching holes in sheetmetal up to 1.6mm in thickness		990	-	12.7-51
Core Drill Cutters (Sluggers) with Pilot Pin - HSS For cutting holes in various materials with high speed.		9RA	-	12-65
Solid Carbide Tipped Core Drill Cutters (Sluggers) - HSS For cutting holes in various materials with high speed.		9RC	-	12-46
Engineers Black Book - Third Edition The ENGINEERS BLACK BOOK is a Technical Engineering Resource Book consolidating the most commonly used Engineering information into a easy-to-read and convenient user friendly format.		EHB0001 EHB0001LRG	-	-
Fastener Black Book - First Edition The FASTENER BLACK BOOK is a Technical Fastener Resource Book consolidating the abundance of Fastener information into a easy-to-read and convenient user friendly format.		EHB0002 EHB0002LRG	-	-
Electrical Black Book - Australia / New Zealand First Edition The ELECTRICAL BLACK BOOK is a Technical Electrical Resource Book consolidating the abundance of Electrical information into a easy-to-read and convenient user friendly format.		EHB0004	-	-
Drill Point Sharpening Gauge The DRILL POINT SHARPENING GAUGE is the tool most frequently used to check the drill point during the sharpening operation.		EHB0005	-	-
General Information		-	-	-



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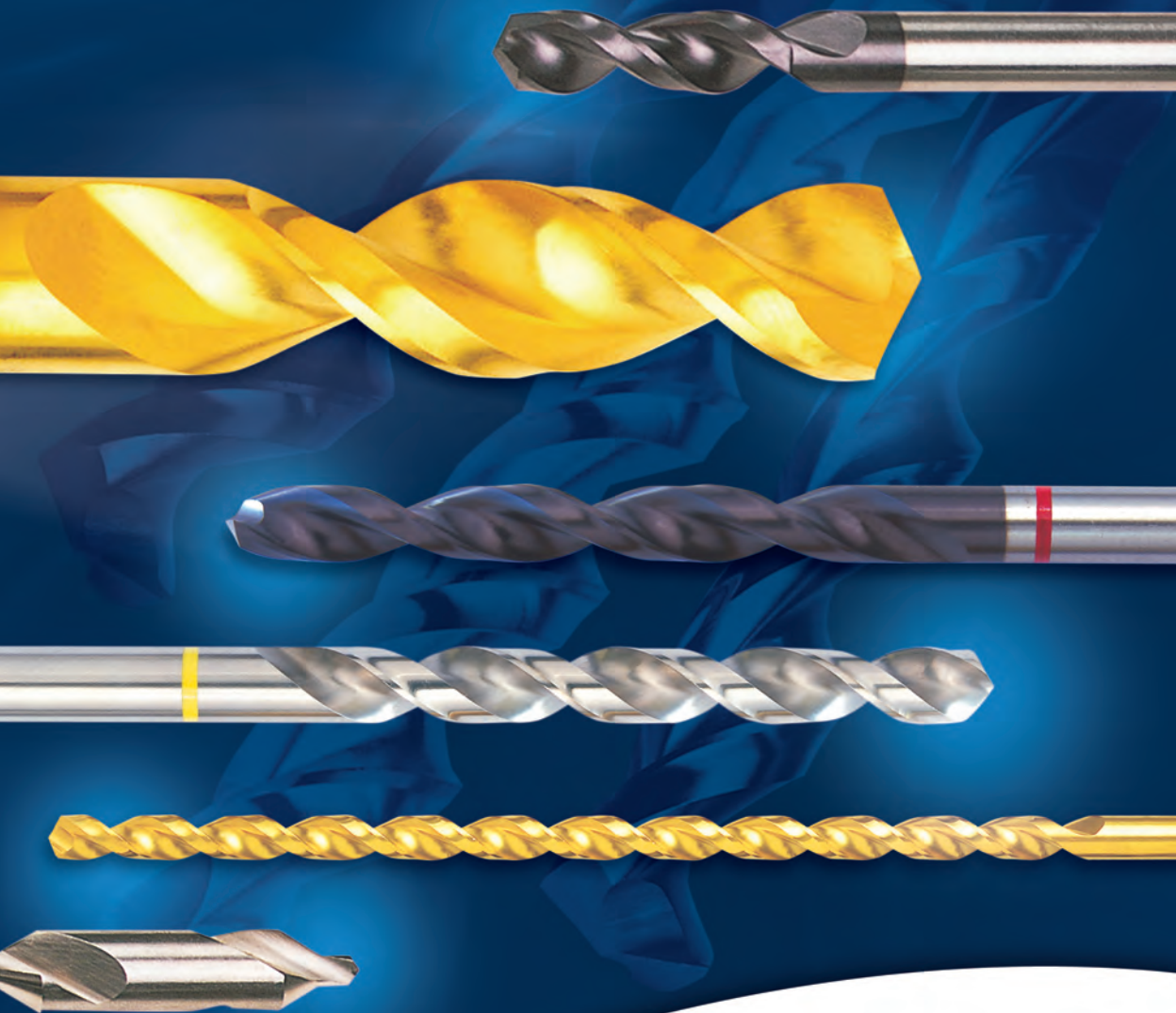
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301	●	●	●	●	●	●	●	●	●		●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○				
301	○	○	○																			○				○	○									
302-303	●	●	●	●	●	●	○	○	○		●	●	●	●																						
303	●	●	●	●	●	●	●	●	●		●	●	●	●																						
304																																				
305																																				
306																																				
306																																				
310-312																																				





shaping your dreams



OSG GROUP COMPANY

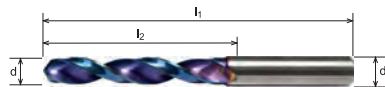
S T R A I G H T S H A N K D R I L L S



OSG GROUP COMPANY

Solid Carbide Coolant Feed MultiForce Jobber Drills

High production drilling in multiple materials.



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	○	●	●	●	●	●	●	●	●	○	○	○				●	●	●	○	○	○	○	○				○	○	○	○

d	d ₁	l ₂	l ₁	Code	Price
3	6	28	66	MFD-05C-0300RA	
3.3	6	28	66	MFD-05C-0330RA	
3.5	6	28	66	MFD-05C-0350RA	
4	6	36	74	MFD-05C-0400RA	
4.2	6	36	74	MFD-05C-0420RA	
4.5	6	36	74	MFD-05C-0450RA	
5	6	44	82	MFD-05C-0500RA	
5.5	6	44	82	MFD-05C-0550RA	
6	6	44	82	MFD-05C-0600RA	
6.8	8	53	91	MFD-05C-0680RA	
7	8	53	91	MFD-05C-0700RA	
8	8	53	91	MFD-05C-0800RA	
8.5	10	61	103	MFD-05C-0850RA	
9	10	61	103	MFD-05C-0900RA	
10	10	61	103	MFD-05C-1000RA	
10.2	12	71	118	MFD-05C-1020RA	
11	12	71	118	MFD-05C-1100RA	
12	12	71	118	MFD-05C-1200RA	

Code
MFD-05C

Properties

SPLIT POINT

mm

WORKS STD.

SOLID CARBIDE

5xD

TYPE N

SHRINK FIT

140°

RAINBOW COATED

pg 55



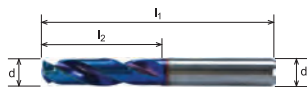
STRAIGHT
SHANK DRILLS



shaping your dreams

Solid Carbide Coolant Feed MultiForce Stub Drills

High production drilling in multiple materials.



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	○	●	●	●	○	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

d	d ₁	l ₂	l ₁	Code	Price
3	6	20	62	MFD-03C-0300RA	
4	6	24	66	MFD-03C-0400RA	
5	6	28	66	MFD-03C-0500RA	
6	6	28	66	MFD-03C-0600RA	
8	8	41	79	MFD-03C-0800RA	
10	10	47	89	MFD-03C-1000RA	
12	12	55	102	MFD-03C-1200RA	

Code

MFD-03C

Properties


**SPLIT
POINT**

mm

WORKS
STD.

**SOLID
CARBIDE**

3xD

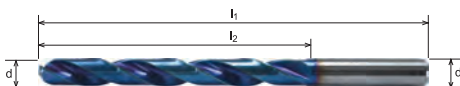
**TYPE
N**

SHRINK
FIT

**RAINBOW
COATED**


Solid Carbide Coolant Feed MultiForce Long Series Drills

High production drilling in multiple materials.



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	○	●	●	●	○	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

d	d ₁	l ₂	l ₁	Code	Price
3	4	30	70	MFD-08C-0300RA	
4	4	40	80	MFD-08C-0400RA	
5	6	50	90	MFD-08C-0500RA	
6	6	57	97	MFD-08C-0600RA	
8	8	76	116	MFD-08C-0800RA	
10	10	95	139	MFD-08C-1000RA	
12	12	114	163	MFD-08C-1200RA	

Code

MFD-08C

Properties


**SPLIT
POINT**

mm

WORKS
STD.

**SOLID
CARBIDE**

8-10
xD

**TYPE
N**

SHRINK
FIT

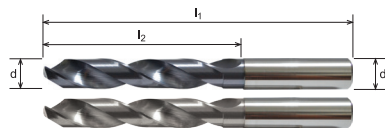
**RAINBOW
COATED**




OSG GROUP COMPANY

Solid Carbide Jobber Drills

High production drilling.



Code
01J

P						M				K				Ti			Ni			Cu				N				Syn			H					
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4		
●	●	●	●	●	●	○	○	○	○	●	●	●	●	○	○	○				●	●	●	○	○	○	○	○	○	○				○	○	○	○

Properties		
SPLIT POINT		
mm	DIN 6537L	SOLID CARBIDE
5xD	TYPE N	140°
h8	30°	COATED UNCOATED
pg 55-56		

d	d1	l2	l1	Drilling Depth	Coated		Uncoated	
					Code	Price	Code	Price
1	4	8	55	6	01J0100F		01J0100	
1.5	4	12	55	9	01J0150F		01J0150	
2	4	21	57	16	01J0200F		01J0200	
2.5	4	21	57	16	01J0250F		01J0250	
3	6	28	66	23	01J0300F		01J0300	
3.3	6	28	66	23	01J0330F		01J0330	
3.5	6	28	66	23	01J0350F		01J0350	
4	6	36	74	29	01J0400F		01J0400	
4.2	6	36	74	29	01J0420F		01J0420	
4.5	6	36	74	29	01J0450F		01J0450	
5	6	44	82	35	01J0500F		01J0500	
5.5	6	44	82	35	01J0550F		01J0550	
6	6	44	82	35	01J0600F		01J0600	
6.3	8	53	91	43	01J0630F		01J0630	
6.5	8	53	91	43	01J0650F		01J0650	
6.8	8	53	91	43	01J0680F		01J0680	
7	8	53	91	43	01J0700F		01J0700	
7.5	8	53	91	43	01J0750F		01J0750	
8	8	53	91	43	01J0800F		01J0800	
8.5	10	61	103	49	01J0850F		01J0850	
9	10	61	103	49	01J0900F		01J0900	
9.5	10	61	103	49	01J0950F		01J0950	
10	10	61	103	49	01J1000F		01J1000	
10.2	12	71	118	56	01J1020F		01J1020	
10.5	12	71	118	56	01J1050F		01J1050	
11	12	71	118	56	01J1100F		01J1100	
11.5	12	71	118	56	01J1150F		01J1150	
12	12	71	118	56	01J1200F		01J1200	
12.5	14	77	124	60	01J1250F		01J1250	
12.7	14	77	124	60	01J1270F		01J1270	
13	14	77	124	60	01J1300F		01J1300	
13.5	14	77	124	60	01J1350F		01J1350	
14	14	77	124	60	01J1400F		01J1400	



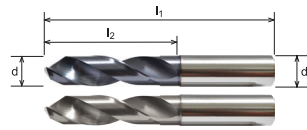
STRAIGHT SHANK DRILLS



shaping your dreams

Solid Carbide Stub Drills

High production drilling.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	○	○	○	○	●	●	●	●	○	○	○				●	●	●	○	○	○	○	○				○	○	○	○

Code
01S

d	d1	l2	l1	Drilling Depth	Coated		Uncoated	
					Code	Price	Code	Price
#1	1	6	26	5	01S0100F		01S0100	
#1.5	1.5	9	32	7	01S0150F		01S0150	
#2	2	12	38	9	01S0200F		01S0200	
#2.5	2.5	14	43	11	01S0250F		01S0250	
3	6	20	62	14	01S0300F		01S0300	
3.3	6	20	62	14	01S0330F		01S0330	
3.5	6	20	62	14	01S0350F		01S0350	
4	6	24	66	17	01S0400F		01S0400	
4.2	6	24	66	17	01S0420F		01S0420	
4.5	6	24	66	17	01S0450F		01S0450	
5	6	28	66	20	01S0500F		01S0500	
5.5	6	28	66	20	01S0550F		01S0550	
6	6	28	66	20	01S0600F		01S0600	
6.3	8	34	79	24	01S0630F		01S0630	
6.5	8	34	79	24	01S0650F		01S0650	
6.8	8	34	79	24	01S0680F		01S0680	
7	8	34	79	24	01S0700F		01S0700	
7.5	8	41	79	29	01S0750F		01S0750	
8	8	41	79	29	01S0800F		01S0800	
8.5	10	47	89	35	01S0850F		01S0850	
9	10	47	89	35	01S0900F		01S0900	
9.5	10	47	89	35	01S0950F		01S0950	
10	10	47	89	35	01S1000F		01S1000	
10.2	12	55	102	40	01S1020F		01S1020	
10.5	12	55	102	40	01S1050F		01S1050	
11	12	55	102	40	01S1100F		01S1100	
11.5	12	55	102	40	01S1150F		01S1150	
12	12	55	102	40	01S1200F		01S1200	
12.5	14	60	107	43	01S1250F		01S1250	
12.7	14	60	107	43	01S1270F		01S1270	
13	14	60	107	43	01S1300F		01S1300	
13.5	14	60	107	43	01S1350F		01S1350	
14	14	60	107	43	01S1400F		01S1400	

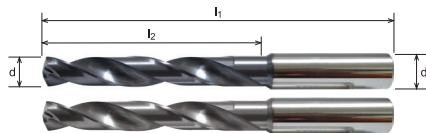
Properties		
SPLIT POINT		
mm	DIN 6537K	SOLID CARBIDE
3xD	TYPE N	140°
h8	30°	COATED UNCOATED
pg 56-57		

DIN 6539









Coolant Feed Solid Carbide Jobber Drills

High production drilling.



Code
OCJ

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	○	○	○	○	●	●	●	●	○	○	○				●	●	●	●	○	○	○	○				○	○	○	○

Properties		
 SPLIT POINT		
mm	DIN 6537L	SOLID CARBIDE
5xD	TYPE N	
		
COATED		
UNCOATED	pg 57-58	

d	d1	l2	l1	Drilling Depth	Coated		Uncoated	
					Code	Price	Code	Price
6	6	44	82	35	-		OCJ0600	
6.3	8	53	91	43	OCJ0630F		-	
7	8	53	91	43	OCJ0700F		-	
9.5	10	61	103	49	OCJ0950F		-	
11	12	71	118	56	OCJ1100F		-	
11.5	12	71	118	56	OCJ1150F		OCJ1150	
12	12	71	118	56	OCJ1200F		OCJ1200	
12.5	14	77	124	60	OCJ1250F		-	
13	14	77	124	60	OCJ1300F		-	
13.5	14	77	124	60	OCJ1350F		-	

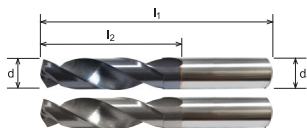
Not available once current stock is depleted



STRAIGHT
SHANK DRILLS

Coolant Feed Solid Carbide Stub Drills

High production drilling.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	○	○	○		●	●	●	●	○	○	○				●	●	●	●	○	○	○	○				○	○	○	○

d	d1	l2	l1	Drilling Depth	Coated		Uncoated	
					Code	Price	Code	Price
6.3	8	34	79	24	OCS0630F	-	-	-
6.5	8	34	79	24	OCS0650F	-	-	-
7	8	34	79	24	OCS0700F	-	-	-
7.5	8	41	79	29	OCS0750F	-	OCS0750	-
8.5	10	47	89	35	OCS0850F	-	-	-
9.5	10	47	89	35	OCS0950F	-	-	-
10	10	47	89	35	OCS1000F	-	OCS1000	-
10.2	12	55	102	40	OCS1020F	-	-	-
10.5	12	55	102	40	OCS1050F	-	-	-
11	12	55	102	40	OCS1100F	-	-	-
11.5	12	55	102	40	OCS1150F	-	OCS1150	-
12	12	55	102	40	OCS1200F	-	OCS1200	-
12.5	14	60	107	43	OCS1250F	-	-	-
12.7	14	60	107	43	OCS1270F	-	-	-
13	14	60	107	43	OCS1300F	-	-	-
13.5	14	60	107	43	OCS1350F	-	-	-

Not available once current stock is depleted



Code
OCS

Properties		
SPLIT POINT		
mm	DIN 6537K	SOLID CARBIDE
3xD	TYPE N	140°
COATED UNCOATED	h8 30°	pg 58-59



Straight Shank Jobber Drill Sets and Counter Dispensers

For various drilling applications.

Codes

101
106 - 107
164, 177
1AQ
1BB, 1G7
1R5, 1TT
1X1, 1X5

Properties

mm inch	DIN 338	HSS Co5
5xD	SEE APPROPRIATE CATALOGUE PAGE	



1X50040

1060040

1TT0040



1019001

Size Range	No. of Drills	Code	Price
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Code 1X1 Sets - Page 9-10

1 - 13 x 0.5	25	1X10040	
1/16 - 1/2 x 1/64	29	1X10030	

Code 1X2/1X5 Sets - Page 11-12

1 - 13 x 0.5	25	1X50040	
1/16 - 1/2 x 1/64	29	1X50030	

Code 101, 102 Sets - Page 14-16

1 - 10 x 1	10	1060025	
1 - 10 x 0.5	19	1060030	
1 - 13 x 1	13	1060035	
1 - 13 x 0.5	25	1060040	
1 - 6 x 0.1	51	1060070	
6 - 10 x 0.1	41	1060080	
1/16 - 1/2 x 1/64	29	1070030	
1/16 - 1/2 x 1/32	15	1070040	

Code 1TT Set - Page 17-18

1 - 13 x 0.5	25	1TT0040	
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Code 177 Set - Page 20-21

1 - 13 x 0.5	25	1770025	
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Code 164 Set - Page 36-39

1 - 13 x 0.5	25	1640025	
1 - 13 x 0.5	25	1640025A	

Code 1AQ Set - Page 26-27

1 - 13 x 0.5	25	1AQ0040	
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Code 1BB Set - Page 28

1 - 13 x 0.5	25	1BB0040	
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Code 1G7 Set - Page 29

1 - 13 x 0.5	25	1G70040	
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Code 1R5 Set - Page 30

1 - 13 x 0.5	25	1R50040	
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Not available once current stock is depleted

Description	Code	Price
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Code 101 Counter Dispenser - Page 14-16

10 each of 1, 2, 3, 3.2, 4,
4.8, 5, 6, 6.5, 7, 8, 9mm and
5 each of 1.2, 1.5, 1.8, 2.2,
2.5, 2.8, 3.5, 3.8, 4.2, 4.5,
5.2, 5.5, 5.8, 6.2, 7.5, 8.5,
9.5, 10, 10.5, 11, 11.5, 12,
12.5, 13mm

with Counter Dispenser 1019000

Counter Dispenser only 1019001



1019005

Description	Code	Price
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Code 101 Counter Dispenser Case - Page 14-16

5 each of 1, 1.5, 2, 2.5, 3,
3.5, 4, 4.5, 5, 5.5, 6, 6.5, 7,
7.5, 8, 8.5, 9, 9.5, 10mm with

Counter Dispenser Case 1019005



X-Ratio Straight Shank Jobber Drills

For general purpose drilling.



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●							●	●														○	○	○	○						

d		l ₂	l ₁	Code	Price
mm	inch				
1		12	34	1X10100	
1.1		14	36	1X10110	
1.191	3/64	16	38	1X10119	
1.2		16	38	1X10120	
1.3		16	38	1X10130	
1.4		18	40	1X10140	
1.5		18	40	1X10150	
1.587	1/16	20	43	1X10159	
1.6		20	43	1X10160	
1.7		20	43	1X10170	
1.8		22	46	1X10180	
1.9		22	46	1X10190	
1.984	5/64	24	49	1X10198	
2		24	49	1X10200	
2.1		24	49	1X10210	
2.2		27	53	1X10220	
2.3		27	53	1X10230	
2.381	3/32	30	57	1X10238	
2.4		30	57	1X10240	
2.5		30	57	1X10250	
2.6		30	57	1X10260	
2.7		33	61	1X10270	
2.778	7/64	33	61	1X10278	
2.8		33	61	1X10280	
2.9		33	61	1X10290	
3		33	61	1X10300	
3.1		36	65	1X10310	
3.175	1/8	36	65	1X10318	
3.2		36	65	1X10320	
3.3		36	65	1X10330	
3.4		39	70	1X10340	
3.5		39	70	1X10350	
3.572	9/64	39	70	1X10357	
3.6		39	70	1X10360	
3.7		39	70	1X10370	
3.8		43	75	1X10380	
3.9		43	75	1X10390	
3.969	5/32	43	75	1X10397	
4		43	75	1X10400	
4.1		43	75	1X10410	
4.2		43	75	1X10420	
4.3		47	80	1X10430	
4.366	11/64	47	80	1X10437	
4.4		47	80	1X10440	
4.5		47	80	1X10450	
4.6		47	80	1X10460	
4.7		47	80	1X10470	
4.762	3/16	52	86	1X10476	
4.8		52	86	1X10480	
4.9		52	86	1X10490	

d		l ₂	l ₁	Code	Price
mm	inch				
5		52	86	1X10500	
5.1		52	86	1X10510	
5.159	13/64	52	86	1X10516	
5.2		52	86	1X10520	
5.3		52	86	1X10530	
5.4		57	93	1X10540	
5.5		57	93	1X10550	
5.556	7/32	57	93	1X10556	
5.6		57	93	1X10560	
5.7		57	93	1X10570	
5.8		57	93	1X10580	
5.9		57	93	1X10590	
5.953	15/64	57	93	1X10595	
6		57	93	1X10600	
6.1		63	101	1X10610	
6.2		63	101	1X10620	
6.3		63	101	1X10630	
6.350	1/4	63	101	1X10635	
6.4		63	101	1X10640	
6.5		63	101	1X10650	
6.6		63	101	1X10660	
6.7		63	101	1X10670	
6.747	17/64	69	109	1X10675	
6.8		69	109	1X10680	
6.9		69	109	1X10690	
7		69	109	1X10700	
7.1		69	109	1X10710	
7.144	9/32	69	109	1X10714	
7.2		69	109	1X10720	
7.3		69	109	1X10730	
7.4		69	109	1X10740	
7.5		69	109	1X10750	
7.541	19/64	75	117	1X10754	
7.6		75	117	1X10760	
7.7		75	117	1X10770	
7.8		75	117	1X10780	
7.9		75	117	1X10790	
7.937	5/16	75	117	1X10794	
8		75	117	1X10800	
8.1		75	117	1X10810	
8.2		75	117	1X10820	
8.3		75	117	1X10830	
8.334	21/64	75	117	1X10833	
8.4		75	117	1X10840	
8.5		75	117	1X10850	
8.6		81	125	1X10860	
8.7		81	125	1X10870	
8.731	11/32	81	125	1X10873	
8.8		81	125	1X10880	

Continued on next page...

Code
1X1

Properties
STANDARD POINT
mm inch
DIN 338
HSS
5xD
TYPE N
118°
h8
30°
BRIGHT FINISH
pg 59

QTY
↓
10 ≤ 9.5mm
5 ≤ 13.0mm
1 > 13.0mm



X-Ratio Straight Shank Jobber Drills

For general purpose drilling.



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●						●	●													○	○	○	○							

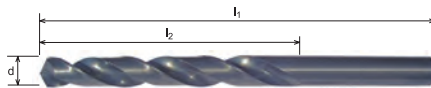
d		l ₂	l ₁	Code	Price	d		l ₂	l ₁	Code	Price
mm	inch					mm	inch				
... from previous page						12.3		101	151	1X11230	
8.9		81	125	1X10890		12.303	31/64	101	151	1X11229	
9		81	125	1X10900		12.4		101	151	1X11240	
9.1		81	125	1X10910		12.5		101	151	1X11250	
9.128	23/64	81	125	1X10913		12.6		101	151	1X11260	
9.2		81	125	1X10920		12.7		101	151	1X11270	
9.3		81	125	1X10930		12.700	1/2	101	151	1X11269	
9.4		81	125	1X10940		12.8		101	151	1X11280	
9.5		81	125	1X10950		12.9		101	151	1X11290	
9.525	3/8	87	133	1X10953		13		101	151	1X11300	
9.6		87	133	1X10960		13.097	33/64	101	151	1X11309	
9.7		87	133	1X10970		13.1		101	151	1X11310	
9.8		87	133	1X10980		13.2		101	151	1X11320	
9.9		87	133	1X10990		13.25		108	160	1X11325	
9.922	25/64	87	133	1X10992		13.3		108	160	1X11330	
10		87	133	1X11000		13.4		108	160	1X11340	
10.1		87	133	1X11010		13.494	17/32	108	160	1X11349	
10.2		87	133	1X11020		13.5		108	160	1X11350	
10.3		87	133	1X11030		13.6		108	160	1X11360	
10.319	13/32	87	133	1X11032		13.7		108	160	1X11370	
10.4		87	133	1X11040		13.8		108	160	1X11380	
10.5		87	133	1X11050		13.891	35/64	108	160	1X11389	
10.6		87	133	1X11060		14		108	160	1X11400	
10.7		94	142	1X11070		14.25		114	169	1X11425	
10.716	27/64	94	142	1X11072		14.287	9/16	114	169	1X11429	
10.8		94	142	1X11080		14.5		114	169	1X11450	
10.9		94	142	1X11090		14.684	37/64	114	169	1X11468	
11		94	142	1X11100		14.75		114	169	1X11475	
11.1		94	142	1X11110		15		114	169	1X11500	
11.112	7/16	94	142	1X11111		15.25		120	178	1X11525	
11.2		94	142	1X11120		15.5		120	178	1X11550	
11.3		94	142	1X11130		15.75		120	178	1X11575	
11.4		94	142	1X11140		15.875	5/8	120	178	1X11588	
11.5		94	142	1X11150		16		120	178	1X11600	
11.509	29/64	94	142	1X11151		16.5		125	184	1X11650	
11.6		94	142	1X11160		17		125	184	1X11700	
11.7		94	142	1X11170		17.5		130	191	1X11750	
11.8		94	142	1X11180		18		130	191	1X11800	
11.9		101	151	1X11190		18.5		135	198	1X11850	
11.906	15/32	101	151	1X11191		19		135	198	1X11900	
12		101	151	1X11200		19.5		140	205	1X11950	
12.1		101	151	1X11210		20		140	205	1X12000	

Not available once current stock is depleted



X-Ratio Straight Shank Jobber Drills

For general purpose drilling.



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●						●	●													○	○	○	○							

d		l ₂	l ₁	Code	Price
mm	inch				
1		12	34	1X20100	
1.1		14	36	1X20110	
1.191	3/64	16	38	1X20119	
1.2		16	38	1X20120	
1.3		16	38	1X20130	
1.4		18	40	1X20140	
1.5		18	40	1X20150	
1.587	1/16	20	43	1X20159	
1.6		20	43	1X20160	
1.7		20	43	1X20170	
1.8		22	46	1X20180	
1.9		22	46	1X20190	
1.984	5/64	24	49	1X20198	
2		24	49	1X20200	
2.1		24	49	1X20210	
2.2		27	53	1X20220	
2.3		27	53	1X20230	
2.381	3/32	30	57	1X20238	
2.4		30	57	1X20240	
2.5		30	57	1X20250	
2.6		30	57	1X20260	
2.7		33	61	1X20270	
2.778	7/64	33	61	1X20278	
2.8		33	61	1X20280	
2.9		33	61	1X20290	
3		33	61	1X50300	
3.1		36	65	1X50310	
3.175	1/8	36	65	1X50318	
3.2		36	65	1X50320	
3.3		36	65	1X50330	
3.4		39	70	1X50340	
3.5		39	70	1X50350	
3.572	9/64	39	70	1X50357	
3.6		39	70	1X50360	
3.7		39	70	1X50370	
3.8		43	75	1X50380	
3.9		43	75	1X50390	
3.969	5/32	43	75	1X50397	
4		43	75	1X50400	
4.1		43	75	1X50410	
4.2		43	75	1X50420	
4.3		47	80	1X50430	
4.366	11/64	47	80	1X50437	
4.4		47	80	1X50440	
4.5		47	80	1X50450	
4.6		47	80	1X50460	
4.7		47	80	1X50470	
4.762	3/16	52	86	1X50476	
4.8		52	86	1X50480	
4.9		52	86	1X50490	

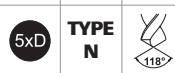
d		l ₂	l ₁	Code	Price
mm	inch				
5		52	86	1X50500	
5.1		52	86	1X50510	
5.159	13/64	52	86	1X50516	
5.2		52	86	1X50520	
5.3		52	86	1X50530	
5.4		57	93	1X50540	
5.5		57	93	1X50550	
5.556	7/32	57	93	1X50556	
5.6		57	93	1X50560	
5.7		57	93	1X50570	
5.8		57	93	1X50580	
5.9		57	93	1X50590	
5.953	15/64	57	93	1X50595	
6		57	93	1X50600	
6.1		63	101	1X50610	
6.2		63	101	1X50620	
6.3		63	101	1X50630	
6.350	1/4	63	101	1X50635	
6.4		63	101	1X50640	
6.5		63	101	1X50650	
6.6		63	101	1X50660	
6.7		63	101	1X50670	
6.747	17/64	69	109	1X50675	
6.8		69	109	1X50680	
6.9		69	109	1X50690	
7		69	109	1X50700	
7.1		69	109	1X50710	
7.144	9/32	69	109	1X50714	
7.2		69	109	1X50720	
7.3		69	109	1X50730	
7.4		69	109	1X50740	
7.5		69	109	1X50750	
7.541	19/64	75	117	1X50754	
7.6		75	117	1X50760	
7.7		75	117	1X50770	
7.8		75	117	1X50780	
7.9		75	117	1X50790	
7.937	5/16	75	117	1X50794	
8		75	117	1X50800	
8.1		75	117	1X50810	
8.2		75	117	1X50820	
8.3		75	117	1X50830	
8.334	21/64	75	117	1X50833	
8.4		75	117	1X50840	
8.5		75	117	1X50850	
8.6		81	125	1X50860	
8.7		81	125	1X50870	
8.731	11/32	81	125	1X50873	
8.8		81	125	1X50880	

Continued on next page...

Codes

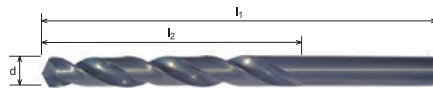
1X2, 1X5

Properties







X-Ratio Straight Shank Jobber Drills


For general purpose drilling.



Codes
1X2, 1X5

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●							●	●													○	○	○	○							

Properties		
 STANDARD POINT sizes below 3.0 mm		
 SPLIT POINT 3.0 mm and above		
mm inch	DIN 338	HSS
5xD	TYPE N	
	30°	BLUE FINISH
pg 59		

QTY ↓ 
10 ≤ 9.5mm 5 ≤ 13.0mm 1 > 13.0mm

d		l ₂	l ₁	Code	Price
mm	inch				
... from previous page					
8.9		81	125	1X50890	
9		81	125	1X50900	
9.1		81	125	1X50910	
9.128	23/64	81	125	1X50913	
9.2		81	125	1X50920	
9.3		81	125	1X50930	
9.4		81	125	1X50940	
9.5		81	125	1X50950	
9.525	3/8	87	133	1X50953	
9.6		87	133	1X50960	
9.7		87	133	1X50970	
9.8		87	133	1X50980	
9.9		87	133	1X50990	
9.922	25/64	87	133	1X50992	
10		87	133	1X51000	
10.1		87	133	1X51010	
10.2		87	133	1X51020	
10.3		87	133	1X51030	
10.319	13/32	87	133	1X51032	
10.4		87	133	1X51040	
10.5		87	133	1X51050	
10.6		87	133	1X51060	
10.7		94	142	1X51070	
10.716	27/64	94	142	1X51072	
10.8		94	142	1X51080	
10.9		94	142	1X51090	
11		94	142	1X51100	
11.1		94	142	1X51110	
11.112	7/16	94	142	1X51111	
11.2		94	142	1X51120	
11.3		94	142	1X51130	
11.4		94	142	1X51140	
11.5		94	142	1X51150	
11.509	29/64	94	142	1X51151	
11.6		94	142	1X51160	
11.7		94	142	1X51170	
11.8		94	142	1X51180	
11.9		101	151	1X51190	
11.906	15/32	101	151	1X51191	
12		101	151	1X51200	
12.1		101	151	1X51210	

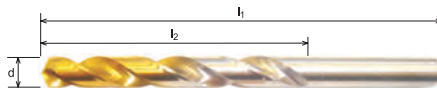
d		l ₂	l ₁	Code	Price
mm	inch				
12.3		101	151	1X51230	
12.303	31/64	101	151	1X51229	
12.4		101	151	1X51240	
12.5		101	151	1X51250	
12.6		101	151	1X51260	
12.7		101	151	1X51270	
12.700	1/2	101	151	1X51269	
12.8		101	151	1X51280	
12.9		101	151	1X51290	
13		101	151	1X51300	
13.097	33/64	101	151	1X51309	
13.1		101	151	1X51310	
13.2		101	151	1X51320	
13.25		108	160	1X51325	
13.3		108	160	1X51330	
13.4		108	160	1X51340	
13.494	17/32	108	160	1X51349	
13.5		108	160	1X51350	
13.6		108	160	1X51360	
13.7		108	160	1X51370	
13.8		108	160	1X51380	
13.891	35/64	108	160	1X51389	
14		108	160	1X51400	
14.25		114	169	1X51425	
14.287	9/16	114	169	1X51429	
14.5		114	169	1X51450	
14.684	37/64	114	169	1X51468	
14.75		114	169	1X51475	
15		114	169	1X51500	
15.25		120	178	1X51525	
15.5		120	178	1X51550	
15.75		120	178	1X51575	
15.875	5/8	120	178	1X51588	
16		120	178	1X51600	
16.5		125	184	1X51650	
17		125	184	1X51700	
17.5		130	191	1X51750	
18		130	191	1X51800	
18.5		135	198	1X51850	
19		135	198	1X51900	
19.5		140	205	1X51950	
20		140	205	1X52000	

Not available once current stock is depleted



X-Ratio Straight Shank Jobber Drills

For general purpose drilling.










P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●							●	●	○	○							○	○	○	○	○	○	○	○	○	○	○				


d		l ₂	l ₁	Code	Price	d		l ₂	l ₁	Code	Price
mm	inch					mm	inch				
1		12	34	1X30100		5		52	86	1X60500	
1.1		14	36	1X30110		5.5		57	93	1X60550	
1.2		16	38	1X30120		6		57	93	1X60600	
1.3		16	38	1X30130		6.5		63	101	1X60650	
1.4		18	40	1X30140		7		69	109	1X60700	
1.5		18	40	1X30150		7.5		69	109	1X60750	
1.6		20	43	1X30160		8		75	117	1X60800	
1.8		22	46	1X30180		8.5		75	117	1X60850	
2		24	49	1X30200		9		81	125	1X60900	
2.381	3/32	30	57	1X30238		9.5		81	125	1X60950	
2.5		30	57	1X30250		10		87	133	1X61000	
3		33	61	1X60300		10.3		87	133	1X61030	
3.5		39	70	1X60350		10.5		87	133	1X61050	
3.6		39	70	1X60360		11		94	142	1X61100	
3.969	5/32	43	75	1X60397		11.5		94	142	1X61150	
4		43	75	1X60400		12		101	151	1X61200	
4.2		43	75	1X60420		12.5		101	151	1X61250	
4.5		47	80	1X60450		13		101	151	1X61300	

Not available once current stock is depleted

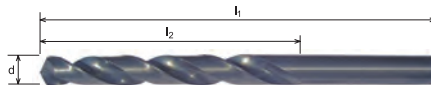


Codes
1X3, 1X6

Properties		
		
STANDARD POINT sizes below 3.0 mm		
		
SPLIT POINT 3.0 mm and above		
mm inch	DIN 338	HSS
	TYPE N	
	30° 	BRIGHT FINISH WITH TIN TIP
	pg 59	

QTY

10 ≤ 9.5mm 5 ≤ 13.0mm 1 > 13.0mm












Codes

101 - 102

P					M				K				Ti			Ni			Cu				N				Syn			H				
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

Properties		
 STANDARD POINT sizes below 3.0 mm		
 SPLIT POINT 3.0 mm and above		
mm inch	DIN 338	HSS
5xD	TYPE N	
		BLUE FINISH
		

QTY ↓ 
10 ≤ 9.5mm 5 ≤ 13.0mm 1 > 13.0mm

d		l ₂	l ₁	Code	Price
mm	inch				
0.3		3	19	1010030	
0.35		4	19	1010035	
0.397	1/64	5	20	1020040	
0.4		5	20	1010040	
0.45		5	20	1010045	
0.5		6	22	1010050	
0.55		7	24	1010055	
0.6		7	24	1010060	
0.62		8	26	1010062	
0.7		9	28	1010070	
0.75		9	28	1010075	
0.794	1/32	10	30	1020079	
0.8		10	30	1010080	
0.88		11	32	1010088	
0.9		11	32	1010090	
0.92		11	32	1010092	
1		12	34	1010100	
1.05		12	34	1010105	
1.1		14	36	1010110	
1.15		14	36	1010115	
1.191	3/64	16	38	1020119	
1.2		16	38	1010120	
1.25		16	38	1010125	
1.3		16	38	1010130	
1.35		18	40	1010135	
1.4		18	40	1010140	
1.45		18	40	1010145	
1.5		18	40	1010150	
1.55		20	43	1010155	
1.587	1/16	20	43	1020159	
1.6		20	43	1010160	
1.65		20	43	1010165	
1.7		20	43	1010170	
1.75		22	46	1010175	
1.8		22	46	1010180	
1.85		22	46	1010185	
1.9		22	46	1010190	
1.95		24	49	1010195	
1.984	5/64	24	49	1020198	
2		24	49	1010200	
2.05		24	49	1010205	
2.1		24	49	1010210	
2.15		27	53	1010215	
2.2		27	53	1010220	
2.25		27	53	1010225	
2.3		27	53	1010230	
2.35		27	53	1010235	
2.381	3/32	30	57	1020238	
2.4		30	57	1010240	
2.45		30	57	1010245	

d		l ₂	l ₁	Code	Price
mm	inch				
2.5		30	57	1010250	
2.55		30	57	1010255	
2.6		30	57	1010260	
2.65		30	57	1010265	
2.7		33	61	1010270	
2.75		33	61	1010275	
2.778	7/64	33	61	1020278	
2.8		33	61	1010280	
2.85		33	61	1010285	
2.9		33	61	1010290	
2.95		33	61	1010295	
3		33	61	1010300	
3.1		36	65	1010310	
3.175	1/8	36	65	1020318	
3.2		36	65	1010320	
3.25		36	65	1010325	
3.3		36	65	1010330	
3.4		39	70	1010340	
3.5		39	70	1010350	
3.572	9/64	39	70	1020357	
3.6		39	70	1010360	
3.7		39	70	1010370	
3.8		43	75	1010380	
3.9		43	75	1010390	
3.969	5/32	43	75	1020397	
4		43	75	1010400	
4.1		43	75	1010410	
4.2		43	75	1010420	
4.25		43	75	1010425	
4.3		47	80	1010430	
4.366	11/64	47	80	1020437	
4.4		47	80	1010440	
4.5		47	80	1010450	
4.6		47	80	1010460	
4.7		47	80	1010470	
4.762	3/16	52	86	1020476	
4.8		52	86	1010480	
4.9		52	86	1010490	
5		52	86	1010500	
5.1		52	86	1010510	
5.159	13/64	52	86	1020516	
5.2		52	86	1010520	
5.25		52	86	1010525	
5.3		52	86	1010530	
5.4		57	93	1010540	
5.5		57	93	1010550	
5.556	7/32	57	93	1020556	
5.6		57	93	1010560	
5.7		57	93	1010570	

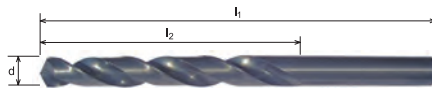
Continued on next page...





Straight Shank Jobber Drills

For precision drilling.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●							●	●	○	○							○	○	○	○	○	○	○	○	○	○					

d		l ₂	l ₁	Code	Price
mm	inch				

... from previous page

5.75		57	93	1010575	
5.8		57	93	1010580	
5.9		57	93	1010590	
5.953	15/64	57	93	1020595	
6		57	93	1010600	
6.1		63	101	1010610	
6.2		63	101	1010620	
6.25		63	101	1010625	
6.3		63	101	1010630	
6.350	1/4	63	101	1020635	
6.4		63	101	1010640	
6.5		63	101	1010650	
6.6		63	101	1010660	
6.7		63	101	1010670	
6.747	17/64	69	109	1020675	
6.75		69	109	1010675	
6.8		69	109	1010680	
6.9		69	109	1010690	
7		69	109	1010700	
7.1		69	109	1010710	
7.144	9/32	69	109	1020714	
7.2		69	109	1010720	
7.3		69	109	1010730	
7.4		69	109	1010740	
7.5		69	109	1010750	
7.541	19/64	75	117	1020754	
7.6		75	117	1010760	
7.7		75	117	1010770	
7.8		75	117	1010780	
7.9		75	117	1010790	
7.937	5/16	75	117	1020794	
8		75	117	1010800	
8.1		75	117	1010810	
8.2		75	117	1010820	
8.25		75	117	1010825	
8.3		75	117	1010830	
8.334	21/64	75	117	1020833	
8.4		75	117	1010840	
8.5		75	117	1010850	
8.6		81	125	1010860	
8.7		81	125	1010870	
8.731	11/32	81	125	1020873	
8.75		81	125	1010875	
8.8		81	125	1010880	
8.9		81	125	1010890	
9		81	125	1010900	
9.1		81	125	1010910	
9.128	23/64	81	125	1020913	
9.2		81	125	1010920	

d		l ₂	l ₁	Code	Price
mm	inch				

9.25		81	125	1010925	
9.3		81	125	1010930	
9.4		81	125	1010940	
9.5		81	125	1010950	
9.525	3/8	87	133	1020953	
9.6		87	133	1010960	
9.7		87	133	1010970	
9.75		87	133	1010975	
9.8		87	133	1010980	
9.9		87	133	1010990	
9.922	25/64	87	133	1020992	
10		87	133	1011000	
10.1		87	133	1011010	
10.2		87	133	1011020	
10.25		87	133	1011025	
10.3		87	133	1011030	
10.319	13/32	87	133	1021032	
10.4		87	133	1011040	
10.5		87	133	1011050	
10.6		87	133	1011060	
10.7		94	142	1011070	
10.716	27/64	94	142	1021072	
10.75		94	142	1011075	
10.8		94	142	1011080	
10.9		94	142	1011090	
11		94	142	1011100	
11.1		94	142	1011110	
11.112	7/16	94	142	1021111	
11.2		94	142	1011120	
11.3		94	142	1011130	
11.4		94	142	1011140	
11.5		94	142	1011150	
11.509	29/64	94	142	1021151	
11.6		94	142	1011160	
11.7		94	142	1011170	
11.8		94	142	1011180	
11.9		101	151	1011190	
11.906	15/32	101	151	1021191	
12		101	151	1011200	
12.1		101	151	1011210	
12.2		101	151	1011220	
12.25		101	151	1011225	
12.3		101	151	1011230	
12.303	31/64	101	151	1021230	
12.4		101	151	1011240	
12.5		101	151	1011250	
12.6		101	151	1011260	
12.7		101	151	1011270	
12.700	1/2	101	151	1021270	

Continued on next page...

Codes

101 - 102

Properties



STANDARD POINT
sizes below
3.0 mm

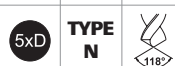


SPLIT POINT
3.0 mm and
above

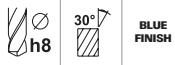
mm
inch

DIN 338

HSS



TYPE N



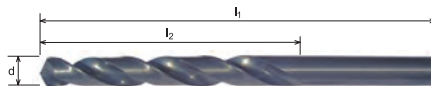
30°

BLUE FINISH










10 ≤ 9.5mm
5 ≤ 13.0mm
1 > 13.0mm






Codes
101 - 102

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●						●	●	●	●							○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

Properties		
	STANDARD POINT sizes below 3.0 mm	
	SPLIT POINT 3.0 mm and above	
mm inch	DIN 338	HSS
	TYPE N	
		BLUE FINISH
		

d		l ₂	l ₁	Code	Price
mm	inch				
... from previous page					
12.75		101	151	1011275	
12.8		101	151	1011280	
12.9		101	151	1011290	
13		101	151	1011300	
13.097	33/64	101	151	1021310	
13.1		101	151	1011310	
13.2		101	151	1011320	
13.25		108	160	1011325	
13.3		108	160	1011330	
13.4		108	160	1011340	
13.494	17/32	108	160	1021349	
13.5		108	160	1011350	
13.6		108	160	1011360	
13.7		108	160	1011370	
13.8		108	160	1011380	
13.891	35/64	108	160	1021389	
14		108	160	1011400	
14.25		114	169	1011425	

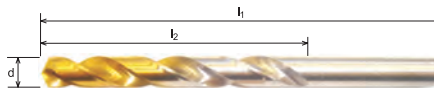
d		l ₂	l ₁	Code	Price
mm	inch				
14.287	9/16	114	169	1021429	
14.5		114	169	1011450	
14.684	37/64	114	169	1021468	
14.75		114	169	1011475	
15		114	169	1011500	
15.25		120	178	1011525	
15.5		120	178	1011550	
15.75		120	178	1011575	
15.875	5/8	120	178	1021588	
16		120	178	1011600	
16.5		125	184	1011650	
17		125	184	1011700	
17.5		130	191	1011750	
18		130	191	1011800	
18.5		135	198	1011850	
19		135	198	1011900	
19.5		140	205	1011950	
20		140	205	1012000	

QTY ↓ 
10 ≤ 9.5mm 5 ≤ 13.0mm 1 > 13.0mm



Straight Shank Jobber Drills

For precision drilling.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●			○	○	○		●	●	○	○							○	○	○	○	○	○	○	○	○	○	○				

d	l ₂	l ₁	Code	Price	d	l ₂	l ₁	Code	Price
1	12	34	1TT0100		6	57	93	1TT0600	
1.1	14	36	1TT0110		6.1	63	101	1TT0610	
1.2	16	38	1TT0120		6.2	63	101	1TT0620	
1.3	16	38	1TT0130		6.3	63	101	1TT0630	
1.4	18	40	1TT0140		6.4	63	101	1TT0640	
1.5	18	40	1TT0150		6.5	63	101	1TT0650	
1.6	20	43	1TT0160		6.6	63	101	1TT0660	
1.7	20	43	1TT0170		6.7	63	101	1TT0670	
1.8	22	46	1TT0180		6.8	69	109	1TT0680	
1.9	22	46	1TT0190		6.9	69	109	1TT0690	
2	24	49	1TT0200		7	69	109	1TT0700	
2.1	24	49	1TT0210		7.1	69	109	1TT0710	
2.2	27	53	1TT0220		7.2	69	109	1TT0720	
2.3	27	53	1TT0230		7.3	69	109	1TT0730	
2.4	30	57	1TT0240		7.4	69	109	1TT0740	
2.5	30	57	1TT0250		7.5	69	109	1TT0750	
2.6	30	57	1TT0260		7.6	75	117	1TT0760	
2.7	33	61	1TT0270		7.7	75	117	1TT0770	
2.8	33	61	1TT0280		7.8	75	117	1TT0780	
2.9	33	61	1TT0290		7.9	75	117	1TT0790	
3	33	61	1TT0300		8	75	117	1TT0800	
3.1	36	65	1TT0310		8.1	75	117	1TT0810	
3.2	36	65	1TT0320		8.2	75	117	1TT0820	
3.3	36	65	1TT0330		8.3	75	117	1TT0830	
3.4	39	70	1TT0340		8.4	75	117	1TT0840	
3.5	39	70	1TT0350		8.5	75	117	1TT0850	
3.6	39	70	1TT0360		8.6	81	125	1TT0860	
3.7	39	70	1TT0370		8.7	81	125	1TT0870	
3.8	43	75	1TT0380		8.8	81	125	1TT0880	
3.9	43	75	1TT0390		8.9	81	125	1TT0890	
4	43	75	1TT0400		9	81	125	1TT0900	
4.1	43	75	1TT0410		9.1	81	125	1TT0910	
4.2	43	75	1TT0420		9.2	81	125	1TT0920	
4.3	47	80	1TT0430		9.3	81	125	1TT0930	
4.4	47	80	1TT0440		9.4	81	125	1TT0940	
4.5	47	80	1TT0450		9.5	81	125	1TT0950	
4.6	47	80	1TT0460		9.6	87	133	1TT0960	
4.7	47	80	1TT0470		9.7	87	133	1TT0970	
4.8	52	86	1TT0480		9.8	87	133	1TT0980	
4.9	52	86	1TT0490		9.9	87	133	1TT0990	
5	52	86	1TT0500		10	87	133	1TT1000	
5.1	52	86	1TT0510		10.1	87	133	1TT1010	
5.2	52	86	1TT0520		10.2	87	133	1TT1020	
5.3	52	86	1TT0530		10.5	87	133	1TT1050	
5.4	57	93	1TT0540		10.8	94	142	1TT1080	
5.5	57	93	1TT0550		11	94	142	1TT1100	
5.6	57	93	1TT0560		11.2	94	142	1TT1120	
5.7	57	93	1TT0570		11.5	94	142	1TT1150	
5.8	57	93	1TT0580		11.8	94	142	1TT1180	
5.9	57	93	1TT0590						

Continued on next page...

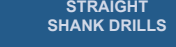
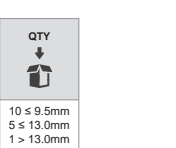
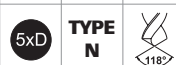
Code

1TT

Properties

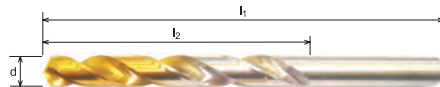


mm DIN 338 HSS



Straight Shank Jobber Drills





For precision drilling.




P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●			○	○	○		●	●	○	○							○	○	○	○	○	○	○	○	○	○	○				

d	l ₂	l ₁	Code	Price	d	l ₂	l ₁	Code	Price
... from previous page					13.5	108	160	1TT1350	
12	101	151	1TT1200		14	108	160	1TT1400	
12.2	101	151	1TT1220		14.5	114	169	1TT1450	
12.5	101	151	1TT1250		15	114	169	1TT1500	
12.8	101	151	1TT1280		15.5	120	178	1TT1550	
13	101	151	1TT1300		16	120	178	1TT1600	

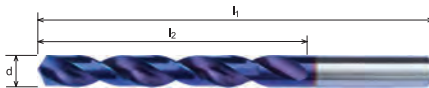


Properties		
 STANDARD POINT sizes below 3.0 mm		
 SPLIT POINT 3.0 mm and above		
mm	DIN 338	HSS
5xD	TYPE N	
	30°	BRIGHT FINISH WITH TIN TIP
pg 60		

QTY
↓

10 ≤ 9.5mm
5 ≤ 13.0mm
1 > 13.0mm



Straight Shank
MultiForce Jobber Drills
 For precision drilling in multiple materials.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	○	○	○	○	○	○	○	●	○	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

d	l ₂	l ₁	Code	Price
3	33	61	MFD-1J-0300RA	
3.3	36	65	MFD-1J-0330RA	
3.5	39	70	MFD-1J-0350RA	
4	43	75	MFD-1J-0400RA	
4.2	43	75	MFD-1J-0420RA	
4.5	47	80	MFD-1J-0450RA	
5	52	86	MFD-1J-0500RA	
5.5	57	93	MFD-1J-0550RA	
6	57	93	MFD-1J-0600RA	
6.8	69	109	MFD-1J-0680RA	
7	69	109	MFD-1J-0700RA	
8	75	117	MFD-1J-0800RA	
8.5	75	117	MFD-1J-0850RA	
9	81	125	MFD-1J-0900RA	
10	87	133	MFD-1J-1000RA	
10.2	87	133	MFD-1J-1020RA	
11	94	142	MFD-1J-1100RA	
12	101	151	MFD-1J-1200RA	

Code

MFD-1J

Properties



THINNED
POINT

mm **DIN 338** **HSS Co5**

5xD **TYPE N**

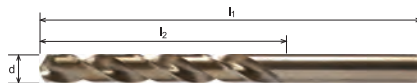
RAINBOW COATED

pg 60









NDX Jobber Drills - Heavy Duty


For drilling high tensile steels and other difficult materials.



Code
177

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	○	○	○	○			●	●	●	●								○	○	○	○	○	○	○	○						

Properties		
 STANDARD POINT sizes below 2.5 mm		
 SPLIT POINT 2.5 mm and above		
mm inch	DIN 338	HSS Co5
5xD	TYPE N	
		GOLD OXIDE FINISH
 pg 61		

QTY ↓ 
10 ≤ 9.5mm 5 ≤ 13.0mm 1 > 13.0mm

d		l ₂	l ₁	Code	Price
mm	inch				
1		12	34	1770100	
1.5		18	40	1770150	
1.587	1/16	20	43	1770159	
1.6		20	43	1770160	
1.7		20	43	1770170	
1.8		22	46	1770180	
1.9		22	46	1770190	
1.984	5/64	24	49	1770198	
2		24	49	1770200	
2.1		24	49	1770210	
2.2		27	53	1770220	
2.3		27	53	1770230	
2.381	3/32	30	57	1770238	
2.4		30	57	1770240	
2.5		30	57	1770250	
2.6		30	57	1770260	
2.7		33	61	1770270	
2.778	7/64	33	61	1770278	
2.8		33	61	1770280	
2.9		33	61	1770290	
3		33	61	1770300	
3.175	1/8	36	65	1770318	
3.2		36	65	1770320	
3.3		36	65	1770330	
3.4		39	70	1770340	
3.5		39	70	1770350	
3.572	9/64	39	70	1770357	
3.6		39	70	1770360	
3.7		39	70	1770370	
3.8		43	75	1770380	
3.9		43	75	1770390	
3.969	5/32	43	75	1770397	
4		43	75	1770400	
4.1		43	75	1770410	
4.2		43	75	1770420	
4.3		47	80	1770430	
4.366	11/64	47	80	1770437	
4.4		47	80	1770440	
4.5		47	80	1770450	
4.6		47	80	1770460	
4.7		47	80	1770470	
4.762	3/16	52	86	1770476	
4.8		52	86	1770480	
4.9		52	86	1770490	
5		52	86	1770500	
5.1		52	86	1770510	
5.159	13/64	52	86	1770516	
5.2		52	86	1770520	
5.3		52	86	1770530	
5.4		57	93	1770540	

d		l ₂	l ₁	Code	Price
mm	inch				
5.5		57	93	1770550	
5.556	7/32	57	93	1770556	
5.6		57	93	1770560	
5.7		57	93	1770570	
5.8		57	93	1770580	
5.9		57	93	1770590	
5.953	15/64	57	93	1770595	
6		57	93	1770600	
6.1		63	101	1770610	
6.2		63	101	1770620	
6.3		63	101	1770630	
6.350	1/4	63	101	1770635	
6.4		63	101	1770640	
6.5		63	101	1770650	
6.6		63	101	1770660	
6.7		63	101	1770670	
6.747	17/64	69	109	1770675	
6.8		69	109	1770680	
6.9		69	109	1770690	
7		69	109	1770700	
7.1		69	109	1770710	
7.2		69	109	1770720	
7.3		69	109	1770730	
7.4		69	109	1770740	
7.5		69	109	1770750	
7.541	19/64	75	117	1770754	
7.6		75	117	1770760	
7.7		75	117	1770770	
7.8		75	117	1770780	
7.9		75	117	1770790	
7.937	5/16	75	117	1770794	
8		75	117	1770800	
8.1		75	117	1770810	
8.2		75	117	1770820	
8.3		75	117	1770830	
8.334	21/64	75	117	1770833	
8.4		75	117	1770840	
8.5		75	117	1770850	
8.6		81	125	1770860	
8.7		81	125	1770870	
8.731	11/32	81	125	1770873	
8.8		81	125	1770880	
8.9		81	125	1770890	
9		81	125	1770900	
9.1		81	125	1770910	
9.2		81	125	1770920	
9.3		81	125	1770930	
9.4		81	125	1770940	
9.5		81	125	1770950	

Continued on next page...



NDX Jobber Drills - Heavy Duty

For drilling high tensile steels and other difficult materials.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	○	○	○	○	○	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

d		l ₂	l ₁	Code	Price
mm	inch				

... from previous page








9.525	3/8	87	133	1770953	
9.6		87	133	1770960	
9.7		87	133	1770970	
9.8		87	133	1770980	
9.9		87	133	1770990	
10		87	133	1771000	
10.1		87	133	1771010	
10.2		87	133	1771020	
10.3		87	133	1771030	
10.319	13/32	87	133	1771032	
10.4		87	133	1771040	
10.5		87	133	1771050	
10.7		94	142	1771070	
10.8		94	142	1771080	
11		94	142	1771100	
11.1		94	142	1771110	
11.112	7/16	94	142	1771111	

d		l ₂	l ₁	Code	Price
mm	inch				

11.2		94	142	1771120	
11.3		94	142	1771130	
11.4		94	142	1771140	
11.5		94	142	1771150	
11.7		94	142	1771170	
11.8		94	142	1771180	
12		101	151	1771200	
12.1		101	151	1771210	
12.2		101	151	1771220	
12.3		101	151	1771230	
12.4		101	151	1771240	
12.5		101	151	1771250	
12.6		101	151	1771260	
12.700	1/2	101	151	1771269	
12.7		101	151	1771270	
12.8		101	151	1771280	
12.9		101	151	1771290	
13		101	151	1771300	



Code
177

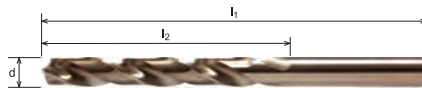
Properties		
	STANDARD POINT sizes below 2.5 mm	
	SPLIT POINT 2.5 mm and above	
mm inch	DIN 338	HSS Co5
	TYPE N	
		GOLD OXIDE FINISH
		
pg 61		

QTY
10 ≤ 9.5mm 5 ≤ 13.0mm 1 > 13.0mm






Straight Shank Jobber Drills

For drilling high tensile steels and other difficult materials.



Code
112

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	○	○	○	○	○	○	●	●	●	●							○	○	○	○	○	○	○	○							


Properties		
 STANDARD POINT		
mm inch	DIN 338	HSS Co5
5xD	TYPE N	
	30°	GOLD OXIDE FINISH
pg 61		

d		l ₂	l ₁	Code	Price
mm	inch				
1.587	1/16	20	43	1120159	
2.1		24	49	1120210	
2.2		27	53	1120220	
2.7		33	61	1120270	
2.9		33	61	1120290	
3.5		39	70	1120350	
3.6		39	70	1120360	
3.7		39	70	1120370	
4.1		43	75	1120410	
4.9		52	86	1120490	
5.1		52	86	1120510	
5.7		57	93	1120570	
5.9		57	93	1120590	
5.953	15/64	57	93	1120595	
6.5		63	101	1120650	

d		l ₂	l ₁	Code	Price
mm	inch				
6.9		69	109	1120690	
7		69	109	1120700	
7.4		69	109	1120740	
7.9		75	117	1120790	
8.3		75	117	1120830	
8.6		81	125	1120860	
9.128	23/64	81	125	1120913	
9.5		81	125	1120950	
9.525	3/8	87	133	1120953	
9.9		87	133	1120990	
10.3		87	133	1121030	
10.6		87	133	1121060	
11		94	142	1121100	
11.5		94	142	1121150	
11.7		94	142	1121170	

Not available once current stock is depleted

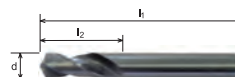


QTY ↓ 
10 ≤ 9.5mm 5 ≤ 13.0mm 1 > 13.0mm



Straight Shank Stub Drills

A robust drill suited to portable drill application.










OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●			○	○	○		●	●	○	○							○	○	○	○	○	○	○	○	○	○					

d		l ₂	l ₁	Code	Price	d		l ₂	l ₁	Code	Price
mm	inch					mm	inch				
1		6	26	1400100		4.9		26	62	1400490	
1.1		7	28	1400110		5		26	62	1400500	
1.2		8	30	1400120		5.1		26	62	1400510	
1.3		8	30	1400130		5.159	13/64	26	62	1400516	
1.4		9	32	1400140		5.2		26	62	1400520	
1.5		9	32	1400150		5.3		26	62	1400530	
1.587	1/16	10	34	1400159		5.4		28	66	1400540	
1.6		10	34	1400160		5.5		28	66	1400550	
1.7		10	34	1400170		5.556	7/32	28	66	1400556	
1.8		11	36	1400180		5.6		28	66	1400560	
1.984	5/64	12	38	1400198		5.7		28	66	1400570	
2		12	38	1400200		5.8		28	66	1400580	
2.1		12	38	1400210		5.953	15/64	28	66	1400595	
2.2		13	40	1400220		6		28	66	1400600	
2.25		13	40	1400225		6.1		31	70	1400610	
2.3		13	40	1400230		6.5		31	70	1400650	
2.381	3/32	14	43	1400238		6.6		31	70	1400660	
2.4		14	43	1400240		6.747	17/64	34	74	1400677	
2.5		14	43	1400250		6.8		34	74	1400680	
2.6		14	43	1400260		6.9		34	74	1400690	
2.65		14	43	1400265		7		34	74	1400700	
2.7		16	46	1400270		7.2		34	74	1400720	
2.778	7/64	16	46	1400278		7.4		34	74	1400740	
2.8		16	46	1400280		7.5		34	74	1400750	
2.85		16	46	1400285		7.7		37	79	1400770	
2.9		16	46	1400290		7.8		37	79	1400780	
3		16	46	1400300		7.937	5/16	37	79	1400794	
3.1		18	49	1400310		8		37	79	1400800	
3.175	1/8	18	49	1400318		8.2		37	79	1400820	
3.2		18	49	1400320		8.334	21/64	37	79	1400833	
3.25		18	49	1400325		8.5		37	79	1400850	
3.3		18	49	1400330		8.6		40	84	1400860	
3.4		20	52	1400340		8.731	11/32	40	84	1400873	
3.5		20	52	1400350		8.8		40	84	1400880	
3.572	9/64	20	52	1400357		9		40	84	1400900	
3.6		20	52	1400360		9.128	23/64	40	84	1400913	
3.7		20	52	1400370		9.2		40	84	1400920	
3.8		22	55	1400380		9.5		40	84	1400950	
3.9		22	55	1400390		9.8		43	89	1400980	
3.969	5/32	22	55	1400397		9.922	25/64	43	89	1400992	
4		22	55	1400400		10		43	89	1401000	
4.1		22	55	1400410		10.2		43	89	1401020	
4.2		22	55	1400420		10.5		43	89	1401050	
4.3		24	58	1400430		11		47	95	1401100	
4.366	11/64	24	58	1400437		11.906	15/32	51	102	1401191	
4.4		24	58	1400440		12		51	102	1401200	
4.5		24	58	1400450		12.5		51	102	1401250	
4.6		24	58	1400460		12.6		51	102	1401260	
4.7		24	58	1400470		12.700	1/2	51	102	1401269	
4.762	3/16	26	62	1400476		13		51	102	1401300	
4.8		26	62	1400480							

Not available once current stock is depleted

Code
140

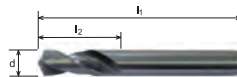
Properties		
		
STANDARD POINT sizes below 3.0 mm		
		
SPLIT POINT 3.0 mm and above		
mm inch	DIN 1897	HSS
	TYPE N	
	30° 	BLUE FINISH
	pg 61	

QTY
10 ≤ 9.5mm 5 ≤ 13.0mm 1 > 13.0mm



Straight Shank Stub Drills

A robust drill suited to portable drill application.



Code
141

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

Properties		
STANDARD POINT		
mm	DIN 1897	HSS
3xD	TYPE N	118°
h8	30°	BLUE FINISH
pg 61		

QTY ↓ 10 ≤ 9.5mm 5 ≤ 13.0mm 1 > 13.0mm
--

d	l2	l1	Code	Price	d	l2	l1	Code	Price
1.5	9	32	1410150		6.5	31	70	1410650	
1.6	10	34	1410160		6.8	34	74	1410680	
1.8	11	36	1410180		7	34	74	1410700	
2	12	38	1410200		7.2	34	74	1410720	
2.1	12	38	1410210		7.5	34	74	1410750	
2.2	13	40	1410220		7.8	37	79	1410780	
2.3	13	40	1410230		8	37	79	1410800	
2.4	14	43	1410240		8.2	37	79	1410820	
2.5	14	43	1410250		8.5	37	79	1410850	
2.6	14	43	1410260		8.8	40	84	1410880	
2.7	16	46	1410270		9	40	84	1410900	
2.8	16	46	1410280		9.5	40	84	1410950	
2.9	16	46	1410290		9.8	43	89	1410980	
3	16	46	1410300		10	43	89	1411000	
3.1	18	49	1410310		10.2	43	89	1411020	
3.2	18	49	1410320		10.5	43	89	1411050	
3.3	18	49	1410330		10.8	47	95	1411080	
3.4	20	52	1410340		11	47	95	1411100	
3.5	20	52	1410350		11.2	47	95	1411120	
3.6	20	52	1410360		11.5	47	95	1411150	
3.7	20	52	1410370		11.8	47	95	1411180	
3.8	22	55	1410380		12	51	102	1411200	
3.9	22	55	1410390		12.2	51	102	1411220	
4	22	55	1410400		12.5	51	102	1411250	
4.1	22	55	1410410		12.8	51	102	1411280	
4.2	22	55	1410420		13	51	102	1411300	
4.3	24	58	1410430		13.2	51	102	1411320	
4.4	24	58	1410440		13.5	54	107	1411350	
4.5	24	58	1410450		13.8	54	107	1411380	
4.6	24	58	1410460		14	54	107	1411400	
4.7	24	58	1410470		14.5	56	111	1411450	
4.8	26	62	1410480		15	56	111	1411500	
4.9	26	62	1410490		15.5	58	115	1411550	
5	26	62	1410500		16	58	115	1411600	
5.1	26	62	1410510		16.5	60	119	1411650	
5.2	26	62	1410520		17	60	119	1411700	
5.3	26	62	1410530		17.5	62	123	1411750	
5.4	28	66	1410540		18	62	123	1411800	
5.5	28	66	1410550		18.5	64	127	1411850	
5.6	28	66	1410560		19	64	127	1411900	
5.7	28	66	1410570		19.5	66	131	1411950	
5.8	28	66	1410580		20	66	131	1412000	
5.9	28	66	1410590		21	68	136	1412100	
6	28	66	1410600		22	70	141	1412200	
6.1	31	70	1410610		23	72	146	1412300	
6.2	31	70	1410620		24	75	151	1412400	
6.3	31	70	1410630		25	75	151	1412500	
6.4	31	70	1410640						

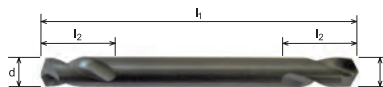
Not available once current stock is depleted





Double Ended Sheet Metal / Body Drills

Double ended self centering drill designed to produce accurate holes in thin materials.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

d	l ₂	l ₁	Code	Price	d	l ₂	l ₁	Code	Price
1.5	6	34	1510150		4.5	13	58	1510450	
1.8	6	36	1510180		4.8	14	62	1510480	
2	6	38	1510200		*4.9	14	62	1510490	
2.2	7	40	1510220		#5	14	62	1510500	
*2.5	8	43	1510250		5.2	14	62	1510520	
2.8	9	46	1510280		5.5	15	66	1510550	
3	9	46	1510300		5.8	15	66	1510580	
3.2	10	49	1510320		6	15	66	1510600	
*3.3	10	49	1510330		6.2	16	70	1510620	
3.5	11	52	1510350		*6.5	16	70	1510650	
3.8	12	55	1510380		7	18	74	1510700	
4	12	55	1510400		7.5	19	80	1510750	
*4.1	12	55	1510410		8	19	80	1510800	
#4.2	12	55	1510420						

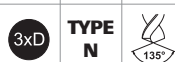
* Blind rivet drill sizes

Groove blind rivet drill sizes

Code

151

Properties

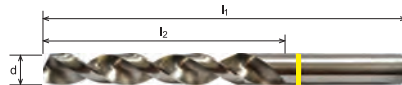




OSG GROUP COMPANY

Yellow Band Quick Spiral Jobber Drills for drilling Aluminium

For drilling materials of low tensile strength.



Code
1AQ

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	○	○																			●	●	●	●	○	○					

Properties		
STANDARD POINT sizes below 2.0 mm		
THINNED POINT 2.0 mm and above		
mm	DIN 338	HSS
5xD	CBA	TYPE W
130° h8 40°		
QS	BRIGHT FINISH	
		pg 62

d	l ₂	l ₁	Code	Price
0.9	11	32	1AQ0090	
1	12	34	1AQ0100	
1.1	14	36	1AQ0110	
1.2	16	38	1AQ0120	
1.3	16	38	1AQ0130	
1.4	18	40	1AQ0140	
1.5	18	40	1AQ0150	
1.6	20	43	1AQ0160	
1.7	20	43	1AQ0170	
1.75	22	46	1AQ0175	
1.8	22	46	1AQ0180	
1.9	22	46	1AQ0190	
2	24	49	1AQ0200	
2.1	24	49	1AQ0210	
2.2	27	53	1AQ0220	
2.25	27	53	1AQ0225	
2.3	27	53	1AQ0230	
2.4	30	57	1AQ0240	
2.5	30	57	1AQ0250	
2.6	30	57	1AQ0260	
2.7	33	61	1AQ0270	
2.75	33	61	1AQ0275	
2.8	33	61	1AQ0280	
2.9	33	61	1AQ0290	
3	33	61	1AQ0300	
3.1	36	65	1AQ0310	
3.2	36	65	1AQ0320	
3.3	36	65	1AQ0330	
3.4	39	70	1AQ0340	
3.5	39	70	1AQ0350	
3.6	39	70	1AQ0360	
3.7	39	70	1AQ0370	
3.8	43	75	1AQ0380	
3.9	43	75	1AQ0390	
4	43	75	1AQ0400	
4.1	43	75	1AQ0410	
4.2	43	75	1AQ0420	
4.3	47	80	1AQ0430	
4.4	47	80	1AQ0440	
4.5	47	80	1AQ0450	
4.6	47	80	1AQ0460	
4.7	47	80	1AQ0470	
4.8	52	86	1AQ0480	
4.9	52	86	1AQ0490	
5	52	86	1AQ0500	
5.1	52	86	1AQ0510	
5.2	52	86	1AQ0520	
5.3	52	86	1AQ0530	
5.4	57	93	1AQ0540	
5.5	57	93	1AQ0550	

d	l ₂	l ₁	Code	Price
5.6	57	93	1AQ0560	
5.7	57	93	1AQ0570	
5.8	57	93	1AQ0580	
5.9	57	93	1AQ0590	
6	57	93	1AQ0600	
6.1	63	101	1AQ0610	
6.2	63	101	1AQ0620	
6.3	63	101	1AQ0630	
6.4	63	101	1AQ0640	
6.5	63	101	1AQ0650	
6.6	63	101	1AQ0660	
6.7	63	101	1AQ0670	
6.8	69	109	1AQ0680	
6.9	69	109	1AQ0690	
7	69	109	1AQ0700	
7.1	69	109	1AQ0710	
7.2	69	109	1AQ0720	
7.3	69	109	1AQ0730	
7.4	69	109	1AQ0740	
7.5	69	109	1AQ0750	
7.6	75	117	1AQ0760	
7.7	75	117	1AQ0770	
7.8	75	117	1AQ0780	
7.9	75	117	1AQ0790	
8	75	117	1AQ0800	
8.1	75	117	1AQ0810	
8.2	75	117	1AQ0820	
8.3	75	117	1AQ0830	
8.4	75	117	1AQ0840	
8.5	75	117	1AQ0850	
8.6	81	125	1AQ0860	
8.7	81	125	1AQ0870	
8.8	81	125	1AQ0880	
8.9	81	125	1AQ0890	
9	81	125	1AQ0900	
9.1	81	125	1AQ0910	
9.2	81	125	1AQ0920	
9.3	81	125	1AQ0930	
9.4	81	125	1AQ0940	
9.5	81	125	1AQ0950	
9.6	87	133	1AQ0960	
9.7	87	133	1AQ0970	
9.8	87	133	1AQ0980	
9.9	87	133	1AQ0990	
10	87	133	1AQ1000	
10.2	87	133	1AQ1020	
10.5	87	133	1AQ1050	
11	94	142	1AQ1100	
11.5	94	142	1AQ1150	

Continued on next page...



STRAIGHT
SHANK DRILLS



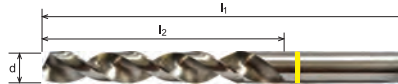
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26

JUNE 2023 V3 SOMTA CATALOGUE

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Yellow Band Quick Spiral
Jobber Drills for drilling Aluminium
 For drilling materials of low tensile strength.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	○	○																			●	●	●	●	○	○					

d	l ₂	l ₁	Code	Price
... from previous page				
12	101	151	1AQ1200	
12.5	101	151	1AQ1250	

d	l ₂	l ₁	Code	Price
12.7	101	151	1AQ1270	
13	101	151	1AQ1300	



Code
1AQ

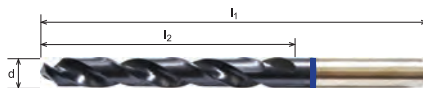
Properties		
	STANDARD POINT sizes below 2.0 mm	
	THINNED POINT 2.0 mm and above	
mm	DIN 338	HSS
5xD	CBA	TYPE W
QS	BRIGHT FINISH	pg 62





OSG GROUP COMPANY

Blue Band RF Jobber
Drills for drilling Stainless Steel (VA)
 Ideal for use on CNC machines where high productivity and accurate holes are required.



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	○	○	●	●	●						○	○	○	○	○	○															

d	l ₂	l ₁	Code	Price	d	l ₂	l ₁	Code	Price
1	12	34	1BB0100		6.8	69	109	1BB0680	
1.5	18	40	1BB0150		7	69	109	1BB0700	
1.6	20	43	1BB0160		7.3	69	109	1BB0730	
2	24	49	1BB0200		7.5	69	109	1BB0750	
2.1	24	49	1BB0210		8	75	117	1BB0800	
2.5	30	57	1BB0250		8.5	75	117	1BB0850	
2.7	33	61	1BB0270		8.8	81	125	1BB0880	
2.9	33	61	1BB0290		9	81	125	1BB0900	
3	33	61	1BB0300		9.5	81	125	1BB0950	
3.3	36	65	1BB0330		10	87	133	1BB1000	
3.5	39	70	1BB0350		10.2	87	133	1BB1020	
4	43	75	1BB0400		10.5	87	133	1BB1050	
4.2	43	75	1BB0420		10.8	94	142	1BB1080	
4.5	47	80	1BB0450		11	94	142	1BB1100	
5	52	86	1BB0500		11.5	94	142	1BB1150	
5.3	52	86	1BB0530		12	101	151	1BB1200	
5.5	57	93	1BB0550		12.5	101	151	1BB1250	
6	57	93	1BB0600		13	101	151	1BB1300	
6.5	63	101	1BB0650						



Code
1BB

Properties		
	STANDARD POINT sizes below 2.5 mm	
	SPLIT POINT 2.5 mm to below 4.0 mm	
	SECONDARY CLEARANCE 4.0 mm to below 6.0mm	
	MULTI-FACET POINT 6.0 mm and above	
mm	DIN 338	HSS Co5
5xD	CBA	TYPE VA
		35°
RF	TIAlN	



STRAIGHT SHANK DRILLS

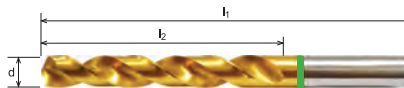


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Green Band NDX Jobber

Drills for drilling Carbon Steel

Ideal for use on CNC machines where high productivity and accurate holes are required.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	○	○	○	○		○	○	○	○								○	○	○	○	○	○	○	○						

d	l2	l1	Code	Price	d	l2	l1	Code	Price
1	12	34	1G70100		6.5	63	101	1G70650	
1.5	18	40	1G70150		6.8	69	109	1G70680	
1.6	20	43	1G70160		6.9	69	109	1G70690	
1.7	20	43	1G70170		7	69	109	1G70700	
1.9	22	46	1G70190		7.3	69	109	1G70730	
2	24	49	1G70200		7.5	69	109	1G70750	
2.1	24	49	1G70210		7.7	75	117	1G70770	
2.5	30	57	1G70250		7.8	75	117	1G70780	
2.6	30	57	1G70260		7.9	75	117	1G70790	
2.7	33	61	1G70270		8	75	117	1G70800	
2.8	33	61	1G70280		8.1	75	117	1G70810	
2.9	33	61	1G70290		8.2	75	117	1G70820	
3	33	61	1G70300		8.4	75	117	1G70840	
3.1	36	65	1G70310		8.5	75	117	1G70850	
3.2	36	65	1G70320		8.7	81	125	1G70870	
3.3	36	65	1G70330		8.8	81	125	1G70880	
3.4	39	70	1G70340		8.9	81	125	1G70890	
3.5	39	70	1G70350		9	81	125	1G70900	
3.6	39	70	1G70360		9.3	81	125	1G70930	
3.7	39	70	1G70370		9.5	81	125	1G70950	
3.8	43	75	1G70380		9.6	87	133	1G70960	
3.9	43	75	1G70390		10	87	133	1G71000	
4	43	75	1G70400		10.1	87	133	1G71010	
4.1	43	75	1G70410		10.2	87	133	1G71020	
4.2	43	75	1G70420		10.3	87	133	1G71030	
4.3	47	80	1G70430		10.5	87	133	1G71050	
4.5	47	80	1G70450		10.6	87	133	1G71060	
4.8	52	86	1G70480		10.7	94	142	1G71070	
5	52	86	1G70500		10.8	94	142	1G71080	
5.1	52	86	1G70510		11	94	142	1G71100	
5.2	52	86	1G70520		11.3	94	142	1G71130	
5.3	52	86	1G70530		11.5	94	142	1G71150	
5.5	57	93	1G70550		11.7	94	142	1G71170	
5.8	57	93	1G70580		11.8	94	142	1G71180	
5.9	57	93	1G70590		12	101	151	1G71200	
6	57	93	1G70600		12.5	101	151	1G71250	
6.1	63	101	1G70610		12.7	101	151	1G71270	
6.2	63	101	1G70620		12.8	101	151	1G71280	
6.3	63	101	1G70630		12.9	101	151	1G71290	
6.4	63	101	1G70640		13	101	151	1G71300	

Not available once current stock is depleted



Code
1G7

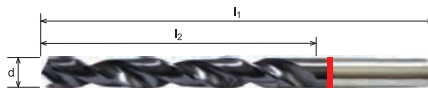
Properties		
STANDARD POINT sizes below 2.5 mm		
SPLIT POINT 2.5 mm and above		
mm	DIN 338	HSS Co5
5xD	CBA	TYPE UNI
130°	h8	33°
TiN	pg 63	





OSG GROUP COMPANY

Red Band UDS Jobber
Drills for drilling Tough Treatable Steel
Ideal for use on CNC machines where high productivity and accurate holes are required.



Code
1R5

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	●	●												○	○	○															

Properties		
SPLIT POINT sizes below 3.0 mm		
UX POINT 3.0 mm and above		
mm	DIN 338	HSS Co5
5xD	CBA	TYPE H
TYPE FS		
	TiAIN	

d	l2	l1	Code	Price
1	12	34	1R50100	
1.5	18	40	1R50150	
1.6	20	43	1R50160	
2	24	49	1R50200	
2.1	24	49	1R50210	
2.5	30	57	1R50250	
2.9	33	61	1R50290	
3	33	61	1R50300	
3.3	36	65	1R50330	
3.5	39	70	1R50350	
4	43	75	1R50400	
4.2	43	75	1R50420	
4.5	47	80	1R50450	
5	52	86	1R50500	
5.5	57	93	1R50550	
6	57	93	1R50600	

d	l2	l1	Code	Price
6.5	63	101	1R50650	
6.8	69	109	1R50680	
7	69	109	1R50700	
7.5	69	109	1R50750	
8	75	117	1R50800	
8.5	75	117	1R50850	
9	81	125	1R50900	
9.5	81	125	1R50950	
10	87	133	1R51000	
10.2	87	133	1R51020	
10.5	87	133	1R51050	
11	94	142	1R51100	
11.5	94	142	1R51150	
12	101	151	1R51200	
12.5	101	151	1R51250	
13	101	151	1R51300	

Not available once current stock is depleted



STRAIGHT
SHANK DRILLS



shaping your dreams

30

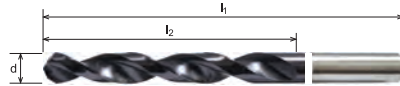
JUNE 2023 V3 SOMTA CATALOGUE

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White Band UDC Jobber

Drills for drilling Cast Iron

Ideal for use on CNC machines where high productivity and accurate holes are required.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4

d	l ₂	l ₁	Code	Price	d	l ₂	l ₁	Code	Price
2.5	30	57	1W60250		7	69	109	1W60700	
3.3	36	65	1W60330		7.5	69	109	1W60750	
4	43	75	1W60400		8	75	117	1W60800	
4.2	43	75	1W60420		8.5	75	117	1W60850	
4.5	47	80	1W60450		9	81	125	1W60900	
5	52	86	1W60500		10	87	133	1W61000	
5.5	57	93	1W60550		10.2	87	133	1W61020	
6	57	93	1W60600		10.5	87	133	1W61050	
6.5	63	101	1W60650		12	101	151	1W61200	
6.8	69	109	1W60680						

Not available once current stock is depleted

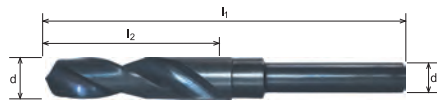


Code		
1W6		
Properties		
	SPLIT POINT sizes below 4.0 mm	
	DX POINT 4.0 mm and above	
mm	DIN 338	HSS Co5
5xD	CBA	TYPE GG
TYPE FS		
	TIAIN	
		pg 63








Reduced Shank (Electricians) Drills

For general purpose drilling.



Codes
175 - 176

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	

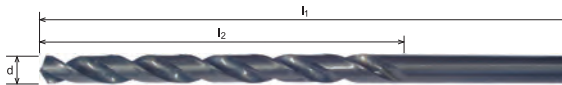
Properties		
 STANDARD POINT		
mm	WORKS	HSS
inch	STD.	
5xD	TYPE	
	N	
	30°	BLUE
		FINISH
		
pg 64		

d		d ₁	l ₂	l ₁	Code	Price
mm	inch					
11		10	94	142	1751100	
11.5		10	94	142	1751150	
12		10	101	151	1751200	
12.5		10	101	151	1751250	
12.700	1/2	10	101	151	1761270	
13		10	80	152	1751300	
13.494	17/32	1/2"	80	152	1761349	
13.5		12.7	80	152	1751350	
14		12.7	80	152	1751400	
14.287	9/16	1/2"	80	152	1761429	
14.5		12.7	80	152	1751450	
15		12.7	80	152	1751500	
15.081	19/32	1/2"	80	152	1761508	
15.5		12.7	80	152	1751550	
15.875	5/8	1/2"	80	152	1761588	
16		12.7	80	152	1751600	
16.5		12.7	80	152	1751650	
16.669	21/32	1/2"	80	152	1761667	
17		12.7	80	152	1751700	
17.462	11/16	1/2"	80	152	1761746	
17.5		12.7	80	152	1751750	
18		12.7	80	152	1751800	
18.5		12.7	80	152	1751850	
19		12.7	80	152	1751900	
19.050	3/4	1/2"	80	152	1761905	
19.5		12.7	76	152	1751950	
20		12.7	76	152	1752000	
20.5		12.7	76	152	1752050	
20.637	13/16	1/2"	76	152	1762064	
21		12.7	76	152	1752100	
21.5		12.7	76	152	1752150	
22		12.7	76	152	1752200	
22.225	7/8	1/2"	76	152	1762223	
22.5		12.7	76	152	1752250	
23		12.7	76	152	1752300	
23.5		12.7	76	152	1752350	
23.812	15/16	1/2"	76	152	1762381	
24		12.7	76	152	1752400	
24.5		12.7	76	152	1752450	
25		12.7	76	152	1752500	
25.400	1"	1/2"	76	152	1762540	



Straight Shank Long Series Drills

For long reach drilling.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●			○	○	○		●	●	○	○								○	○	○	○	○	○	○	○	○	○				

d		l ₂	l ₁	Code	Price
mm	inch				
1		33	56	1160100	
1.1		37	60	1160110	
1.2		41	65	1160120	
1.3		41	65	1160130	
1.4		45	70	1160140	
1.5		45	70	1160150	
1.587	1/16	50	76	1170159	
1.6		50	76	1160160	
1.7		50	76	1160170	
1.8		53	80	1160180	
1.9		53	80	1160190	
2		56	85	1160200	
2.1		56	85	1160210	
2.2		59	90	1160220	
2.3		59	90	1160230	
2.381	3/32	62	95	1170238	
2.4		62	95	1160240	
2.5		62	95	1160250	
2.6		62	95	1160260	
2.7		66	100	1160270	
2.8		66	100	1160280	
2.9		66	100	1160290	
3		66	100	1160300	
3.1		69	106	1160310	
3.175	1/8	69	106	1170318	
3.2		69	106	1160320	
3.3		69	106	1160330	
3.4		73	112	1160340	
3.5		73	112	1160350	
3.6		73	112	1160360	
3.7		73	112	1160370	
3.8		78	119	1160380	
3.9		78	119	1160390	
3.969	5/32	78	119	1170397	
4		78	119	1160400	
4.1		78	119	1160410	
4.2		78	119	1160420	
4.3		82	126	1160430	
4.4		82	126	1160440	
4.5		82	126	1160450	
4.6		82	126	1160460	
4.7		82	126	1160470	
4.762	3/16	87	132	1170476	
4.8		87	132	1160480	
4.9		87	132	1160490	
5		87	132	1160500	
5.1		87	132	1160510	
5.2		87	132	1160520	
5.3		87	132	1160530	
5.4		91	139	1160540	

d		l ₂	l ₁	Code	Price
mm	inch				
5.5		91	139	1160550	
5.556	7/32	91	139	1170556	
5.6		91	139	1160560	
5.7		91	139	1160570	
5.8		91	139	1160580	
5.9		91	139	1160590	
6		91	139	1160600	
6.1		97	148	1160610	
6.2		97	148	1160620	
6.3		97	148	1160630	
6.350	1/4	97	148	1170635	
6.4		97	148	1160640	
6.5		97	148	1160650	
6.6		97	148	1160660	
6.7		97	148	1160670	
6.8		102	156	1160680	
6.9		102	156	1160690	
7		102	156	1160700	
7.1		102	156	1160710	
7.144	9/32	102	156	1170714	
7.2		102	156	1160720	
7.3		102	156	1160730	
7.4		102	156	1160740	
7.5		102	156	1160750	
7.6		109	165	1160760	
7.7		109	165	1160770	
7.8		109	165	1160780	
7.9		109	165	1160790	
7.937	5/16	109	165	1170794	
8		109	165	1160800	
8.2		109	165	1160820	
8.5		109	165	1160850	
8.731	11/32	115	175	1170873	
8.8		115	175	1160880	
9		115	175	1160900	
9.2		115	175	1160920	
9.5		115	175	1160950	
9.525	3/8	121	184	1170953	
9.8		121	184	1160980	
10		121	184	1161000	
10.2		121	184	1161020	
10.319	13/32	121	184	1171032	
10.5		121	184	1161050	
10.8		128	195	1161080	
11		128	195	1161100	
11.112	7/16	128	195	1171111	
11.2		128	195	1161120	
11.5		128	195	1161150	
11.8		128	195	1161180	

Continued on next page...

Codes
116 - 117

Properties		
STANDARD POINT		
mm inch	DIN 340	HSS
	TYPE N	
		BLUE FINISH

QTY ↓
10 ≤ 9.5mm 5 ≤ 13.0mm 1 > 13.0mm

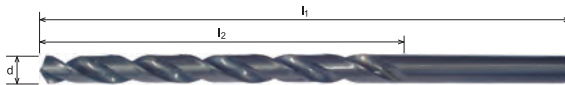




OSG GROUP COMPANY

Straight Shank Long Series Drills

For long reach drilling.



Codes
116 - 117

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	○	○	○	○	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

d		l ₂	l ₁	Code	Price
mm	inch				
... from previous page					
12		134	205	1161200	
12.2		134	205	1161220	
12.5		134	205	1161250	
12.700	1/2	134	205	1171270	
12.8		134	205	1161280	

d		l ₂	l ₁	Code	Price
mm	inch				
13		134	205	1161300	
14		140	214	1161400	
14.287	9/16	144	220	1171429	
15		144	220	1161500	
15.875	5/8	149	227	1171588	
16		149	227	1161600	

Properties		
STANDARD POINT		
mm inch	DIN 340	HSS
8-10 xD	TYPE N	
h8	30°	BLUE FINISH
pg 64		



QTY ↓
10 ≤ 9.5mm 5 ≤ 13.0mm 1 > 13.0mm



STRAIGHT
SHANK DRILLS



shaping your dreams

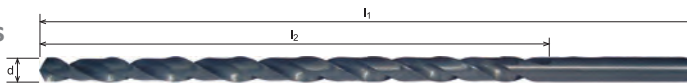
34

JUNE 2023 V3 SOMTA CATALOGUE

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Straight Shank Extra Length Drills

For extra deep hole
drilling.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●			○	○	○		●	●	○	○											○	○	○	○	○	○					

d		l ₂	l ₁	Code	Price
mm	inch				
1.5		80	125	1210150	
1.5		100	160	1220150	
2		80	125	1210200	
2		100	160	1220200	
2		160	200	1230200	
2.5		80	125	1210250	
2.5		100	160	1220250	
2.5		160	200	1230250	
3		80	125	1210300	
3		100	160	1220300	
3		160	200	1230300	
3		200	250	1240300	
3		250	315	1250300	
3.175	1/8	6"	200	1330318	
3.175	1/8	8"	250	1340318	
3.175	1/8	10"	315	1350318	
3.5		100	160	1220350	
3.5		160	200	1230350	
3.5		200	250	1240350	
3.969	5/32	4"	160	1320397	
3.969	5/32	6"	200	1330397	
4		100	160	1220400	
4		160	200	1230400	
4		200	250	1240400	
4		250	315	1250400	
4		300	400	1260400	
4.5		100	160	1220450	
4.5		160	200	1230450	
4.5		200	250	1240450	
4.762	3/16	6"	200	1330476	
4.762	3/16	10"	315	1350476	
5		100	160	1220500	
5		160	200	1230500	
5		200	250	1240500	
5		250	315	1250500	
5		300	400	1260500	
5.5		100	160	1220550	
5.5		160	200	1230550	
5.5		200	250	1240550	
5.556	7/32	10"	315	1350556	
6		100	160	1220600	
6		160	200	1230600	
6		200	250	1240600	
6		250	315	1250600	
6		300	400	1260600	
6.350	1/4	6"	200	1330635	
6.350	1/4	10"	315	1350635	

d		l ₂	l ₁	Code	Price
mm	inch				
6.5		160	200	1230650	
6.5		200	250	1240650	
7		160	200	1230700	
7		200	250	1240700	
7		250	315	1250700	
7		300	400	1260700	
7.144	9/32	10"	315	1350714	
7.5		160	200	1230750	
7.5		200	250	1240750	
7.937	5/16	6"	200	1330794	
7.937	5/16	10"	315	1350794	
7.937	5/16	12"	400	1360794	
8		160	200	1230800	
8		200	250	1240800	
8		250	315	1250800	
8		300	400	1260800	
8.5		160	200	1230850	
8.5		200	250	1240850	
8.731	11/32	10"	315	1350873	
9		160	200	1230900	
9		200	250	1240900	
9		250	315	1250900	
9		300	400	1260900	
9.5		160	200	1230950	
9.5		200	250	1240950	
9.525	3/8	6"	200	1330953	
9.525	3/8	8"	250	1340953	
9.525	3/8	10"	315	1350953	
10		160	200	1231000	
10		200	250	1241000	
10		250	315	1251000	
10		300	400	1261000	
10.5		200	250	1241050	
11		200	250	1241100	
11		250	315	1251100	
11		300	400	1261100	
11.112	7/16	8"	250	1341111	
11.112	7/16	10"	315	1351111	
11.5		200	250	1241150	
12		200	250	1241200	
12		250	315	1251200	
12		300	400	1261200	
12.5		200	250	1241250	
12.700	1/2	10"	315	1351270	
13		200	250	1241300	
13		250	315	1251300	
13		300	400	1261300	

Codes

121 - 126
132 - 136

Properties



mm
inch

BASED ON
ISO
3292

HSS

15-20
xD

TYPE
N

118°

h8

30°

BLUE
FINISH

pg 64



Not available once current stock is depleted

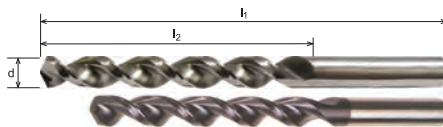




OSG GROUP COMPANY

UDL Jobber Drills

Ideal for use on CNC machines where high productivity and accurate holes are required.



Code

164

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	○	○	○	○	●	●	●	●							○	○	○	○	○	○	○	○	○	○					

Properties



STANDARD POINT
sizes below
1.5 mm



SPLIT POINT
1.5 mm and
above

mm
inch
wire
letter

**DIN
338**

**HSS
Co5**

5xD

**TYPE
FS**

130°

h8

40°

**BRIGHT
FINISH
TiAIN**

pg 65-66

QTY



10 ≤ 9.5mm
5 ≤ 13.0mm
1 > 13.0mm

d	mm Equiv.	l ₂	l ₁	Bright Finish		TiAIN Coated	
				Code	Price	Code	Price
1		12	34	1640100		1640100A	
No.60	1.016	12	34	1640102		-	
No.59	1.041	12	34	1640104		-	
No.58	1.067	14	36	1640107		-	
No.57	1.092	14	36	1640109		-	
1.1		14	36	1640110		1640110A	
No.56	1.181	16	38	1640118		-	
3/64	1.191	16	38	1640119		-	
1.2		16	38	1640120		1640120A	
1.3		16	38	1640130		1640130A	
No.55	1.321	18	40	1640132		-	
No.54	1.397	18	40	1640139		-	
1.4		18	40	1640140		1640140A	
1.5		18	40	1640150		1640150A	
No.53	1.511	20	43	1640152		-	
1/16	1.588	20	43	1640159		-	
1.6		20	43	1640160		1640160A	
No.52	1.613	20	43	1640161		-	
1.7		20	43	1640170		1640170A	
No.51	1.702	22	46	1640169		-	
No.50	1.778	22	46	1640178		-	
1.8		22	46	1640180		1640180A	
No.49	1.854	22	46	1640185		-	
1.9		22	46	1640190		1640190A	
No.48	1.930	24	49	1640193		-	
5/64	1.984	24	49	1640198		-	
No.47	1.994	24	49	1640199		-	
2		24	49	1640200		1640200A	
No.46	2.057	24	49	1640206		-	
No.45	2.083	24	49	1640208		-	
2.1		24	49	1640210		1640210A	
No.44	2.184	27	53	1640218		-	
2.2		27	53	1640220		1640220A	
No.43	2.261	27	53	1640226		-	
2.3		27	53	1640230		1640230A	
No.42	2.375	30	57	1640237		-	
3/32	2.381	30	57	1640238		-	
2.4		30	57	1640240		1640240A	
No.41	2.438	30	57	1640244		-	
No.40	2.489	30	57	1640249		-	
2.5		30	57	1640250		1640250A	
No.39	2.527	30	57	1640253		-	
No.38	2.578	30	57	1640258		-	
2.6		30	57	1640260		1640260A	
No.37	2.642	30	57	1640264		-	
2.7		33	61	1640270		1640270A	
No.36	2.705	33	61	1640271		-	
7/64	2.778	33	61	1640278		-	

Continued on next page...



STRAIGHT
SHANK DRILLS



shaping your dreams

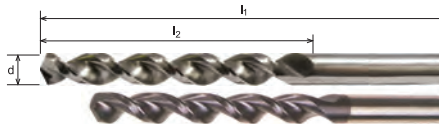
36

JUNE 2023 V3 SOMTA CATALOGUE

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UDL Jobber Drills

Ideal for use on CNC machines where high productivity and accurate holes are required.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	○	○	○	○	●	●	●	●							○	○	○	○	○	○	○	○	○	○					

d	mm Equiv.	l2	l1	Bright Finish		TiAlN Coated	
				Code	Price	Code	Price

... from previous page

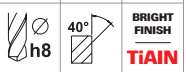
No.35	2.794	33	61	1640279	-	-	-
2.8		33	61	1640280	-	1640280A	-
No.34	2.819	33	61	1640282	-	-	-
No.33	2.870	33	61	1640287	-	-	-
2.9		33	61	1640290	-	1640290A	-
No.32	2.946	33	61	1640295	-	-	-
3		33	61	1640300	-	1640300A	-
No.31	3.048	36	65	1640305	-	-	-
3.1		36	65	1640310	-	1640310A	-
1/8	3.175	36	65	1640318	-	-	-
3.2		36	65	1640320	-	1640320A	-
No.30	3.264	36	65	1640326	-	-	-
3.3		36	65	1640330	-	1640330A	-
3.4		39	70	1640340	-	1640340A	-
No.29	3.454	39	70	1640345	-	-	-
3.5		39	70	1640350	-	1640350A	-
9/64	3.572	39	70	1640357	-	-	-
3.6		39	70	1640360	-	1640360A	-
3.7		39	70	1640370	-	1640370A	-
No.26	3.734	39	70	1640373	-	-	-
No.25	3.797	43	75	1640379	-	-	-
3.8		43	75	1640380	-	1640380A	-
No.24	3.861	43	75	1640386	-	-	-
3.9		43	75	1640390	-	1640390A	-
No.23	3.912	43	75	1640391	-	-	-
5/32	3.969	43	75	1640397	-	-	-
No.22	3.988	43	75	1640399	-	-	-
4		43	75	1640400	-	1640400A	-
No.21	4.039	43	75	1640404	-	-	-
No.20	4.089	43	75	1640409	-	-	-
4.1		43	75	1640410	-	1640410A	-
4.2		43	75	1640420	-	1640420A	-
No.19	4.216	43	75	1640422	-	-	-
4.3		47	80	1640430	-	1640430A	-
No.18	4.305	47	80	1640431	-	-	-
11/64	4.366	47	80	1640437	-	-	-
No.17	4.394	47	80	1640439	-	-	-
4.4		47	80	1640440	-	1640440A	-
No.16	4.496	47	80	1640449	-	-	-
4.5		47	80	1640450	-	1640450A	-
4.6		47	80	1640460	-	1640460A	-
4.7		47	80	1640470	-	1640470A	-
3/16	4.762	52	86	1640476	-	-	-
No.12	4.800	52	86	1640479	-	-	-
4.8		52	86	1640480	-	1640480A	-
No.11	4.851	52	86	1640485	-	-	-
4.9		52	86	1640490	-	1640490A	-

Continued on next page...

Code

164

Properties

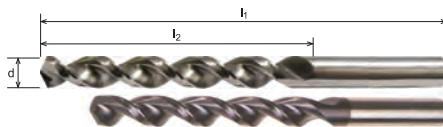




OSG GROUP COMPANY

UDL Jobber Drills

Ideal for use on CNC machines where high productivity and accurate holes are required.



Code

164

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	○	○	○	○	●	●	●	●							○	○	○	○	○	○	○	○	○	○					

Properties



STANDARD POINT
sizes below
1.5 mm



SPLIT POINT
1.5 mm and
above

mm
inch
wire
letter

DIN 338

HSS Co5

5xD

TYPE FS

130°

h8

40°

BRIGHT FINISH
TiAlN

pg 65-66

QTY



10 ≤ 9.5mm
5 ≤ 13.0mm
1 > 13.0mm

d	mm Equiv.	l ₂	l ₁	Bright Finish		TiAlN Coated	
				Code	Price	Code	Price

... from previous page

No.10	4.915	52	86	1640492	-	-	-
No.9	4.978	52	86	1640498	-	-	-
5		52	86	1640500		1640500A	
No.8	5.055	52	86	1640506	-	-	-
5.1		52	86	1640510		1640510A	
No.7	5.105	52	86	1640511	-	-	-
13/64	5.159	52	86	1640516	-	-	-
No.6	5.182	52	86	1640518	-	-	-
5.2		52	86	1640520		1640520A	
No.5	5.220	52	86	1640522	-	-	-
5.3		52	86	1640530		1640530A	
No.4	5.309	57	93	1640532	-	-	-
5.4		57	93	1640540		1640540A	
No.3	5.410	57	93	1640541	-	-	-
5.5		57	93	1640550		1640550A	
7/32	5.556	57	93	1640556	-	-	-
5.6		57	93	1640560		1640560A	
No.2	5.613	57	93	1640561	-	-	-
5.7		57	93	1640570		1640570A	
No.1	5.791	57	93	1640579	-	-	-
5.8		57	93	1640580		1640580A	
5.9		57	93	1640590		1640590A	
LTR.A	5.944	57	93	1640594	-	-	-
15/64	5.953	57	93	1640595	-	-	-
6		57	93	1640600		1640600A	
LTR.B	6.045	63	101	1640605	-	-	-
6.1		63	101	1640610		1640610A	
LTR.C	6.147	63	101	1640615	-	-	-
6.2		63	101	1640620		1640620A	
LTR.D	6.248	63	101	1640625	-	-	-
6.3		63	101	1640630		1640630A	
LTR.E	6.350	63	101	1640634	-	-	-
1/4	6.350	63	101	1640635	-	-	-
6.4		63	101	1640640		1640640A	
6.5		63	101	1640650		1640650A	
LTR.F	6.528	63	101	1640653	-	-	-
6.6		63	101	1640660		1640660A	
LTR.G	6.629	63	101	1640663	-	-	-
6.7		63	101	1640670		1640670A	
LTR.H	6.756	69	109	1640676	-	-	-
17/64	6.747	69	109	1640677	-	-	-
6.8		69	109	1640680		1640680A	
6.9		69	109	1640690		1640690A	
LTR.I	6.909	69	109	1640691	-	-	-
7		69	109	1640700		1640700A	
LTR.J	7.036	69	109	1640704	-	-	-
7.1		69	109	1640710		1640710A	

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STRAIGHT
SHANK DRILLS



shaping your dreams

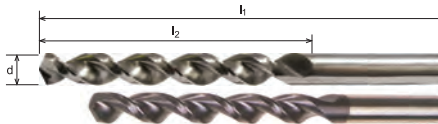
38

JUNE 2023 V3 SOMTA CATALOGUE

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UDL Jobber Drills

Ideal for use on CNC machines where high productivity and accurate holes are required.



OSG GROUP COMPANY

P					M				K				Ti			Ni				Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	○	○	○	○	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

d	mm Equiv.	l2	l1	Bright Finish		TiAlN Coated	
				Code	Price	Code	Price

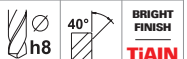
... from previous page

LTR.K	7.137	69	109	1640713	-	-	-
9/32	7.144	69	109	1640714	-	-	-
7.2		69	109	1640720		1640720A	
7.3		69	109	1640730		1640730A	
LTR.L	7.366	69	109	1640737	-	-	-
7.4		69	109	1640740		1640740A	
LTR.M	7.493	69	109	1640749	-	-	-
7.5		69	109	1640750		1640750A	
19/64	7.541	75	117	1640754	-	-	-
7.6		75	117	1640760		1640760A	
LTR.N	7.671	75	117	1640767	-	-	-
7.7		75	117	1640770		1640770A	
7.8		75	117	1640780		1640780A	
7.9		75	117	1640790		1640790A	
5/16	7.937	75	117	1640794	-	-	-
8		75	117	1640800		1640800A	
LTR.Q	8.433	75	117	1640843	-	-	-
8.5		75	117	1640850		1640850A	
11/32	8.731	81	125	1640873	-	-	-
LTR.S	8.839	81	125	1640884	-	-	-
9		81	125	1640900		1640900A	
23/64	9.128	81	125	1640913	-	-	-
LTR.U	9.347	81	125	1640935	-	-	-
9.5		81	125	1640950		1640950A	
3/8	9.525	87	133	1640953	-	-	-
10		87	133	1641000		1641000A	
10.5		87	133	1641050		1641050A	
27/64	10.716	94	142	1641072	-	-	-
11		94	142	1641100		1641100A	
11.5		94	142	1641150		1641150A	
12		101	151	1641200		1641200A	
12.5		101	151	1641250		1641250A	
1/2	12.700	101	151	1641269	-	-	-
13		101	151	1641300		1641300A	

Code

164

Properties

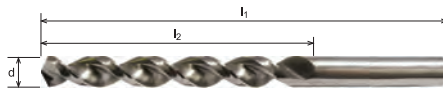




OSG GROUP COMPANY

UDL Jobber Drills

Ideal for use on CNC machines where high productivity and accurate holes are required.



Code
154

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●		○	○	○		●	●	●	●							○	○	○	○	○	○	○	○	○	○					

d	l ₂	l ₁	Code	Price
3.3	36	65	1540330	
3.4	39	70	1540340	
5.5	57	93	1540550	
7	69	109	1540700	

d	l ₂	l ₁	Code	Price
7.5	69	109	1540750	
8.5	75	117	1540850	
9.5	81	125	1540950	
10	87	133	1541000	

Not available once current stock is depleted



Properties		
mm	DIN 338	HSS Co5
5xD	TYPE FS	130°
h8	40°	BRIGHT FINISH
pg 65		

QTY ↓
10 ≤ 9.5mm 5 ≤ 13.0mm 1 > 13.0mm



STRAIGHT
SHANK DRILLS



shaping your dreams

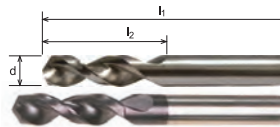
40

JUNE 2023 V3 SOMTA CATALOGUE

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UDL Stub Drills

Ideal for use on CNC machines where high productivity and accurate holes are required.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	○	○	○		●	●	●	●							○	○	○	○	○	○	○	○	○	○					

Code

163

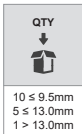
d	mm Equiv.	l2	l1	Bright Finish		TiAlN Coated	
				Code	Price	Code	Price
1		6	26	1630100		1630100A	
No.60	1.016	6	26	1630102		-	
No.59	1.041	6	26	1630104		-	
No.58	1.067	7	28	1630107		-	
No.57	1.092	7	28	1630109		-	
1.1		7	28	1630110		1630110A	
No.56	1.181	8	30	1630118		-	
3/64	1.191	8	30	1630119		-	
1.2		8	30	1630120		1630120A	
1.3		8	30	1630130		1630130A	
No.55	1.321	9	32	1630132		-	
No.54	1.397	9	32	1630139		-	
1.4		9	32	1630140		1630140A	
1.5		9	32	1630150		1630150A	
No.53	1.511	10	34	1630152		-	
1/16	1.587	10	34	1630159		-	
1.6		10	34	1630160		1630160A	
No.52	1.613	10	34	1630161		-	
1.7		10	34	1630170		1630170A	
No.51	1.702	11	36	1630169		-	
No.50	1.778	11	36	1630178		-	
1.8		11	36	1630180		1630180A	
No.49	1.854	11	36	1630185		-	
1.9		11	36	1630190		1630190A	
No.48	1.930	12	38	1630193		-	
5/64	1.984	12	38	1630198		-	
No.47	1.994	12	38	1630199		-	
2		12	38	1630200		1630200A	
No.46	2.057	12	38	1630206		-	
No.45	2.083	12	38	1630208		-	
2.1		12	38	1630210		1630210A	
No.44	2.184	13	40	1630218		-	
2.2		13	40	1630220		1630220A	
No.43	2.261	13	40	1630226		-	
2.3		13	40	1630230		1630230A	
No.42	2.375	14	43	1630237		-	
3/32	2.381	14	43	1630238		-	
2.4		14	43	1630240		1630240A	
No.41	2.438	14	43	1630244		-	
No.40	2.489	14	43	1630249		-	
2.5		14	43	1630250		1630250A	
No.39	2.527	14	43	1630253		-	
No.38	2.578	14	43	1630258		-	
2.6		14	43	1630260		1630260A	
No.37	2.642	14	43	1630264		-	
2.7		16	46	1630270		1630270A	
No.36	2.705	16	46	1630271		-	
7/64	2.778	16	46	1630278		-	

Continued on next page...

Properties

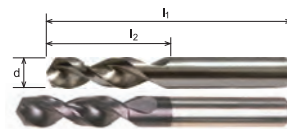


mm inch wire letter	DIN 1897	HSS Co5
3xD	TYPE FS	130°
h8	40°	BRIGHT FINISH TiAlN
pg 65-66		







UDL Stub Drills


Ideal for use on CNC machines where high productivity and accurate holes are required.



Code
163

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	○	○	○	○	●	●	●	●							○	○	○	○	○	○	○	○	○	○					

Properties		
 STANDARD POINT sizes below 1.5 mm		
 SPLIT POINT 1.5 mm and above		
mm inch wire letter	DIN 1897	HSS Co5
3xD	TYPE FS	
	40°	BRIGHT FINISH TIAIN
pg 65-66		

QTY ↓ 
10 ≤ 9.5mm 5 ≤ 13.0mm 1 > 13.0mm

d	mm Equiv.	l ₂	l ₁	Bright Finish		TiAlN Coated	
				Code	Price	Code	Price
... from previous page							
No.35	2.794	16	46	1630279	-	-	-
2.8		16	46	1630280	-	1630280A	-
No.34	2.819	16	46	1630282	-	-	-
No.33	2.870	16	46	1630287	-	-	-
2.9		16	46	1630290	-	1630290A	-
No.32	2.946	16	46	1630295	-	-	-
3		16	46	1630300	-	1630300A	-
No.31	3.048	18	49	1630305	-	-	-
3.1		18	49	1630310	-	1630310A	-
1/8	3.175	18	49	1630318	-	-	-
3.2		18	49	1630320	-	1630320A	-
No.30	3.264	18	49	1630326	-	-	-
3.3		18	49	1630330	-	1630330A	-
3.4		20	52	1630340	-	1630340A	-
No.29	3.454	20	52	1630345	-	-	-
3.5		20	52	1630350	-	1630350A	-
9/64	3.572	20	52	1630357	-	-	-
3.6		20	52	1630360	-	1630360A	-
No.27	3.658	20	52	1630366	-	-	-
3.7		20	52	1630370	-	1630370A	-
No.26	3.734	20	52	1630373	-	-	-
No.25	3.797	22	55	1630379	-	-	-
3.8		22	55	1630380	-	1630380A	-
No.24	3.861	22	55	1630386	-	-	-
3.9		22	55	1630390	-	1630390A	-
No.23	3.912	22	55	1630391	-	-	-
5/32	3.969	22	55	1630397	-	-	-
No.22	3.988	22	55	1630399	-	-	-
4		22	55	1630400	-	1630400A	-
No.21	4.039	22	55	1630404	-	-	-
No.20	4.089	22	55	1630409	-	-	-
4.1		22	55	1630410	-	1630410A	-
4.2		22	55	1630420	-	1630420A	-
No.19	4.216	22	55	1630422	-	-	-
4.3		24	58	1630430	-	1630430A	-
No.18	4.305	24	58	1630431	-	-	-
11/64	4.366	24	58	1630437	-	-	-
No.17	4.394	24	58	1630439	-	-	-
4.4		24	58	1630440	-	1630440A	-
No.16	4.496	24	58	1630449	-	-	-
4.5		24	58	1630450	-	1630450A	-
No.15	4.572	24	58	1630457	-	-	-
4.6		24	58	1630460	-	1630460A	-
4.7		24	58	1630470	-	1630470A	-
3/16	4.762	26	62	1630476	-	-	-
No.12	4.800	26	62	1630479	-	-	-
4.8		26	62	1630480	-	1630480A	-

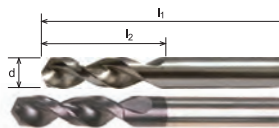
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STRAIGHT
SHANK DRILLS

UDL Stub Drills

Ideal for use on CNC machines where high productivity and accurate holes are required.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	○	○	○	○	●	●	●	●							○	○	○	○	○	○	○	○	○	○					

d	mm Equiv.	l2	l1	Bright Finish		TiAlN Coated	
				Code	Price	Code	Price

... from previous page

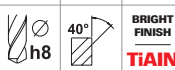
No.11	4.851	26	62	1630485	-	-	-
4.9		26	62	1630490	-	1630490A	-
No.10	4.915	26	62	1630492	-	-	-
No.9	4.978	26	62	1630498	-	-	-
5		26	62	1630500	-	1630500A	-
No.8	5.055	26	62	1630506	-	-	-
5.1		26	62	1630510	-	1630510A	-
No.7	5.105	26	62	1630511	-	-	-
13/64	5.159	26	62	1630516	-	-	-
No.6	5.182	26	62	1630518	-	-	-
5.2		26	62	1630520	-	1630520A	-
No.5	5.220	26	62	1630522	-	-	-
5.3		26	62	1630530	-	1630530A	-
No.4	5.309	28	66	1630532	-	-	-
5.4		28	66	1630540	-	1630540A	-
No.3	5.410	28	66	1630541	-	-	-
5.5		28	66	1630550	-	1630550A	-
7/32	5.556	28	66	1630556	-	-	-
5.6		28	66	1630560	-	1630560A	-
No.2	5.613	28	66	1630561	-	-	-
5.7		28	66	1630570	-	1630570A	-
No.1	5.791	28	66	1630579	-	-	-
5.8		28	66	1630580	-	1630580A	-
5.9		28	66	1630590	-	1630590A	-
LTR.A	5.944	28	66	1630594	-	-	-
15/64	5.953	28	66	1630595	-	-	-
6		28	66	1630600	-	1630600A	-
LTR.B	6.045	31	70	1630605	-	-	-
6.1		31	70	1630610	-	1630610A	-
LTR.C	6.147	31	70	1630615	-	-	-
6.2		31	70	1630620	-	1630620A	-
LTR.D	6.248	31	70	1630625	-	-	-
6.3		31	70	1630630	-	1630630A	-
LTR.E	6.350	31	70	1630634	-	-	-
1/4	6.350	31	70	1630635	-	-	-
6.4		31	70	1630640	-	1630640A	-
6.5		31	70	1630650	-	1630650A	-
LTR.F	6.528	31	70	1630653	-	-	-
6.6		31	70	1630660	-	1630660A	-
LTR.G	6.629	31	70	1630663	-	-	-
6.7		31	70	1630670	-	1630670A	-
LTR.H	6.756	34	74	1630676	-	-	-
17/64	6.747	34	74	1630677	-	-	-
6.8		34	74	1630680	-	1630680A	-
6.9		34	74	1630690	-	1630690A	-
LTR.I	6.909	34	74	1630691	-	-	-
7		34	74	1630700	-	1630700A	-

Continued on next page...

Code

163

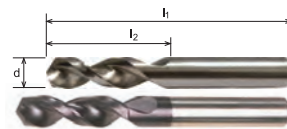
Properties



STRAIGHT
SHANK DRILLS

UDL Stub Drills

Ideal for use on CNC machines where high productivity and accurate holes are required.



Code

163

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	○	○	○	○	●	●	●	●							○	○	○	○	○	○	○	○	○	○					

Properties



STANDARD POINT
sizes below
1.5 mm



SPLIT POINT
1.5 mm and
above

mm
inch
wire
letter

**DIN
1897**

**HSS
Co5**

3xD

**TYPE
FS**

130°

h8

40°

**BRIGHT
FINISH
TiAlN**

pg 65-66

QTY



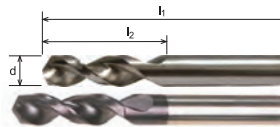
10 ≤ 9.5mm
5 ≤ 13.0mm
1 > 13.0mm

d	mm Equiv.	l ₂	l ₁	Bright Finish		TiAlN Coated	
				Code	Price	Code	Price
... from previous page							
LTR.J	7.036	34	74	1630704		-	
7.1		34	74	1630710		1630710A	
LTR.K	7.137	34	74	1630713		-	
9/32	7.144	34	74	1630714		-	
7.2		34	74	1630720		1630720A	
7.3		34	74	1630730		1630730A	
LTR.L	7.366	34	74	1630737		-	
7.4		34	74	1630740		1630740A	
LTR.M	7.493	34	74	1630749		-	
7.5		34	74	1630750		1630750A	
19/64	7.541	37	79	1630754		-	
7.6		37	79	1630760		1630760A	
LTR.N	7.671	37	79	1630767		-	
7.7		37	79	1630770		1630770A	
7.8		37	79	1630780		1630780A	
7.9		37	79	1630790		1630790A	
5/16	7.937	37	79	1630794		-	
8		37	79	1630800		1630800A	
LTR.O	8.026	37	79	1630803		-	
8.1		37	79	1630810		1630810A	
8.2		37	79	1630820		1630820A	
LTR.P	8.204	37	79	1630821		-	
8.3		37	79	1630830		1630830A	
21/64	8.334	37	79	1630833		-	
8.4		37	79	1630840		1630840A	
LTR.Q	8.433	37	79	1630843		-	
8.5		37	79	1630850		1630850A	
8.6		40	84	1630860		1630860A	
LTR.R	8.611	40	84	1630861		-	
8.7		40	84	1630870		1630870A	
11/32	8.731	40	84	1630873		-	
8.8		40	84	1630880		1630880A	
LTR.S	8.839	40	84	1630884		-	
8.9		40	84	1630890		1630890A	
9		40	84	1630900		1630900A	
LTR.T	9.093	40	84	1630909		-	
9.1		40	84	1630910		1630910A	
23/64	9.128	40	84	1630913		-	
9.2		40	84	1630920		1630920A	
9.3		40	84	1630930		1630930A	
LTR.U	9.347	40	84	1630935		-	
9.4		40	84	1630940		1630940A	
9.5		40	84	1630950		1630950A	
3/8	9.525	43	89	1630953		-	
LTR.V	9.576	43	89	1630958		-	
9.6		43	89	1630960		1630960A	
9.7		43	89	1630970		1630970A	

Continued on next page...

UDL Stub Drills

Ideal for use on CNC machines where high productivity and accurate holes are required.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	○	○	○	○	●	●	●	●							○	○	○	○	○	○	○	○	○	○					

d	mm Equiv.	l ₂	l ₁	Bright Finish		TiAlN Coated	
				Code	Price	Code	Price
... from previous page							
9.8		43	89	1630980		1630980A	
LTR.W	9.804	43	89	1630981		-	
9.9		43	89	1630990		1630990A	
25/64	9.922	43	89	1630992		-	
10		43	89	1631000		1631000A	
LTR.X	10.084	43	89	1631008		-	
10.2		43	89	1631020		1631020A	
LTR.Y	10.262	43	89	1631026		-	
13/32	10.319	43	89	1631032		-	
LTR.Z	10.490	43	89	1631049		-	
10.5		43	89	1631050		1631050A	
27/64	10.716	47	95	1631072		-	
10.8		47	95	1631080		1631080A	
11		47	95	1631100		1631100A	
7/16	11.112	47	95	1631111		-	
11.2		47	95	1631120		1631120A	
11.5		47	95	1631150		1631150A	
29/64	11.509	47	95	1631151		-	
12		51	102	1631200		1631200A	
31/64	12.303	51	102	1631229		-	
12.5		51	102	1631250		1631250A	
1/2	12.700	51	102	1631269		-	
13		51	102	1631300		1631300A	

Code
163

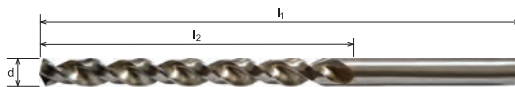
Properties		
STANDARD POINT sizes below 1.5 mm		
SPLIT POINT 1.5 mm and above		
mm inch wire letter	DIN 1897	HSS Co5
3xD	TYPE FS	
h8	40°	BRIGHT FINISH TiAlN
pg 65-66		

QTY ↓
10 ≤ 9.5mm 5 ≤ 13.0mm 1 > 13.0mm



UDL Long Series Drills

Ideal for use on CNC machines where high productivity and accurate holes are required. High performance deep hole drilling.



Code

110

Properties



**STANDARD
POINT**
sizes below
1.5 mm



**SPLIT
POINT**
1.5 mm and
above

mm

DIN
340

HSS
Co5

**TYPE
FS**

**BRIGHT
FINISH**


QTY



10 ≤ 9.5mm
5 ≤ 13.0mm
1 > 13.0mm

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

d	l ₂	l ₁	Code	Price	d	l ₂	l ₁	Code	Price
1	33	56	1100100		5.6	91	139	1100560	
1.1	37	60	1100110		5.7	91	139	1100570	
1.2	41	65	1100120		5.8	91	139	1100580	
1.3	41	65	1100130		5.9	91	139	1100590	
1.4	45	70	1100140		6	91	139	1100600	
1.5	45	70	1100150		6.1	97	148	1100610	
1.6	50	76	1100160		6.2	97	148	1100620	
1.7	50	76	1100170		6.3	97	148	1100630	
1.8	53	80	1100180		6.4	97	148	1100640	
1.9	53	80	1100190		6.5	97	148	1100650	
2	56	85	1100200		6.6	97	148	1100660	
2.1	56	85	1100210		6.7	97	148	1100670	
2.2	59	90	1100220		6.8	102	156	1100680	
2.3	59	90	1100230		6.9	102	156	1100690	
2.4	62	95	1100240		7	102	156	1100700	
2.5	62	95	1100250		7.1	102	156	1100710	
2.6	62	95	1100260		7.2	102	156	1100720	
2.7	66	100	1100270		7.3	102	156	1100730	
2.8	66	100	1100280		7.4	102	156	1100740	
2.9	66	100	1100290		7.5	102	156	1100750	
3	66	100	1100300		7.6	109	165	1100760	
3.1	69	106	1100310		7.7	109	165	1100770	
3.2	69	106	1100320		7.8	109	165	1100780	
3.3	69	106	1100330		7.9	109	165	1100790	
3.4	73	112	1100340		8	109	165	1100800	
3.5	73	112	1100350		8.1	109	165	1100810	
3.6	73	112	1100360		8.2	109	165	1100820	
3.7	73	112	1100370		8.3	109	165	1100830	
3.8	78	119	1100380		8.4	109	165	1100840	
3.9	78	119	1100390		8.5	109	165	1100850	
4	78	119	1100400		8.6	115	175	1100860	
4.1	78	119	1100410		8.7	115	175	1100870	
4.2	78	119	1100420		8.8	115	175	1100880	
4.3	82	126	1100430		8.9	115	175	1100890	
4.4	82	126	1100440		9	115	175	1100900	
4.5	82	126	1100450		9.1	115	175	1100910	
4.6	82	126	1100460		9.2	115	175	1100920	
4.7	82	126	1100470		9.3	115	175	1100930	
4.8	87	132	1100480		9.4	115	175	1100940	
4.9	87	132	1100490		9.5	115	175	1100950	
5	87	132	1100500		9.6	121	184	1100960	
5.1	87	132	1100510		9.7	121	184	1100970	
5.2	87	132	1100520		9.8	121	184	1100980	
5.3	87	132	1100530		9.9	121	184	1100990	
5.4	91	139	1100540		10	121	184	1101000	
5.5	91	139	1100550						



STRAIGHT
SHANK DRILLS



shaping your dreams

46

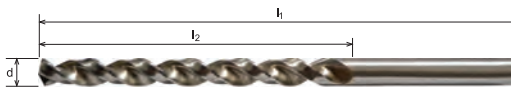
JUNE 2023 V3 SOMTA CATALOGUE

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UDL Long Series Drills

Ideal for use on CNC machines where high productivity and accurate holes are required. High performance deep hole drilling.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	○	○	○	○	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

d	l ₂	l ₁	Code	Price	d	l ₂	l ₁	Code	Price
3.1	69	106	1090310		5.5	91	139	1090550	
3.9	78	119	1090390		5.8	91	139	1090580	
4.6	82	126	1090460		6.4	97	148	1090640	
4.8	87	132	1090480		7.1	102	156	1090710	
5.1	87	132	1090510		7.5	102	156	1090750	
5.2	87	132	1090520		8.4	109	165	1090840	
5.4	91	139	1090540		9.6	121	184	1090960	

Not available once current stock is depleted



Code
109

Properties		
mm	DIN 340	HSS Co5
8-10 xD	TYPE FS	130°
h8	40°	BRIGHT FINISH
pg 66		

QTY
↓
10 ≤ 9.5mm
5 ≤ 13.0mm
1 > 13.0mm

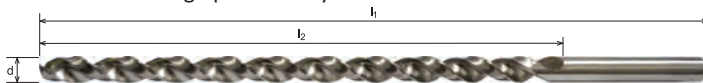




OSG GROUP COMPANY

UDL Extra Length Drills

Ideal for use on CNC machines where high productivity and accurate holes are required. High performance extra deep hole drilling.



Codes

118
119
120

Properties



SPLIT POINT
sizes below
3.0 mm



UX POINT
3.0 mm and
above

mm

DIN 1869

HSS Co5



TYPE FS



40°

BRIGHT FINISH



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	○	○	○	○	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

d	l ₂	l ₁	Code	Price	d	l ₂	l ₁	Code	Price
---	----------------	----------------	------	-------	---	----------------	----------------	------	-------

Series 1

2	85	125	1180200		8.5	165	240	1180850	
2	90	135	1180201		9	175	250	1180900	
2.5	95	140	1180250		9.5	175	250	1180950	
3	100	150	1180300		10	185	265	1181000	
3	105	155	1180301		*11	195	280	1181100	
3.5	115	165	1180350		*11.5	195	280	1181150	
4	120	175	1180400		*12	205	295	1181200	
4.5	125	185	1180450		*12.5	205	295	1181250	
5	135	195	1180500		*13	205	295	1181300	
5.5	140	205	1180550		*13.5	220	310	1181350	
6	140	205	1180600		*14	220	310	1181400	
6.5	150	215	1180650		*14.5	220	310	1181450	
7	155	225	1180700		*15	220	310	1181500	
7.5	155	225	1180750		*15.5	230	320	1181550	
8	165	240	1180800		*16	230	320	1181600	

Series 2

3	130	190	1190300		9.5	220	320	1190950	
3	135	200	1190301		10	235	340	1191000	
3.5	145	210	1190350		*10.5	235	340	1191050	
4	150	220	1190400		*11	250	365	1191100	
4.5	160	235	1190450		*12	260	375	1191200	
5	170	245	1190500		*12.5	260	375	1191250	
5.5	180	260	1190550		*13	260	375	1191300	
6	180	260	1190600		*13.5	275	380	1191350	
6.5	190	275	1190650		*14	275	380	1191400	
7	200	290	1190700		*14.5	275	380	1191450	
7.5	200	290	1190750		*15	275	380	1191500	
8	210	305	1190800		*15.5	290	400	1191550	
8.5	210	305	1190850		*16	290	400	1191600	
9	220	320	1190900						

Series 3

4	190	280	1200400		9	280	410	1200900	
4.5	200	295	1200450		9.5	280	410	1200950	
5	210	315	1200500		10	295	430	1201000	
5.5	225	330	1200550		*10.5	295	430	1201050	
6	225	330	1200600		*11	300	455	1201100	
6.5	235	350	1200650		*11.5	300	455	1201150	
7	250	370	1200700		*12	300	480	1201200	
7.5	250	370	1200750		*12.5	300	480	1201250	
8	265	390	1200800		*13	300	480	1201300	
8.5	265	390	1200850						

* Works Standard



STRAIGHT
SHANK DRILLS



shaping your dreams

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JUNE 2023 V3 SOMTA CATALOGUE

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Straight Shank Oil Tube Chipbreaker Jobber Drills

High performance production drilling.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●

d	d ₁	l ₂	l ₁	Code	Price
12	12	78	125	10F1200	
12.5	14	88	135	10F1250	
13	14	88	135	10F1300	
13.5	14	88	135	10F1350	
14	14	88	135	10F1400	
14.5	16	100	150	10F1450	
15	16	100	150	10F1500	
15.5	16	100	150	10F1550	
16	16	100	150	10F1600	
16.5	18	115	165	10F1650	
17	18	115	165	10F1700	
17.5	18	115	165	10F1750	
18	18	115	165	10F1800	
18.5	20	128	180	10F1850	
19	20	128	180	10F1900	
19.5	20	128	180	10F1950	
20	20	128	180	10F2000	

Not available once current stock is depleted

Straight Shank Oil Tube Chipbreaker Long Series Drills

High performance production drilling.



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4

d	d ₁	l ₂	l ₁	Code	Price
12	12	138	185	10L1200	
12.5	14	158	205	10L1250	
13	14	158	205	10L1300	
13.5	14	158	205	10L1350	
14	14	158	205	10L1400	
14.5	16	180	230	10L1450	
15	16	180	230	10L1500	
15.5	16	180	230	10L1550	
16	16	180	230	10L1600	
16.5	18	200	250	10L1650	
17	18	200	250	10L1700	
17.5	18	200	250	10L1750	
18	18	200	250	10L1800	
18.5	20	228	280	10L1850	
19	20	228	280	10L1900	
19.5	20	228	280	10L1950	
20	20	228	280	10L2000	

Not available once current stock is depleted

Code
10L

Properties		
mm	WORKS STD.	HSS Co5
5xD	TYPE N	118°
h8	30°	
TiAIN	pg 68	



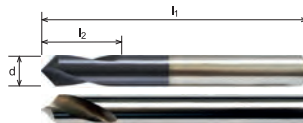
STRAIGHT
SHANK DRILLS



OSG GROUP COMPANY

NC Spotting Drills

For accurate positioning of holes. Ideal for CNC lathes.
Alternative to using Centre drills.



Codes
184, 185

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	○	○	○	○		○	○	○	○	○	○	○					○	○	○	○	●	●	●	●	●	●				

Properties		
STANDARD POINT		
mm	DIN 1897	HSS Co5
3xD	90°	120°
h8	h6	20°
TiAIN BRIGHT FINISH	pg 68-69	

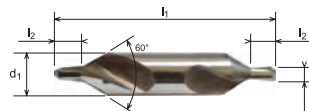
d	l ₂	l ₁	TiAlN Coated		Bright Finish	
			Code	Price	Code	Price
90° Drill Point Angle						
3	10	46	1840300		1840300B	
4	12	55	1840400		1840400B	
5	14	62	1840500		1840500B	
6	16	66	1840600		1840600B	
8	21	79	1840800		1840800B	
10	25	89	1841000		1841000B	
12	30	102	1841200		1841200B	
16	38	115	1841600		1841600B	
20	45	131	1842000		1842000B	
120° Drill Point Angle						
3	10	46	1850300		1850300B	
4	12	55	1850400		1850400B	
5	14	62	1850500		1850500B	
6	16	66	1850600		1850600B	
8	21	79	1850800		1850800B	
10	25	89	1851000		1851000B	
12	30	102	1851200		1851200B	
16	38	115	1851600		1851600B	
20	45	131	1852000		1852000B	



Code
1NA

Centre Drills - American Standard

For general centering operations on workpieces requiring additional machining between centres.



Properties		
inch	ANSI	HSS
60°	BRIGHT FINISH	pg 69

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

Ref. Number	d	d ₁	l ₂	l ₁	Code	Price
No. 1	1.19	3.18	1.2	32	1NA0001	
No. 2	1.98	4.76	2.0	48	1NA0002	
No. 3	2.78	6.35	2.8	51	1NA0003	
No. 4	3.18	7.94	3.2	54	1NA0004	
No. 5	4.76	11.11	4.8	70	1NA0005	
No. 6	5.56	12.7	5.5	76	1NA0006	
No. 7	6.35	15.88	6.4	83	1NA0007	



STRAIGHT SHANK DRILLS

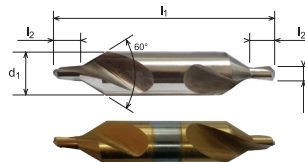


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JUNE 2023 V3 SOMTA CATALOGUE

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OSG GROUP COMPANY

Centre Drills - Form A

For general centering operations on workpieces requiring additional machining between centres.

P						M				K				Ti			Ni			Cu				N				Syn			H				
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4	
●	●	●	●	○	○	○	○	○	○	●	●	○	○											○	○	○	○	○	○	○	○	○	○	○	○

d	d ₁	l ₂	l ₁	Bright Finish		TiN Coated	
				Code	Price	Code	Price
0.8	3.15	1.1	25	1140080		1140080T	
1	3.15	1.3	31.5	1140100		1140100T	
1.25	3.15	1.6	31.5	1140125		1140125T	
1.6	4	2	35.5	1140160		1140160T	
2	5	2.5	40	1140200		1140200T	
2.5	6.3	3.1	45	1140250		1140250T	
3.15	8	3.9	50	1140315		1140315T	
4	10	5	56	1140400		1140400T	
5	12.5	6.3	63	1140500		1140500T	
6.3	16	8	71	1140630		1140630T	
8	20	10.1	80	1140800		1140800T	
10	25	12.8	100	1141000		1141000T	

Description	Code	Price
-------------	------	-------



Centre Drill Set - TiN Coated

1140000T

THIS SET CONTAINS:

2mm - 1140200T, 2.5mm - 1140250T,

3.15mm - 1140315T, 4mm - 1140400T,

6.3mm - 1140630T

Ref. Number	d	d ₁	l ₂	l ₁	Bright Finish Code	Price
BS1	1.19	3.18	1.8	38	1150119	
BS2	1.59	4.76	2.2	45	1150159	
BS3	2.38	6.35	3.6	51	1150238	
BS4	3.18	7.94	4.4	57	1150318	
BS5	4.76	11.11	6.8	64	1150476	
BS6	6.35	15.88	8.7	76	1150635	
BS7	7.94	19.05	11.1	89	1150754	

Description	Code	Price
-------------	------	-------



Centre Drill Set - TiN Coated

1150000T

THIS SET CONTAINS:

BS2 - 1150159T, BS3 - 1150238T,

BS4 - 1150318T, BS5 - 1150476T,

BS6 - 1150635T

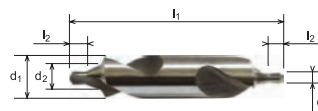




OSG GROUP COMPANY

Centre Drills - Form B

For centering operations as in Type A, but to produce a protected centre.



Code
138

P	M	K	Ti	Ni	Cu	N	Syn	H
1.1 1.2 1.3 1.4 1.5 1.6	2.1 2.2 2.3 2.4	3.1 3.2 3.3 3.4	4.1 4.2 4.3	5.1 5.2 5.3	6.1 6.2 6.3 6.4	7.1 7.2 7.3 7.4	8.1 8.2 8.3	9.1 9.2 9.3 9.4
● ● ● ● ○ ○	○ ○ ○ ○ ○ ○	● ● ○ ○	○ ○ ○ ○	○ ○ ○ ○	○ ○ ○ ○	○ ○ ○ ○	○ ○ ○ ○	○ ○ ○ ○

d	d ₁	d ₂	l ₂	l ₁	Code	Price
1	4	2.12	1.3	35.5	1380100	
5	18	10.6	6.3	75	1380500	

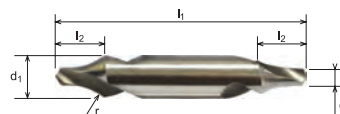
Not available once current stock is depleted



Properties		
mm	DIN 333	HSS
60° 120°	BRIGHT FINISH	pg 69

Centre Drills - Form R

Same as Type A, but produces a radius centre suitable for a variety of male centre angles.



P	M	K	Ti	Ni	Cu	N	Syn	H
1.1 1.2 1.3 1.4 1.5 1.6	2.1 2.2 2.3 2.4	3.1 3.2 3.3 3.4	4.1 4.2 4.3	5.1 5.2 5.3	6.1 6.2 6.3 6.4	7.1 7.2 7.3 7.4	8.1 8.2 8.3	9.1 9.2 9.3 9.4
● ● ● ● ○ ○	○ ○ ○ ○ ○ ○	● ● ○ ○	○ ○ ○ ○	○ ○ ○ ○	○ ○ ○ ○	○ ○ ○ ○	○ ○ ○ ○	○ ○ ○ ○

d	d ₁	r		l ₂	l ₁	Code	Price
		max.	min.				
1.25	3.15	4	3.15	3.35	31.5	1390125	
8	20	25	20	21.2	80	1390800	

Not available once current stock is depleted



Code
139

P	M	K	Ti	Ni	Cu	N	Syn	H
1.1 1.2 1.3 1.4 1.5 1.6	2.1 2.2 2.3 2.4	3.1 3.2 3.3 3.4	4.1 4.2 4.3	5.1 5.2 5.3	6.1 6.2 6.3 6.4	7.1 7.2 7.3 7.4	8.1 8.2 8.3	9.1 9.2 9.3 9.4
● ● ● ● ○ ○	○ ○ ○ ○ ○ ○	● ● ○ ○	○ ○ ○ ○	○ ○ ○ ○	○ ○ ○ ○	○ ○ ○ ○	○ ○ ○ ○	○ ○ ○ ○

d	d ₁	r		l ₂	l ₁	Code	Price
		max.	min.				
1.25	3.15	4	3.15	3.35	31.5	1390125	
8	20	25	20	21.2	80	1390800	

Not available once current stock is depleted



Properties		
mm	DIN 333	HSS
60° 120°	BRIGHT FINISH	pg 69



STRAIGHT
SHANK DRILLS



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d	d ₁	l ₂	l ₁	Code	Price
Jobber					
3	2.8	28	60	1860300	
4	3.2	40	75	1860400	
4.5	3.8	50	85	1860450	
5	4.2	50	85	1860500	
5.5	4.6	50	85	1860550	
6	5	60	100	1860600	
6.5	5.5	60	100	1860650	
7	5.5	60	100	1860700	
8	7	80	120	1860800	
8.5	7.5	80	120	1860850	
9	8	80	120	1860900	
10	8	90	150	1861000	
11	9	90	150	1861100	
12	10	90	150	1861200	
13	10	90	150	1861300	
14	10	90	150	1861400	
15	10	90	150	1861500	
16	10	90	150	1861600	
18	13	100	160	1861800	
19	13	100	160	1861900	
20	13	100	160	1862000	
22	13	100	160	1862200	
24	13	100	160	1862400	
25	13	100	160	1862500	
Long Series					
10	8	250	330	1871000	
13	10	250	330	1871300	
Extra Length					
25	13	350	400	1882500	

Not available once current stock is depleted

Codes

186 - 188

Properties

mm	5xD 186	8-10 xD 187
15-20 xD 188		





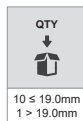
OSG GROUP COMPANY

Codes

291
292
295

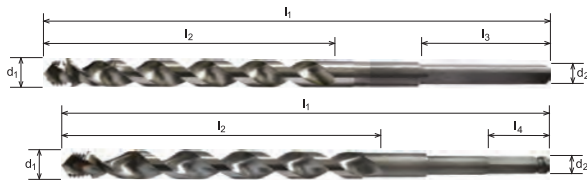
Properties

mm	WORKS STD.	HSS
15-20 xD	100°	42° • 44°
BRIGHT FINISH		



Sorgers

A wood auger for drilling all types of wood.



d ₁	l ₁	l ₂	l ₃	d ₂	Code	Price
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Standard with Flat

15	300	180	80	12.3	2911500	
17.5	300	180	80	12.3	2911750	
19	300	180	80	12.3	2911900	
22	300	200	80	12.3	2912200	

Standard Plain Shank

17.5	300	180	80	12.3	2911751	
19	300	180	80	12.3	2911901	
22	300	200	80	12.3	2912201	

Mining Plain Shank

17.5	310	210	100	16	2951750	
19	310	210	100	19	2951900	

d ₁	l ₁	l ₂	l ₄	d ₂	Code	Price
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with Hexagon Shank

17.5	300	180	40	11.11	2921750	
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Not available once current stock is depleted



STRAIGHT
SHANK DRILLS



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Straight Shank Drills Cutting Data



If you have any cutting tool problem,
please feel free to contact our technical sales representatives.

Download the Somta Tools app to access machining data on your mobile or desktop.

MFD-03C/05C/08C

Material	Ø	Vc m/min	3	4	5	6	8	10	12
			F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	1.1	125	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350
	1.2	115	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350
	1.3	110	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350
	1.4	95	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350
	1.5	75	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350
	1.6	65	0.053-0.088	0.060-0.100	0.068-0.113	0.080-0.134	0.105-0.175	0.128-0.213	0.150-0.250
M	2.1	55	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350
	2.2	35	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350
	2.3	30	0.053-0.088	0.060-0.100	0.068-0.113	0.080-0.134	0.105-0.175	0.128-0.213	0.150-0.250
K	3.1	110	0.098-0.163	0.113-0.188	0.128-0.213	0.150-0.250	0.195-0.325	0.248-0.413	0.285-0.475
	3.2	110	0.098-0.163	0.113-0.188	0.128-0.213	0.150-0.250	0.195-0.325	0.248-0.413	0.285-0.475
	3.3	80	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350
Ti	3.4	80	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350
	4.1	55	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350
	4.2	45	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350
Cu	4.3	40	0.053-0.088	0.060-0.100	0.068-0.113	0.080-0.134	0.105-0.175	0.128-0.213	0.150-0.250
	6.1	125	0.098-0.163	0.113-0.188	0.128-0.213	0.150-0.250	0.195-0.325	0.248-0.413	0.285-0.475
	6.2	220	0.098-0.163	0.113-0.188	0.128-0.213	0.150-0.250	0.195-0.325	0.248-0.413	0.285-0.475
N	6.3	220	0.098-0.163	0.113-0.188	0.128-0.213	0.150-0.250	0.195-0.325	0.248-0.413	0.285-0.475
	6.4	100	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350
	7.1	250	0.098-0.163	0.113-0.188	0.128-0.213	0.150-0.250	0.195-0.325	0.248-0.413	0.285-0.475
H	7.2	250	0.098-0.163	0.113-0.188	0.128-0.213	0.150-0.250	0.195-0.325	0.248-0.413	0.285-0.475
	7.3	200	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350
	7.4	150	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350
H	9.1	50	0.053-0.088	0.060-0.100	0.068-0.113	0.080-0.134	0.105-0.175	0.128-0.213	0.150-0.250
	9.2	30	0.053-0.088	0.060-0.100	0.068-0.113	0.080-0.134	0.105-0.175	0.128-0.213	0.150-0.250
	9.3	25	0.053-0.088	0.060-0.100	0.068-0.113	0.080-0.134	0.105-0.175	0.128-0.213	0.150-0.250
	9.4	15	0.053-0.088	0.060-0.100	0.068-0.113	0.080-0.134	0.105-0.175	0.128-0.213	0.150-0.250

% Speed and Feed reduction for deep hole drilling:

More than 3 x Drill Diameter - 10%, More than 4 x Drill Diameter - 20%, More than 5 x Drill Diameter - 30%, More than 6 x Drill Diameter - 40%

01J Coated

Material	Ø	Vc m/min	1	2	3	4	5	6	8	10	12	15
			F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	1.1	125	0.029-0.048	0.052-0.086	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	1.2	110	0.029-0.048	0.052-0.086	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	1.3	90	0.029-0.048	0.052-0.086	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	1.4	80	0.029-0.048	0.052-0.086	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	1.5	60	0.029-0.048	0.052-0.086	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	1.6	50	0.020-0.033	0.036-0.060	0.053-0.088	0.060-0.100	0.068-0.113	0.080-0.134	0.105-0.175	0.128-0.213	0.150-0.250	0.167-0.279
M	2.1	45	0.020-0.033	0.036-0.060	0.053-0.088	0.060-0.100	0.068-0.113	0.080-0.134	0.105-0.175	0.128-0.213	0.150-0.250	0.167-0.279
	2.2	40	0.011-0.019	0.021-0.035	0.030-0.050	0.038-0.063	0.045-0.075	0.053-0.088	0.068-0.113	0.083-0.138	0.098-0.163	0.120-0.200
	2.3	35	0.011-0.019	0.021-0.035	0.030-0.050	0.038-0.063	0.045-0.075	0.053-0.088	0.068-0.113	0.083-0.138	0.098-0.163	0.120-0.200
K	2.4	35	0.011-0.019	0.021-0.035	0.030-0.050	0.038-0.063	0.045-0.075	0.053-0.088	0.068-0.113	0.083-0.138	0.098-0.163	0.120-0.200
	3.1	90	0.037-0.061	0.067-0.111	0.098-0.163	0.113-0.188	0.128-0.213	0.150-0.250	0.195-0.325	0.248-0.413	0.285-0.475	0.314-0.523
	3.2	90	0.037-0.061	0.067-0.111	0.098-0.163	0.113-0.188	0.128-0.213	0.150-0.250	0.195-0.325	0.248-0.413	0.285-0.475	0.314-0.523
Ti	3.3	70	0.029-0.048	0.052-0.086	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	3.4	70	0.029-0.048	0.052-0.086	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	4.1	50	0.020-0.033	0.036-0.060	0.053-0.088	0.060-0.100	0.068-0.113	0.080-0.134	0.105-0.175	0.128-0.213	0.150-0.250	0.167-0.279
Cu	4.2	40	0.020-0.033	0.036-0.060	0.053-0.088	0.060-0.100	0.068-0.113	0.080-0.134	0.105-0.175	0.128-0.213	0.150-0.250	0.167-0.279
	4.3	35	0.011-0.019	0.021-0.035	0.030-0.050	0.038-0.063	0.045-0.075	0.053-0.088	0.068-0.113	0.083-0.138	0.098-0.163	0.120-0.200
	6.1	100	0.029-0.048	0.052-0.086	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
N	6.2	200	0.029-0.048	0.052-0.086	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	6.3	200	0.029-0.048	0.052-0.086	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	6.4	80	0.020-0.033	0.036-0.060	0.053-0.088	0.060-0.100	0.068-0.113	0.080-0.134	0.105-0.175	0.128-0.213	0.150-0.250	0.167-0.279
H	7.1	225	0.037-0.061	0.067-0.111	0.098-0.163	0.113-0.188	0.128-0.213	0.150-0.250	0.195-0.325	0.248-0.413	0.285-0.475	0.314-0.523
	7.2	225	0.037-0.061	0.067-0.111	0.098-0.163	0.113-0.188	0.128-0.213	0.150-0.250	0.195-0.325	0.248-0.413	0.285-0.475	0.314-0.523
	7.3	180	0.029-0.048	0.052-0.086	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
H	7.4	120	0.029-0.048	0.052-0.086	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	9.1	50	0.020-0.033	0.036-0.060	0.053-0.088	0.060-0.100	0.068-0.113	0.080-0.134	0.105-0.175	0.128-0.213	0.150-0.250	0.167-0.279
	9.2	30	0.020-0.033	0.036-0.060	0.053-0.088	0.060-0.100	0.068-0.113	0.080-0.134	0.105-0.175	0.128-0.213	0.150-0.250	0.167-0.279
	9.3	25	0.020-0.033	0.036-0.060	0.053-0.088	0.060-0.100	0.068-0.113	0.080-0.134	0.105-0.175	0.128-0.213	0.150-0.250	0.167-0.279
	9.4	15	0.020-0.033	0.036-0.060	0.053-0.088	0.060-0.100	0.068-0.113	0.080-0.134	0.105-0.175	0.128-0.213	0.150-0.250	0.167-0.279

Parameters based on ideal conditions.
Please adjust parameters accordingly to real applications.



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01J Uncoated

Material	Ø	Vc m/min	1	2	3	4	5	6	8	10	12	15
			F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	1.1	95	0.021-0.035	0.076-0.126	0.124-0.206	0.140-0.233	0.156-0.260	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
	1.2	80	0.021-0.035	0.076-0.126	0.124-0.206	0.140-0.233	0.156-0.260	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
	1.3	70	0.021-0.035	0.076-0.126	0.124-0.206	0.140-0.233	0.156-0.260	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
	1.4	60	0.021-0.035	0.076-0.126	0.124-0.206	0.140-0.233	0.156-0.260	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
	1.5	45	0.021-0.035	0.076-0.126	0.124-0.206	0.140-0.233	0.156-0.260	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
M	1.6	40	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
	2.1	35	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
	2.2	30	0.009-0.015	0.017-0.029	0.022-0.036	0.024-0.040	0.027-0.045	0.032-0.053	0.041-0.068	0.047-0.078	0.052-0.086	0.062-0.103
	2.3	25	0.009-0.015	0.017-0.029	0.022-0.036	0.024-0.040	0.027-0.045	0.032-0.053	0.041-0.068	0.047-0.078	0.052-0.086	0.062-0.103
	2.4	20	0.009-0.015	0.017-0.029	0.022-0.036	0.024-0.040	0.027-0.045	0.032-0.053	0.041-0.068	0.047-0.078	0.052-0.086	0.062-0.103
K	3.1	70	0.029-0.048	0.052-0.086	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	3.2	70	0.029-0.048	0.052-0.086	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	3.3	55	0.021-0.035	0.076-0.126	0.124-0.206	0.140-0.233	0.156-0.260	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
	3.4	55	0.021-0.035	0.076-0.126	0.124-0.206	0.140-0.233	0.156-0.260	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
	4.1	40	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
Ti	4.2	30	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
	4.3	25	0.009-0.015	0.017-0.029	0.022-0.036	0.024-0.040	0.027-0.045	0.032-0.053	0.041-0.068	0.047-0.078	0.052-0.086	0.062-0.103
	6.1	75	0.021-0.035	0.076-0.126	0.124-0.206	0.140-0.233	0.156-0.260	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
	6.2	150	0.021-0.035	0.076-0.126	0.124-0.206	0.140-0.233	0.156-0.260	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
	6.3	150	0.021-0.035	0.076-0.126	0.124-0.206	0.140-0.233	0.156-0.260	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
Cu	6.4	60	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
	7.1	225	0.037-0.061	0.067-0.111	0.098-0.163	0.113-0.188	0.128-0.213	0.150-0.250	0.195-0.325	0.248-0.413	0.285-0.475	0.314-0.523
	7.2	225	0.037-0.061	0.067-0.111	0.098-0.163	0.113-0.188	0.128-0.213	0.150-0.250	0.195-0.325	0.248-0.413	0.285-0.475	0.314-0.523
	7.3	180	0.029-0.048	0.052-0.086	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	7.4	120	0.029-0.048	0.052-0.086	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
N	9.1	45	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
	9.2	25	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
	9.3	20	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
	9.4	10	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339

01S Coated

Material	Ø	Vc m/min	1	2	3	4	5	6	8	10	12	15
			F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	1.1	125	0.037-0.061	0.067-0.111	0.098-0.163	0.113-0.188	0.128-0.213	0.150-0.250	0.195-0.325	0.248-0.413	0.285-0.475	0.314-0.523
	1.2	110	0.037-0.061	0.067-0.111	0.098-0.163	0.113-0.188	0.128-0.213	0.150-0.250	0.195-0.325	0.248-0.413	0.285-0.475	0.314-0.523
	1.3	90	0.037-0.061	0.067-0.111	0.098-0.163	0.113-0.188	0.128-0.213	0.150-0.250	0.195-0.325	0.248-0.413	0.285-0.475	0.314-0.523
	1.4	80	0.029-0.048	0.052-0.086	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	1.5	60	0.029-0.048	0.052-0.086	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
M	1.6	50	0.020-0.033	0.036-0.060	0.053-0.088	0.060-0.100	0.068-0.113	0.080-0.134	0.105-0.175	0.128-0.213	0.150-0.250	0.167-0.279
	2.1	45	0.020-0.033	0.036-0.060	0.053-0.088	0.060-0.100	0.068-0.113	0.080-0.134	0.105-0.175	0.128-0.213	0.150-0.250	0.167-0.279
	2.2	40	0.011-0.019	0.021-0.035	0.030-0.050	0.038-0.063	0.045-0.075	0.053-0.088	0.068-0.113	0.083-0.138	0.098-0.163	0.120-0.200
	2.3	35	0.011-0.019	0.021-0.035	0.030-0.050	0.038-0.063	0.045-0.075	0.053-0.088	0.068-0.113	0.083-0.138	0.098-0.163	0.120-0.200
	2.4	30	0.011-0.019	0.021-0.035	0.030-0.050	0.038-0.063	0.045-0.075	0.053-0.088	0.068-0.113	0.083-0.138	0.098-0.163	0.120-0.200
K	3.1	90	0.037-0.061	0.067-0.111	0.098-0.163	0.113-0.188	0.128-0.213	0.150-0.250	0.195-0.325	0.248-0.413	0.285-0.475	0.314-0.523
	3.2	90	0.037-0.061	0.067-0.111	0.098-0.163	0.113-0.188	0.128-0.213	0.150-0.250	0.195-0.325	0.248-0.413	0.285-0.475	0.314-0.523
	3.3	70	0.029-0.048	0.052-0.086	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	3.4	70	0.029-0.048	0.052-0.086	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	4.1	50	0.020-0.033	0.036-0.060	0.053-0.088	0.060-0.100	0.068-0.113	0.080-0.134	0.105-0.175	0.128-0.213	0.150-0.250	0.167-0.279
Ti	4.2	40	0.020-0.033	0.036-0.060	0.053-0.088	0.060-0.100	0.068-0.113	0.080-0.134	0.105-0.175	0.128-0.213	0.150-0.250	0.167-0.279
	4.3	35	0.011-0.019	0.021-0.035	0.030-0.050	0.038-0.063	0.045-0.075	0.053-0.088	0.068-0.113	0.083-0.138	0.098-0.163	0.120-0.200
	6.1	100	0.029-0.048	0.052-0.086	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	6.2	200	0.029-0.048	0.052-0.086	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	6.3	200	0.029-0.048	0.052-0.086	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
Cu	6.4	80	0.020-0.033	0.036-0.060	0.053-0.088	0.060-0.100	0.068-0.113	0.080-0.134	0.105-0.175	0.128-0.213	0.150-0.250	0.167-0.279
	7.1	225	0.037-0.061	0.067-0.111	0.098-0.163	0.113-0.188	0.128-0.213	0.150-0.250	0.195-0.325	0.248-0.413	0.285-0.475	0.314-0.523
	7.2	225	0.037-0.061	0.067-0.111	0.098-0.163	0.113-0.188	0.128-0.213	0.150-0.250	0.195-0.325	0.248-0.413	0.285-0.475	0.314-0.523
	7.3	180	0.029-0.048	0.052-0.086	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	7.4	120	0.029-0.048	0.052-0.086	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
N	9.1	50	0.020-0.033	0.036-0.060	0.053-0.088	0.060-0.100	0.068-0.113	0.080-0.134	0.105-0.175	0.128-0.213	0.150-0.250	0.167-0.279
	9.2	30	0.020-0.033	0.036-0.060	0.053-0.088	0.060-0.100	0.068-0.113	0.080-0.134	0.105-0.175	0.128-0.213	0.150-0.250	0.167-0.279
	9.3	25	0.020-0.033	0.036-0.060	0.053-0.088	0.060-0.100	0.068-0.113	0.080-0.134	0.105-0.175	0.128-0.213	0.150-0.250	0.167-0.279
	9.4	15	0.020-0.033	0.036-0.060	0.053-0.088	0.060-0.100	0.068-0.113	0.080-0.134	0.105-0.175	0.128-0.213	0.150-0.250	0.167-0.279



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Parameters based on ideal conditions. Please adjust parameters accordingly to real applications.

01S Uncoated

Material	Ø	Vc m/min	1	2	3	4	5	6	8	10	12	15
			F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	1.1	95	0.029-0.048	0.052-0.086	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	1.2	80	0.029-0.048	0.052-0.086	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	1.3	70	0.029-0.048	0.052-0.086	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	1.4	60	0.021-0.035	0.076-0.126	0.124-0.206	0.140-0.233	0.156-0.260	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
	1.5	45	0.021-0.035	0.076-0.126	0.124-0.206	0.140-0.233	0.156-0.260	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
	1.6	40	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
M	2.1	35	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
	2.2	30	0.009-0.015	0.017-0.029	0.022-0.036	0.024-0.040	0.027-0.045	0.032-0.053	0.041-0.068	0.047-0.078	0.052-0.086	0.062-0.103
	2.3	25	0.009-0.015	0.017-0.029	0.022-0.036	0.024-0.040	0.027-0.045	0.032-0.053	0.041-0.068	0.047-0.078	0.052-0.086	0.062-0.103
	2.4	20	0.009-0.015	0.017-0.029	0.022-0.036	0.024-0.040	0.027-0.045	0.032-0.053	0.041-0.068	0.047-0.078	0.052-0.086	0.062-0.103
K	3.1	70	0.029-0.048	0.052-0.086	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	3.2	70	0.029-0.048	0.052-0.086	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	3.3	55	0.021-0.035	0.076-0.126	0.124-0.206	0.140-0.233	0.156-0.260	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
	3.4	55	0.021-0.035	0.076-0.126	0.124-0.206	0.140-0.233	0.156-0.260	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
Ti	4.1	40	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
	4.2	30	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
	4.3	25	0.009-0.015	0.017-0.029	0.022-0.036	0.024-0.040	0.027-0.045	0.032-0.053	0.041-0.068	0.047-0.078	0.052-0.086	0.062-0.103
	4.4	20	0.009-0.015	0.017-0.029	0.022-0.036	0.024-0.040	0.027-0.045	0.032-0.053	0.041-0.068	0.047-0.078	0.052-0.086	0.062-0.103
Cu	6.1	75	0.021-0.035	0.076-0.126	0.124-0.206	0.140-0.233	0.156-0.260	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
	6.2	150	0.021-0.035	0.076-0.126	0.124-0.206	0.140-0.233	0.156-0.260	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
	6.3	150	0.021-0.035	0.076-0.126	0.124-0.206	0.140-0.233	0.156-0.260	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
	6.4	60	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
N	7.1	225	0.037-0.061	0.067-0.111	0.098-0.163	0.113-0.188	0.128-0.213	0.150-0.250	0.195-0.325	0.248-0.413	0.285-0.475	0.314-0.523
	7.2	225	0.037-0.061	0.067-0.111	0.098-0.163	0.113-0.188	0.128-0.213	0.150-0.250	0.195-0.325	0.248-0.413	0.285-0.475	0.314-0.523
	7.3	180	0.029-0.048	0.052-0.086	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	7.4	120	0.029-0.048	0.052-0.086	0.075-0.125	0.086-0.144	0.098-0.163	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
H	9.1	45	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
	9.2	25	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
	9.3	20	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
	9.4	10	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339

00CJ Coated

Material	Ø	Vc m/min	6	8	10	12	15
			F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	1.1	125	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	1.2	115	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	1.3	110	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	1.4	95	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	1.5	75	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	1.6	65	0.080-0.134	0.105-0.175	0.128-0.213	0.150-0.250	0.167-0.279
M	2.1	55	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	2.2	35	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	2.3	30	0.080-0.134	0.105-0.175	0.128-0.213	0.150-0.250	0.167-0.279
	3.1	110	0.150-0.250	0.195-0.325	0.248-0.413	0.285-0.475	0.314-0.523
K	3.2	110	0.150-0.250	0.195-0.325	0.248-0.413	0.285-0.475	0.314-0.523
	3.3	80	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	3.4	80	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
Ti	4.1	55	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	4.2	45	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	4.3	40	0.080-0.134	0.105-0.175	0.128-0.213	0.150-0.250	0.167-0.279
	6.1	125	0.150-0.250	0.195-0.325	0.248-0.413	0.285-0.475	0.314-0.523
Cu	6.2	220	0.150-0.250	0.195-0.325	0.248-0.413	0.285-0.475	0.314-0.523
	6.3	220	0.150-0.250	0.195-0.325	0.248-0.413	0.285-0.475	0.314-0.523
	6.4	100	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
N	7.1	250	0.150-0.250	0.195-0.325	0.248-0.413	0.285-0.475	0.314-0.523
	7.2	250	0.150-0.250	0.195-0.325	0.248-0.413	0.285-0.475	0.314-0.523
	7.3	200	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	7.4	150	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
H	9.1	50	0.080-0.134	0.105-0.175	0.128-0.213	0.150-0.250	0.167-0.279
	9.2	30	0.080-0.134	0.105-0.175	0.128-0.213	0.150-0.250	0.167-0.279
	9.3	25	0.080-0.134	0.105-0.175	0.128-0.213	0.150-0.250	0.167-0.279
	9.4	15	0.080-0.134	0.105-0.175	0.128-0.213	0.150-0.250	0.167-0.279

Parameters based on ideal conditions.
Please adjust parameters accordingly to real applications.



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OCJ Uncoated

Material	Ø	Vc m/min	6	8	10	12	15
			F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	1.1 ● 95		0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
	1.2 ● 85		0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
	1.3 ● 80		0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
	1.4 ● 70		0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
	1.5 ● 55		0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
	1.6 ● 50		0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
M	2.1 ○ 40		0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
	2.2 ○ 25		0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
	2.3 ○ 25		0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
K	3.1 ● 80		0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	3.2 ● 80		0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	3.3 ● 60		0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
	3.4 ● 60		0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
Ti	4.1 ○ 40		0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
	4.2 ○ 35		0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
	4.3 ○ 30		0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
Cu	6.1 ● 95		0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	6.2 ● 165		0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	6.3 ● 165		0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	6.4 ● 75		0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
N	7.1 ● 250		0.150-0.250	0.195-0.325	0.248-0.413	0.285-0.475	0.314-0.523
	7.2 ● 250		0.150-0.250	0.195-0.325	0.248-0.413	0.285-0.475	0.314-0.523
	7.3 ● 200		0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	7.4 ● 150		0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
H	9.1 ○ 45		0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
	9.2 ○ 25		0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
	9.3 ○ 20		0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
	9.4 ○ 10		0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339

OCS Coated

Material	Ø	Vc m/min	6	8	10	12	15
			F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	1.1 ● 125		0.150-0.250	0.195-0.325	0.248-0.413	0.285-0.475	0.314-0.523
	1.2 ● 115		0.150-0.250	0.195-0.325	0.248-0.413	0.285-0.475	0.314-0.523
	1.3 ● 110		0.150-0.250	0.195-0.325	0.248-0.413	0.285-0.475	0.314-0.523
	1.4 ● 95		0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	1.5 ● 75		0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	1.6 ● 65		0.080-0.134	0.105-0.175	0.128-0.213	0.150-0.250	0.167-0.279
M	2.1 ○ 55		0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	2.2 ○ 35		0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	2.3 ○ 30		0.080-0.134	0.105-0.175	0.128-0.213	0.150-0.250	0.167-0.279
K	3.1 ● 110		0.150-0.250	0.195-0.325	0.248-0.413	0.285-0.475	0.314-0.523
	3.2 ● 110		0.150-0.250	0.195-0.325	0.248-0.413	0.285-0.475	0.314-0.523
	3.3 ● 80		0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	3.4 ● 80		0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
Ti	4.1 ○ 55		0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	4.2 ○ 45		0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	4.3 ○ 40		0.080-0.134	0.105-0.175	0.128-0.213	0.150-0.250	0.167-0.279
Cu	6.1 ● 125		0.150-0.250	0.195-0.325	0.248-0.413	0.285-0.475	0.314-0.523
	6.2 ● 220		0.150-0.250	0.195-0.325	0.248-0.413	0.285-0.475	0.314-0.523
	6.3 ● 220		0.150-0.250	0.195-0.325	0.248-0.413	0.285-0.475	0.314-0.523
	6.4 ● 100		0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
N	7.1 ○ 250		0.150-0.250	0.195-0.325	0.248-0.413	0.285-0.475	0.314-0.523
	7.2 ○ 250		0.150-0.250	0.195-0.325	0.248-0.413	0.285-0.475	0.314-0.523
	7.3 ○ 200		0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	7.4 ○ 150		0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
H	9.1 ● 50		0.080-0.134	0.105-0.175	0.128-0.213	0.150-0.250	0.167-0.279
	9.2 ● 30		0.080-0.134	0.105-0.175	0.128-0.213	0.150-0.250	0.167-0.279
	9.3 ● 25		0.080-0.134	0.105-0.175	0.128-0.213	0.150-0.250	0.167-0.279
	9.4 ● 15		0.080-0.134	0.105-0.175	0.128-0.213	0.150-0.250	0.167-0.279



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Parameters based on ideal conditions.
Please adjust parameters accordingly to real applications.

OCS Uncoated

Material	Ø	Vc m/min	6	8	10	12	15
			F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	1.1	95	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	1.2	85	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	1.3	80	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	1.4	70	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
	1.5	55	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
	1.6	50	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
M	2.1	40	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
	2.2	25	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
	2.3	25	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
K	3.1	80	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	3.2	80	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	3.3	60	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
	3.4	60	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
Ti	4.1	40	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
	4.2	35	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
	4.3	30	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
Cu	6.1	95	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	6.2	165	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	6.3	165	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	6.4	75	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
N	7.1	250	0.150-0.250	0.195-0.325	0.248-0.413	0.285-0.475	0.314-0.523
	7.2	250	0.150-0.250	0.195-0.325	0.248-0.413	0.285-0.475	0.314-0.523
	7.3	200	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	7.4	150	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
	7.5	150	0.115-0.191	0.150-0.250	0.188-0.313	0.210-0.350	0.233-0.388
H	9.1	45	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
	9.2	25	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
	9.3	20	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
	9.4	10	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
	9.5	10	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339

1X1, 1X2, 1X5

Material	Ø	Vc m/min	1	2	3	4	5	6	8	10	12	15	16	20
			F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	1.1	35	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350	0.240-0.400
	1.2	30	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350	0.240-0.400
	1.3	25	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253	0.158-0.263	0.186-0.310
	1.4	20	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253	0.158-0.263	0.186-0.310
K	3.1	30	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350	0.240-0.400
	3.2	24	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253	0.158-0.263	0.186-0.310
	7.1	33	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436	0.270-0.450	0.304-0.506
N	7.2	30	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388	0.240-0.400	0.270-0.450
	7.3	27	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350	0.240-0.400
	7.4	24	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253	0.158-0.263	0.186-0.310

1X3, 1X6

Material	Ø	Vc m/min	1	2	3	4	5	6	8	10	12	15	16	20
			F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	1.1	45	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350	0.240-0.400
	1.2	40	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350	0.240-0.400
	1.3	35	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253	0.158-0.263	0.186-0.310
	1.4	30	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253	0.158-0.263	0.186-0.310
K	3.1	40	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436	0.270-0.450	0.304-0.506
	3.2	30	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253	0.158-0.263	0.186-0.310
	3.3	28	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216	0.135-0.225	0.161-0.269
	3.4	26	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216	0.135-0.225	0.161-0.269
Cu	6.1	50	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238	0.154-0.256	0.173-0.289	0.180-0.300	0.210-0.350
	6.2	33	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388	0.240-0.400	0.270-0.450
	6.3	39	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350	0.240-0.400
	6.4	30	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238	0.154-0.256	0.173-0.289	0.180-0.300	0.210-0.350
N	7.1	41	0.020-0.033	0.069-0.115	0.113-0.188	0.128-0.213	0.143-0.238	0.165-0.275	0.210-0.350	0.248-0.413	0.263-0.438	0.291-0.485	0.300-0.500	0.338-0.563
	7.2	38	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436	0.270-0.450	0.304-0.506
	7.3	33	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388	0.240-0.400	0.270-0.450
	7.4	33	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388	0.240-0.400	0.270-0.450
Syn	8.1	30	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388	0.240-0.400	0.270-0.450
	8.2	50	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350	0.240-0.400
	8.3	35	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253	0.158-0.263	0.186-0.310

Parameters based on ideal conditions.
Please adjust parameters accordingly to real applications.



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101 - 102

Material	Ø Vc m/min	1	2	3	4	5	6	8	10	12	15	16	20
		F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	1.1 ● 35	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350	0.240-0.400
	1.2 ● 30	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350	0.240-0.400
	1.3 ● 25	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253	0.158-0.263	0.186-0.310
	1.4 ● 20	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253	0.158-0.263	0.186-0.310
K	3.1 ● 30	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350	0.240-0.400
	3.2 ● 24	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253	0.158-0.263	0.186-0.310
	3.3 ○ 20	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216	0.135-0.225	0.161-0.269
	3.4 ○ 14	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216	0.135-0.225	0.161-0.269
Cu	6.1 ○ 33	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238	0.154-0.256	0.173-0.289	0.180-0.300	0.210-0.350
	6.2 ○ 27	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388	0.240-0.400	0.270-0.450
	6.3 ○ 27	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350	0.240-0.400
	6.4 ○ 16	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238	0.154-0.256	0.173-0.289	0.180-0.300	0.210-0.350
N	7.1 ○ 33	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436	0.270-0.450	0.304-0.506
	7.2 ○ 30	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388	0.240-0.400	0.270-0.450
	7.3 ○ 27	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350	0.240-0.400
	7.4 ○ 24	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253	0.158-0.263	0.186-0.310
Syn	8.1 ○ 30	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436	0.270-0.450	0.304-0.506
	8.2 ○ 28	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350	0.240-0.400

1TT

Material	Ø Vc m/min	1	2	3	4	5	6	8	10	12	15	16
		F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	1.1 ● 47	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436	0.270-0.450
	1.2 ● 40	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436	0.270-0.450
	1.3 ● 35	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253	0.158-0.263
	1.4 ● 30	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253	0.158-0.263
M	2.1 ○ 20	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253	0.158-0.263
	2.2 ○ 12	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238	0.154-0.256	0.173-0.289	0.180-0.300
	2.3 ○ 16	0.011-0.019	0.024-0.040	0.033-0.055	0.038-0.063	0.042-0.070	0.048-0.080	0.060-0.100	0.074-0.123	0.083-0.138	0.094-0.156	0.098-0.163
	3.1 ● 40	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436	0.270-0.450
K	3.2 ● 30	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253	0.158-0.263
	3.3 ○ 28	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216	0.135-0.225
	3.4 ○ 26	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216	0.135-0.225
	6.1 ○ 50	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238	0.154-0.256	0.173-0.289	0.180-0.300
Cu	6.2 ○ 33	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388	0.240-0.400
	6.3 ○ 39	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350
	6.4 ○ 30	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238	0.154-0.256	0.173-0.289	0.180-0.300
	7.1 ○ 41	0.020-0.033	0.069-0.115	0.113-0.188	0.128-0.213	0.143-0.238	0.165-0.275	0.210-0.350	0.248-0.413	0.263-0.438	0.291-0.485	0.300-0.500
N	7.2 ○ 38	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436	0.270-0.450
	7.3 ○ 33	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388	0.240-0.400
	7.4 ○ 33	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253	0.158-0.263
	8.1 ○ 30	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436	0.270-0.450
Syn	8.2 ○ 50	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350
	8.3 ○ 35	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253	0.158-0.263

MFD-1J

Material	Ø Vc m/min	3	4	5	6	8	10	12
		F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	1.1 ● 54	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394
	1.2 ● 46	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394
	1.3 ● 43	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350
	1.4 ● 43	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350
M	1.5 ○ 31	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188
	1.6 ○ 26	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188
	2.1 ○ 20	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223
	3.1 ● 46	0.124-0.206	0.140-0.233	0.156-0.260	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481
K	3.2 ● 35	0.124-0.206	0.140-0.233	0.156-0.260	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481
	3.3 ● 35	0.124-0.206	0.140-0.233	0.156-0.260	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481
	6.1 ○ 88	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304
	6.2 ○ 89	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394
Cu	6.3 ○ 54	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394
	7.1 ○ 101	0.124-0.206	0.140-0.233	0.156-0.260	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481
	7.2 ○ 61	0.146-0.244	0.164-0.273	0.182-0.303	0.210-0.350	0.266-0.444	0.315-0.525	0.341-0.569



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Parameters based on ideal conditions.
Please adjust parameters accordingly to real applications.

Material	Ø	Vc m/min	1	2	3	4	5	6	8	10	12	15
			F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	1.1	35	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436
	1.2	30	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
	1.3	27	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238	0.154-0.256	0.173-0.289
	1.4	24	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253
	1.5	17	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216
M	1.6	10	0.012-0.020	0.029-0.048	0.040-0.066	0.045-0.075	0.051-0.085	0.059-0.098	0.074-0.123	0.089-0.149	0.098-0.163	0.112-0.186
	2.1	22	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216
	2.2	11	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238	0.154-0.256	0.173-0.289
K	2.3	15	0.011-0.019	0.029-0.048	0.040-0.066	0.045-0.075	0.051-0.085	0.059-0.098	0.074-0.123	0.089-0.149	0.098-0.163	0.112-0.186
	3.1	35	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
	3.2	28	0.012-0.020	0.029-0.048	0.040-0.066	0.045-0.075	0.051-0.085	0.059-0.098	0.074-0.123	0.089-0.149	0.098-0.163	0.112-0.186
Cu	3.3	22	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216
	3.4	17	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216
	6.1	38	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
N	6.2	40	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253
	6.3	27	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
	6.4	21	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253
Syn	7.1	33	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436
	7.2	30	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436
	7.3	30	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
	7.4	27	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253

140, 141

Material	Ø	Vc m/min	1	2	3	4	5	6	8	10	12	15	16	20
			F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	1.1	35	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436	0.270-0.450	0.304-0.506
	1.2	30	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436	0.270-0.450	0.304-0.506
	1.3	27	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238	0.154-0.256	0.173-0.289	0.180-0.300	0.210-0.350
	1.4	24	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238	0.154-0.256	0.173-0.289	0.180-0.300	0.210-0.350
	2.1	16	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253	0.158-0.263	0.186-0.310
M	2.2	9	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350	0.240-0.400
	2.3	10	0.012-0.020	0.029-0.048	0.040-0.066	0.045-0.075	0.051-0.085	0.059-0.098	0.074-0.123	0.089-0.149	0.098-0.163	0.112-0.186	0.116-0.194	0.141-0.235
	3.1	32	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436	0.270-0.450	0.304-0.506
K	3.2	27	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238	0.154-0.256	0.173-0.289	0.180-0.300	0.210-0.350
	3.3	20	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253	0.158-0.263	0.186-0.310
	3.4	16	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253	0.158-0.263	0.186-0.310
Cu	6.1	36	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350	0.240-0.400
	6.2	38	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436	0.270-0.450	0.304-0.506
	6.3	27	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388	0.240-0.400	0.270-0.450
N	6.4	16	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350	0.240-0.400
	7.1	33	0.020-0.033	0.069-0.115	0.113-0.188	0.128-0.213	0.143-0.238	0.165-0.275	0.210-0.350	0.248-0.413	0.263-0.438	0.291-0.485	0.300-0.500	0.338-0.563
	7.2	30	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436	0.270-0.450	0.304-0.506
Syn	7.3	30	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388	0.240-0.400	0.270-0.450
	7.4	25	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388	0.240-0.400	0.270-0.450
	8.1	30	0.020-0.033	0.069-0.115	0.113-0.188	0.128-0.213	0.143-0.238	0.165-0.275	0.210-0.350	0.248-0.413	0.263-0.438	0.291-0.485	0.300-0.500	0.338-0.563
	8.2	35	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388	0.240-0.400	0.270-0.450

Material	Ø	Vc m/min	25
			F (mm/rev.)
P	1.1	35	0.334-0.556
	1.2	30	0.334-0.556
	1.3	27	0.233-0.388
	1.4	21	0.233-0.388
M	2.1	16	0.206-0.344
	2.2	9	0.266-0.444
	2.3	10	0.158-0.263
K	3.1	32	0.334-0.556
	3.2	27	0.233-0.388
	3.3	20	0.206-0.344
Cu	6.1	36	0.206-0.344
	6.2	38	0.266-0.444
	6.3	27	0.300-0.500
	6.4	16	0.266-0.444
N	7.1	33	0.368-0.613
	7.2	30	0.334-0.556
	7.3	30	0.300-0.500
	7.4	25	0.300-0.500
Syn	8.1	30	0.368-0.613
	8.2	35	0.300-0.500

Parameters based on ideal conditions.
Please adjust parameters accordingly to real applications.



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Material	Ø	Vc m/min	1	2	3	4	5	6	8
			F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	1.1	35	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313
	1.2	30	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313
	1.3	27	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200
	1.4	21	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200
M	2.1	16	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173
	2.2	9	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238
	2.3	10	0.012-0.020	0.029-0.048	0.040-0.066	0.045-0.075	0.051-0.085	0.059-0.098	0.074-0.123
Cu	6.1	36	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238
	6.2	38	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313
	6.3	27	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275
	6.4	16	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238
N	7.1	33	0.020-0.033	0.069-0.115	0.113-0.188	0.128-0.213	0.143-0.238	0.165-0.275	0.210-0.350
	7.2	30	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313
	7.3	30	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275
Syn	7.4	25	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275
	8.1	30	0.020-0.033	0.069-0.115	0.113-0.188	0.128-0.213	0.143-0.238	0.165-0.275	0.210-0.350
	8.2	35	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275

1AQ

Material	Ø	Vc m/min	1	2	3	4	5	6	8	10	12	15
			F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	1.1	60	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436
	1.2	50	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436
	1.3	44	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388
	1.4	40	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388
	1.5	33	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238	0.154-0.256	0.173-0.289
	1.6	26	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238	0.154-0.256	0.173-0.289
N	7.1	60	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436
	7.2	45	0.024-0.040	0.089-0.149	0.146-0.244	0.164-0.273	0.182-0.303	0.210-0.350	0.266-0.444	0.315-0.525	0.341-0.569	0.361-0.601
	7.3	40	0.024-0.040	0.089-0.149	0.146-0.244	0.164-0.273	0.182-0.303	0.210-0.350	0.266-0.444	0.315-0.525	0.341-0.569	0.361-0.601
	7.4	48	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388
Syn	8.1	55	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388
	8.2	40	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238	0.154-0.256	0.173-0.289

1BB

Material	Ø	Vc m/min	1	2	3	4	5	6	8	10	12	15
			F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	1.1	38	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
	1.2	33	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
	1.3	26	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
	1.4	26	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
	1.5	21	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216
	1.6	25	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253
M	2.1	17	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216
	2.2	9	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216
	2.3	11	0.011-0.019	0.024-0.040	0.033-0.055	0.038-0.063	0.042-0.070	0.048-0.080	0.060-0.100	0.074-0.123	0.083-0.138	0.094-0.156
Ti	4.1	35	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238	0.154-0.256	0.173-0.289
	4.2	34	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238	0.154-0.256	0.173-0.289
	4.3	10	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216
Ni	5.1	22	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388
	5.2	11	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388
	5.3	10	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216



1G7

Material	Ø Vc m/min	1	2	3	4	5	6	8	10	12	15
		F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	1.1 ● 60	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436
	1.2 ● 50	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436
	1.3 ○ 44	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388
	1.4 ○ 44	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388
	1.5 ● 33	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238	0.154-0.256	0.173-0.289
M	1.6 ○ 26	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238	0.154-0.256	0.173-0.289
	2.1 ○ 22	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216
K	2.2 ○ 11	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238	0.154-0.256	0.173-0.289
	2.3 ○ 15	0.011-0.019	0.024-0.040	0.033-0.055	0.038-0.063	0.042-0.070	0.048-0.080	0.060-0.100	0.074-0.123	0.083-0.138	0.094-0.156
	3.1 ○ 35	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
	3.2 ○ 28	0.012-0.020	0.029-0.048	0.040-0.066	0.045-0.075	0.051-0.085	0.059-0.098	0.074-0.123	0.089-0.149	0.098-0.163	0.112-0.186
	3.3 ○ 22	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216
Cu	3.4 ○ 17	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216
	6.1 ○ 38	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
	6.2 ○ 40	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253
	6.3 ○ 27	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
	6.4 ○ 48	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388
N	7.1 ○ 33	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436
	7.2 ○ 30	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388
	7.3 ○ 30	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
	7.4 ○ 27	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253

1R5

Material	Ø Vc m/min	1	2	3	4	5	6	8	10	12	15
		F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	1.1 ○ 60	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436
	1.2 ○ 50	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436
	1.3 ○ 44	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388
	1.4 ○ 44	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388
	1.5 ● 33	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238	0.154-0.256	0.173-0.289
Ni	1.6 ● 26	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238	0.154-0.256	0.173-0.289
	5.1 ○ 22	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388
	5.2 ○ 11	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388
	5.3 ○ 10	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216

1W6

Material	Ø Vc m/min	2	3	4	5	6	8	10	12
		F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
K	3.1 ● 58	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350
	3.2 ● 47	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350
	3.3 ● 34	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394
	3.4 ● 28	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350

Parameters based on ideal conditions.
Please adjust parameters accordingly to real applications.



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Material	Ø	Vc m/min	10	12	15	16	20	25	30
			F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	1.1 ○	35	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350	0.240-0.400	0.266-0.444	0.281-0.469
	1.2 ○	30	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350	0.240-0.400	0.266-0.444	0.281-0.469
	1.3 ○	25	0.124-0.206	0.134-0.223	0.152-0.253	0.158-0.263	0.186-0.310	0.206-0.344	0.221-0.369
	1.4 ○	20	0.105-0.175	0.113-0.188	0.130-0.216	0.135-0.225	0.161-0.269	0.180-0.300	0.195-0.325
	1.5 ○	13	0.089-0.149	0.098-0.163	0.112-0.186	0.116-0.194	0.141-0.235	0.158-0.263	0.171-0.285
M	1.6 ○	9	0.074-0.123	0.083-0.138	0.094-0.156	0.098-0.163	0.120-0.200	0.135-0.225	0.146-0.244
	2.1 ○	15	0.089-0.149	0.098-0.163	0.112-0.186	0.116-0.194	0.141-0.235	0.158-0.263	0.171-0.285
	2.2 ○	7	0.124-0.206	0.134-0.223	0.152-0.253	0.158-0.263	0.186-0.310	0.206-0.344	0.221-0.369
K	2.3 ○	7	0.060-0.100	0.068-0.113	0.077-0.129	0.081-0.135	0.101-0.169	0.115-0.191	0.124-0.206
	3.1 ○	27	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350	0.240-0.400	0.266-0.444	0.281-0.469
	3.2 ○	22	0.105-0.175	0.113-0.188	0.130-0.216	0.135-0.225	0.161-0.269	0.180-0.300	0.195-0.325
Cu	3.3 ○	19	0.089-0.149	0.098-0.163	0.112-0.186	0.116-0.194	0.141-0.235	0.158-0.263	0.171-0.285
	3.4 ○	12	0.089-0.149	0.098-0.163	0.112-0.186	0.116-0.194	0.141-0.235	0.158-0.263	0.171-0.285
	6.1 ○	35	0.124-0.206	0.134-0.223	0.152-0.253	0.158-0.263	0.186-0.310	0.206-0.344	0.221-0.369
N	6.2 ○	30	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350	0.240-0.400	0.266-0.444	0.281-0.469
	6.3 ○	27	0.143-0.238	0.154-0.256	0.173-0.289	0.180-0.300	0.210-0.350	0.233-0.388	0.248-0.413
	6.4 ○	16	0.124-0.206	0.134-0.223	0.152-0.253	0.158-0.263	0.186-0.310	0.206-0.344	0.221-0.369
Syn	7.1 ○	33	0.199-0.331	0.210-0.350	0.233-0.388	0.240-0.400	0.270-0.450	0.300-0.500	0.315-0.525
	7.2 ○	30	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350	0.240-0.400	0.266-0.444	0.281-0.469
	7.3 ○	27	0.143-0.238	0.154-0.256	0.173-0.289	0.180-0.300	0.210-0.350	0.233-0.388	0.248-0.413
Syn	7.4 ○	22	0.143-0.238	0.154-0.256	0.173-0.289	0.180-0.300	0.210-0.350	0.233-0.388	0.248-0.413
	8.1 ○	30	0.199-0.331	0.210-0.350	0.233-0.388	0.240-0.400	0.270-0.450	0.300-0.500	0.315-0.525
	8.2 ○	28	0.143-0.238	0.154-0.256	0.173-0.289	0.180-0.300	0.210-0.350	0.233-0.388	0.248-0.413
	8.3 ○	14	0.105-0.175	0.113-0.188	0.130-0.216	0.135-0.225	0.161-0.269	0.180-0.300	0.195-0.325

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Material	Ø	Vc m/min	1	2	3	4	5	6	8	10	12	15	16
			F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	1.1 ●	27	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238	0.154-0.256	0.173-0.289	0.180-0.300
	1.2 ●	25	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238	0.154-0.256	0.173-0.289	0.180-0.300
	1.3 ●	20	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216	0.135-0.225
	1.4 ●	16	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216	0.135-0.225
	2.1 ○	10	0.012-0.020	0.029-0.048	0.040-0.066	0.045-0.075	0.051-0.085	0.059-0.098	0.074-0.123	0.089-0.149	0.098-0.163	0.112-0.186	0.116-0.194
M	2.2 ○	6	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253	0.158-0.263
	2.3 ○	4	0.011-0.018	0.021-0.035	0.028-0.046	0.031-0.051	0.035-0.058	0.040-0.066	0.050-0.084	0.060-0.100	0.068-0.113	0.077-0.129	0.081-0.135
	3.1 ●	28	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350
K	3.2 ●	21	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216	0.135-0.225
	3.3 ○	15	0.012-0.020	0.029-0.048	0.040-0.066	0.045-0.075	0.051-0.085	0.059-0.098	0.074-0.123	0.089-0.149	0.098-0.163	0.112-0.186	0.116-0.194
	3.4 ○	13	0.012-0.020	0.029-0.048	0.040-0.066	0.045-0.075	0.051-0.085	0.059-0.098	0.074-0.123	0.089-0.149	0.098-0.163	0.112-0.186	0.116-0.194
Cu	6.1 ○	30	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216	0.135-0.225
	6.2 ○	32	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350
	6.3 ○	27	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238	0.154-0.256	0.173-0.289	0.180-0.300
N	6.4 ○	16	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216	0.135-0.225
	7.1 ○	32	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388	0.240-0.400
	7.2 ○	27	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350
Syn	7.3 ○	27	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238	0.154-0.256	0.173-0.289	0.180-0.300
	7.4 ○	25	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216	0.135-0.225
	8.1 ○	35	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388	0.240-0.400
	8.2 ○	26	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238	0.154-0.256	0.173-0.289	0.180-0.300

121 - 126, 132 - 136

Material	Ø	Vc m/min	1	2	3	4	5	6	8	10	12	15
			F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	1.1 ●	24	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216
	1.2 ●	22	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216
	1.3 ●	16	0.011-0.019	0.024-0.040	0.033-0.055	0.038-0.063	0.042-0.070	0.048-0.080	0.060-0.100	0.074-0.123	0.083-0.138	0.094-0.156
	1.4 ●	15	0.011-0.019	0.024-0.040	0.033-0.055	0.038-0.063	0.042-0.070	0.048-0.080	0.060-0.100	0.074-0.123	0.083-0.138	0.094-0.156
	2.1 ○	9	0.011-0.019	0.024-0.040	0.033-0.055	0.038-0.063	0.042-0.070	0.048-0.080	0.060-0.100	0.074-0.123	0.083-0.138	0.094-0.156
M	2.2 ○	4	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216
	2.3 ○	8	0.009-0.015	0.017-0.029	0.022-0.036	0.024-0.040	0.027-0.045	0.032-0.053	0.041-0.068	0.047-0.078	0.052-0.086	0.062-0.103
	3.1 ●	25	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238	0.154-0.256	0.173-0.289
K	3.2 ●	18	0.012-0.020	0.029-0.048	0.040-0.066	0.045-0.075	0.051-0.085	0.059-0.098	0.074-0.123	0.089-0.149	0.098-0.163	0.112-0.186
	3.3 ○	13	0.011-0.019	0.024-0.040	0.033-0.055	0.038-0.063	0.042-0.070	0.048-0.080	0.060-0.100	0.074-0.123	0.083-0.138	0.094-0.156
	3.4 ○	9	0.011-0.019	0.024-0.040	0.033-0.055	0.038-0.063	0.042-0.070	0.048-0.080	0.060-0.100	0.074-0.123	0.083-0.138	0.094-0.156
N	7.1 ○	24	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
	7.2 ○	22	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238	0.154-0.256	0.173-0.289
	7.3 ○	22	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253
Syn	7.4 ○	20	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216
	8.1 ○	30	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
	8.2 ○	26	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253



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Parameters based on ideal conditions.
Please adjust parameters accordingly to real applications.

154, 164 Bright Finish

Material	Ø	Vc m/min	1	2	3	4	5	6	8	10	12	15	16
			F (mm/rev)	F (mm/rev)	F (mm/rev)	F (mm/rev)	F (mm/rev)	F (mm/rev)	F (mm/rev)	F (mm/rev)	F (mm/rev)	F (mm/rev)	F (mm/rev)
P	1.1	38	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350
	1.2	33	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350
	1.3	26	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350
	1.4	26	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350
	1.5	21	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216	0.135-0.225
M	2.1	15	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216	0.135-0.225
	2.2	7	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216	0.135-0.225
	2.3	9	0.011-0.019	0.024-0.040	0.033-0.055	0.038-0.063	0.042-0.070	0.048-0.080	0.060-0.100	0.074-0.123	0.083-0.138	0.094-0.156	0.098-0.163
K	3.1	24	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436	0.270-0.450
	3.2	19	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436	0.270-0.450
	3.3	19	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436	0.270-0.450
Cu	3.4	14	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388	0.240-0.400
	6.1	65	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238	0.154-0.256	0.173-0.289	0.180-0.300
	6.2	53	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388	0.240-0.400
N	6.3	34	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350
	6.4	30	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238	0.154-0.256	0.173-0.289	0.180-0.300
	7.1	60	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436	0.270-0.450
Syn	7.2	45	0.024-0.040	0.089-0.149	0.146-0.244	0.164-0.273	0.182-0.303	0.210-0.350	0.266-0.444	0.315-0.525	0.341-0.569	0.361-0.601	0.368-0.613
	7.3	40	0.024-0.040	0.089-0.149	0.146-0.244	0.164-0.273	0.182-0.303	0.210-0.350	0.266-0.444	0.315-0.525	0.341-0.569	0.361-0.601	0.368-0.613
	7.4	28	0.021-0.035	0.076-0.126	0.124-0.206	0.140-0.233	0.156-0.260	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524	0.323-0.538
Syn	8.1	55	0.021-0.035	0.076-0.126	0.124-0.206	0.140-0.233	0.156-0.260	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524	0.323-0.538
	8.2	40	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238	0.154-0.256	0.173-0.289	0.180-0.300

163 Bright Finish

Material	Ø	Vc m/min	1	2	3	4	5	6	8	10	12	15
			F (mm/rev)	F (mm/rev)	F (mm/rev)	F (mm/rev)	F (mm/rev)	F (mm/rev)	F (mm/rev)	F (mm/rev)	F (mm/rev)	F (mm/rev)
P	1.1	40	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436
	1.2	34	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436
	1.3	26	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388
	1.4	32	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388
	1.5	23	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216
M	2.1	15	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253
	2.2	7	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253
	2.3	9	0.012-0.020	0.029-0.048	0.040-0.066	0.045-0.075	0.051-0.085	0.059-0.098	0.074-0.123	0.089-0.149	0.098-0.163	0.112-0.186
K	3.1	34	0.021-0.035	0.076-0.126	0.124-0.206	0.140-0.233	0.156-0.260	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
	3.2	26	0.021-0.035	0.076-0.126	0.124-0.206	0.140-0.233	0.156-0.260	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
	3.3	26	0.021-0.035	0.076-0.126	0.124-0.206	0.140-0.233	0.156-0.260	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
Cu	3.4	19	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436
	6.1	65	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
	6.2	66	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436
N	6.3	40	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436
	6.4	31	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238	0.154-0.256	0.173-0.289
	7.1	75	0.021-0.035	0.076-0.126	0.124-0.206	0.140-0.233	0.156-0.260	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
Syn	7.2	45	0.024-0.040	0.089-0.149	0.146-0.244	0.164-0.273	0.182-0.303	0.210-0.350	0.266-0.444	0.315-0.525	0.341-0.569	0.361-0.601
	7.3	40	0.024-0.040	0.089-0.149	0.146-0.244	0.164-0.273	0.182-0.303	0.210-0.350	0.266-0.444	0.315-0.525	0.341-0.569	0.361-0.601
	7.4	36	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436
Syn	8.1	55	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436
	8.2	40	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339

Parameters based on ideal conditions.
Please adjust parameters accordingly to real applications.



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163, 164 TiAlN Coated

Material	Ø	Vc m/min	1	2	3	4	5	6	8	10	12	15	16
			F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	1.1	54	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436	0.270-0.450
	1.2	46	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436	0.270-0.450
	1.3	43	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388	0.240-0.400
	1.4	43	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388	0.240-0.400
	1.5	31	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216	0.135-0.225
	1.6	26	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216	0.135-0.225
M	2.0	20	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253	0.158-0.263
	2.2	9	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253	0.158-0.263
K	3.2	12	0.012-0.020	0.029-0.048	0.040-0.066	0.045-0.075	0.051-0.085	0.059-0.098	0.074-0.123	0.089-0.149	0.098-0.163	0.112-0.186	0.116-0.194
	3.1	46	0.021-0.035	0.076-0.126	0.124-0.206	0.140-0.233	0.156-0.260	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524	0.323-0.538
	3.2	35	0.021-0.035	0.076-0.126	0.124-0.206	0.140-0.233	0.156-0.260	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524	0.323-0.538
	3.3	35	0.021-0.035	0.076-0.126	0.124-0.206	0.140-0.233	0.156-0.260	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524	0.323-0.538
Cu	3.4	26	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436	0.270-0.450
	6.1	88	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350
	6.2	89	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436	0.270-0.450
	6.3	54	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436	0.270-0.450
N	6.4	42	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238	0.154-0.256	0.173-0.289	0.180-0.300
	7.1	101	0.021-0.035	0.076-0.126	0.124-0.206	0.140-0.233	0.156-0.260	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524	0.323-0.538
	7.2	61	0.024-0.040	0.089-0.149	0.146-0.244	0.164-0.273	0.182-0.303	0.210-0.350	0.266-0.444	0.315-0.525	0.341-0.569	0.361-0.601	0.368-0.613
	7.3	54	0.024-0.040	0.089-0.149	0.146-0.244	0.164-0.273	0.182-0.303	0.210-0.350	0.266-0.444	0.315-0.525	0.341-0.569	0.361-0.601	0.368-0.613
Syn	8.1	49	0.021-0.035	0.076-0.126	0.124-0.206	0.140-0.233	0.156-0.260	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524	0.323-0.538
	8.2	74	0.021-0.035	0.076-0.126	0.124-0.206	0.140-0.233	0.156-0.260	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524	0.323-0.538
Syn	8.1	74	0.021-0.035	0.076-0.126	0.124-0.206	0.140-0.233	0.156-0.260	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524	0.323-0.538
	8.2	54	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350

109, 110

Material	Ø	Vc m/min	1	2	3	4	5	6	8	10	12	15
			F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	1.1	38	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253
	1.2	33	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253
	1.3	22	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238	0.154-0.256	0.173-0.289
	1.4	22	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238	0.154-0.256	0.173-0.289
	1.5	17	0.011-0.019	0.024-0.040	0.033-0.055	0.038-0.063	0.042-0.070	0.048-0.080	0.060-0.100	0.074-0.123	0.083-0.138	0.094-0.156
	2.1	15	0.011-0.019	0.024-0.040	0.033-0.055	0.038-0.063	0.042-0.070	0.048-0.080	0.060-0.100	0.074-0.123	0.083-0.138	0.094-0.156
M	2.2	7	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216
	2.3	9	0.011-0.018	0.021-0.035	0.028-0.046	0.031-0.051	0.035-0.058	0.040-0.066	0.050-0.084	0.060-0.100	0.068-0.113	0.077-0.129
K	3.1	16	0.021-0.035	0.076-0.126	0.124-0.206	0.140-0.233	0.156-0.260	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
	3.2	16	0.021-0.035	0.076-0.126	0.124-0.206	0.140-0.233	0.156-0.260	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
	3.3	16	0.021-0.035	0.076-0.126	0.124-0.206	0.140-0.233	0.156-0.260	0.180-0.300	0.229-0.381	0.270-0.450	0.289-0.481	0.314-0.524
	3.4	12	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
Cu	6.1	65	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253
	6.2	70	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253
	6.3	34	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238	0.154-0.256	0.173-0.289
	6.4	30	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238	0.154-0.256	0.173-0.289
N	7.1	53	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
	7.2	45	0.024-0.040	0.089-0.149	0.146-0.244	0.164-0.273	0.182-0.303	0.210-0.350	0.266-0.444	0.315-0.525	0.341-0.569	0.361-0.601
	7.3	40	0.024-0.040	0.089-0.149	0.146-0.244	0.164-0.273	0.182-0.303	0.210-0.350	0.266-0.444	0.315-0.525	0.341-0.569	0.361-0.601
	7.4	30	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238	0.154-0.256	0.173-0.289
Syn	8.1	55	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
	8.2	40	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253



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Parameters based on ideal conditions.
Please adjust parameters accordingly to real applications.

Material	Ø	Vc m/min	2	3	4	5	6	8	10	12	15	16
			F (mm/rev)	F (mm/rev)	F (mm/rev)	F (mm/rev)	F (mm/rev)	F (mm/rev)	F (mm/rev)	F (mm/rev)	F (mm/rev)	F (mm/rev)
P	1.1	31	0.024-0.040	0.033-0.055	0.038-0.063	0.042-0.070	0.048-0.080	0.060-0.100	0.074-0.123	0.083-0.138	0.094-0.156	0.098-0.163
	1.2	26	0.024-0.040	0.033-0.055	0.038-0.063	0.042-0.070	0.048-0.080	0.060-0.100	0.074-0.123	0.083-0.138	0.094-0.156	0.098-0.163
	1.3	22	0.024-0.040	0.033-0.055	0.038-0.063	0.042-0.070	0.048-0.080	0.060-0.100	0.074-0.123	0.083-0.138	0.094-0.156	0.098-0.163
	1.4	22	0.024-0.040	0.033-0.055	0.038-0.063	0.042-0.070	0.048-0.080	0.060-0.100	0.074-0.123	0.083-0.138	0.094-0.156	0.098-0.163
	1.5	12	0.017-0.029	0.022-0.036	0.024-0.040	0.027-0.045	0.032-0.053	0.041-0.068	0.047-0.078	0.052-0.086	0.062-0.103	0.065-0.108
M	2.1	12	0.021-0.035	0.028-0.046	0.031-0.051	0.035-0.058	0.040-0.066	0.050-0.084	0.060-0.100	0.068-0.113	0.077-0.129	0.081-0.135
	2.2	7	0.024-0.040	0.033-0.055	0.038-0.063	0.042-0.070	0.048-0.080	0.060-0.100	0.074-0.123	0.083-0.138	0.094-0.156	0.098-0.163
	2.3	8	0.017-0.029	0.022-0.036	0.024-0.040	0.027-0.045	0.032-0.053	0.041-0.068	0.047-0.078	0.052-0.086	0.062-0.103	0.065-0.108
K	3.1	23	0.024-0.040	0.033-0.055	0.038-0.063	0.042-0.070	0.048-0.080	0.060-0.100	0.074-0.123	0.083-0.138	0.094-0.156	0.098-0.163
	3.2	23	0.024-0.040	0.033-0.055	0.038-0.063	0.042-0.070	0.048-0.080	0.060-0.100	0.074-0.123	0.083-0.138	0.094-0.156	0.098-0.163
	3.3	16	0.024-0.040	0.033-0.055	0.038-0.063	0.042-0.070	0.048-0.080	0.060-0.100	0.074-0.123	0.083-0.138	0.094-0.156	0.098-0.163
	3.4	11	0.017-0.029	0.022-0.036	0.024-0.040	0.027-0.045	0.032-0.053	0.041-0.068	0.047-0.078	0.052-0.086	0.062-0.103	0.065-0.108
N	7.1	24	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350
	7.2	22	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238	0.154-0.256	0.173-0.289	0.180-0.300
	7.3	22	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253	0.158-0.263
	7.4	20	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216	0.135-0.225
	8.1	30	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350
Syn	8.2	26	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253	0.158-0.263

Material	Ø	Vc m/min	3	4	5	6	8	10	12	15	16
			F (mm/rev)	F (mm/rev)	F (mm/rev)	F (mm/rev)	F (mm/rev)	F (mm/rev)	F (mm/rev)	F (mm/rev)	F (mm/rev)
P	1.1	31	0.028-0.046	0.031-0.051	0.035-0.058	0.040-0.066	0.050-0.084	0.060-0.100	0.068-0.113	0.077-0.129	0.081-0.135
	1.2	26	0.028-0.046	0.031-0.051	0.035-0.058	0.040-0.066	0.050-0.084	0.060-0.100	0.068-0.113	0.077-0.129	0.081-0.135
	1.3	22	0.028-0.046	0.031-0.051	0.035-0.058	0.040-0.066	0.050-0.084	0.060-0.100	0.068-0.113	0.077-0.129	0.081-0.135
	1.4	22	0.028-0.046	0.031-0.051	0.035-0.058	0.040-0.066	0.050-0.084	0.060-0.100	0.068-0.113	0.077-0.129	0.081-0.135
	1.5	12	0.022-0.036	0.024-0.040	0.027-0.045	0.032-0.053	0.041-0.068	0.047-0.078	0.052-0.086	0.062-0.103	0.065-0.108
M	2.1	12	0.028-0.046	0.031-0.051	0.035-0.058	0.040-0.066	0.050-0.084	0.060-0.100	0.068-0.113	0.077-0.129	0.081-0.135
	2.2	7	0.028-0.046	0.031-0.051	0.035-0.058	0.040-0.066	0.050-0.084	0.060-0.100	0.068-0.113	0.077-0.129	0.081-0.135
	2.3	8	0.022-0.036	0.024-0.040	0.027-0.045	0.032-0.053	0.041-0.068	0.047-0.078	0.052-0.086	0.062-0.103	0.065-0.108
K	3.1	23	0.028-0.046	0.031-0.051	0.035-0.058	0.040-0.066	0.050-0.084	0.060-0.100	0.068-0.113	0.077-0.129	0.081-0.135
	3.2	23	0.028-0.046	0.031-0.051	0.035-0.058	0.040-0.066	0.050-0.084	0.060-0.100	0.068-0.113	0.077-0.129	0.081-0.135
	3.3	16	0.028-0.046	0.031-0.051	0.035-0.058	0.040-0.066	0.050-0.084	0.060-0.100	0.068-0.113	0.077-0.129	0.081-0.135
	3.4	11	0.022-0.036	0.024-0.040	0.027-0.045	0.032-0.053	0.041-0.068	0.047-0.078	0.052-0.086	0.062-0.103	0.065-0.108
N	7.1	24	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350
	7.2	22	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238	0.154-0.256	0.173-0.289	0.180-0.300
	7.3	22	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253	0.158-0.263
	7.4	20	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216	0.135-0.225
	8.1	30	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350
Syn	8.2	26	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253	0.158-0.263

Material	Ø	Vc m/min	4	5	6	8	10	12	15
			F (mm/rev)	F (mm/rev)	F (mm/rev)	F (mm/rev)	F (mm/rev)	F (mm/rev)	F (mm/rev)
P	1.1	31	0.024-0.040	0.027-0.045	0.032-0.053	0.041-0.068	0.047-0.078	0.052-0.086	0.062-0.103
	1.2	26	0.024-0.040	0.027-0.045	0.032-0.053	0.041-0.068	0.047-0.078	0.052-0.086	0.062-0.103
	1.3	22	0.024-0.040	0.027-0.045	0.032-0.053	0.041-0.068	0.047-0.078	0.052-0.086	0.062-0.103
	1.4	22	0.024-0.040	0.027-0.045	0.032-0.053	0.041-0.068	0.047-0.078	0.052-0.086	0.062-0.103
	1.5	12	0.024-0.040	0.027-0.045	0.032-0.053	0.041-0.068	0.047-0.078	0.052-0.086	0.062-0.103
M	2.1	12	0.024-0.040	0.027-0.045	0.032-0.053	0.041-0.068	0.047-0.078	0.052-0.086	0.062-0.103
	2.2	7	0.024-0.040	0.027-0.045	0.032-0.053	0.041-0.068	0.047-0.078	0.052-0.086	0.062-0.103
	2.3	8	0.024-0.040	0.027-0.045	0.032-0.053	0.041-0.068	0.047-0.078	0.052-0.086	0.062-0.103
K	3.1	23	0.024-0.040	0.027-0.045	0.032-0.053	0.041-0.068	0.047-0.078	0.052-0.086	0.062-0.103
	3.2	23	0.024-0.040	0.027-0.045	0.032-0.053	0.041-0.068	0.047-0.078	0.052-0.086	0.062-0.103
	3.3	16	0.024-0.040	0.027-0.045	0.032-0.053	0.041-0.068	0.047-0.078	0.052-0.086	0.062-0.103
	3.4	11	0.024-0.040	0.027-0.045	0.032-0.053	0.041-0.068	0.047-0.078	0.052-0.086	0.062-0.103
N	7.1	24	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
	7.2	22	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238	0.154-0.256	0.173-0.289
	7.3	22	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253
	7.4	20	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216
	8.1	30	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339
Syn	8.2	26	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253

Parameters based on ideal conditions.
Please adjust parameters accordingly to real applications.



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10F, 10L

Material	Ø	Vc m/min	12	15	16	20
			F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	1.1 ●	35	0.236-0.394	0.262-0.436	0.270-0.450	0.304-0.506
	1.2 ●	30	0.182-0.304	0.203-0.339	0.210-0.350	0.240-0.400
	1.3 ●	27	0.154-0.256	0.173-0.289	0.180-0.300	0.210-0.350
	1.4 ●	23	0.134-0.223	0.152-0.253	0.158-0.263	0.186-0.310
	1.5 ●	17	0.113-0.188	0.130-0.216	0.135-0.225	0.161-0.269
	1.6 ●	10	0.098-0.163	0.112-0.186	0.116-0.194	0.141-0.235
M	2.1 ●	24	0.113-0.188	0.130-0.216	0.135-0.225	0.161-0.269
	2.2 ●	11	0.154-0.256	0.173-0.289	0.180-0.300	0.210-0.350
	2.3 ●	17	0.083-0.138	0.094-0.156	0.098-0.163	0.120-0.200
K	3.1 ●	35	0.236-0.394	0.262-0.436	0.270-0.450	0.304-0.506
	3.2 ●	28	0.154-0.256	0.173-0.289	0.180-0.300	0.210-0.350
	3.3 ●	22	0.113-0.188	0.130-0.216	0.135-0.225	0.161-0.269
	3.4 ●	17	0.113-0.188	0.130-0.216	0.135-0.225	0.161-0.269
Ti	4.1 ○	28	0.154-0.256	0.173-0.289	0.180-0.300	0.210-0.350
	4.2 ○	20	0.098-0.163	0.112-0.186	0.116-0.194	0.141-0.235
	4.3 ○	11	0.083-0.138	0.094-0.156	0.098-0.163	0.120-0.200
Ni	5.1 ○	15	0.154-0.256	0.173-0.289	0.180-0.300	0.210-0.350
	5.2 ○	7	0.113-0.188	0.130-0.216	0.135-0.225	0.161-0.269
	5.3 ○	6	0.068-0.113	0.077-0.129	0.081-0.135	0.101-0.169
Cu	6.1 ●	38	0.289-0.481	0.314-0.524	0.323-0.538	0.364-0.606
	6.2 ●	40	0.236-0.394	0.262-0.436	0.270-0.450	0.304-0.506
	6.3 ●	27	0.182-0.304	0.203-0.339	0.210-0.350	0.240-0.400
	6.4 ●	21	0.134-0.223	0.152-0.253	0.158-0.263	0.186-0.310
N	7.1 ●	33	0.236-0.394	0.262-0.436	0.270-0.450	0.304-0.506
	7.2 ●	30	0.210-0.350	0.233-0.388	0.240-0.400	0.270-0.450
	7.3 ●	30	0.182-0.304	0.203-0.339	0.210-0.350	0.240-0.400
	7.4 ●	27	0.134-0.223	0.152-0.253	0.158-0.263	0.186-0.310
Syn	8.1 ●	35	0.263-0.438	0.291-0.485	0.300-0.500	0.338-0.563
	8.2 ●	28	0.236-0.394	0.262-0.436	0.270-0.450	0.304-0.506
	8.3 ●	20	0.182-0.304	0.203-0.339	0.210-0.350	0.240-0.400

184, 185 TiAlN Coated

Material	Ø	Vc m/min	3	4	5	6	8	10	12	16	20
			F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	1.1 ●	45	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.135-0.225	0.161-0.269
	1.2 ●	39	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.135-0.225	0.161-0.269
	1.3 ●	35	0.033-0.055	0.038-0.063	0.042-0.070	0.048-0.080	0.060-0.100	0.074-0.123	0.083-0.138	0.098-0.163	0.120-0.200
	1.4 ●	27	0.033-0.055	0.038-0.063	0.042-0.070	0.048-0.080	0.060-0.100	0.074-0.123	0.083-0.138	0.098-0.163	0.120-0.200
	1.5 ●	18	0.033-0.055	0.038-0.063	0.042-0.070	0.048-0.080	0.060-0.100	0.074-0.123	0.083-0.138	0.098-0.163	0.120-0.200
	1.6 ○	13	0.028-0.046	0.031-0.051	0.035-0.058	0.040-0.066	0.050-0.084	0.060-0.100	0.068-0.113	0.081-0.135	0.101-0.169
M	2.1 ○	20	0.033-0.055	0.038-0.063	0.042-0.070	0.048-0.080	0.060-0.100	0.074-0.123	0.083-0.138	0.098-0.163	0.120-0.200
	2.2 ○	11	0.040-0.066	0.045-0.075	0.051-0.085	0.059-0.098	0.074-0.123	0.089-0.149	0.098-0.163	0.116-0.194	0.141-0.235
	2.3 ○	13	0.028-0.046	0.031-0.051	0.035-0.058	0.040-0.066	0.050-0.084	0.060-0.100	0.068-0.113	0.081-0.135	0.101-0.169
K	3.1 ○	41	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.135-0.225	0.161-0.269
	3.2 ○	35	0.033-0.055	0.038-0.063	0.042-0.070	0.048-0.080	0.060-0.100	0.074-0.123	0.083-0.138	0.098-0.163	0.120-0.200
	3.3 ○	26	0.033-0.055	0.038-0.063	0.042-0.070	0.048-0.080	0.060-0.100	0.074-0.123	0.083-0.138	0.098-0.163	0.120-0.200
	3.4 ○	20	0.028-0.046	0.031-0.051	0.035-0.058	0.040-0.066	0.050-0.084	0.060-0.100	0.068-0.113	0.081-0.135	0.101-0.169
Cu	6.1 ○	35	0.040-0.066	0.045-0.075	0.051-0.085	0.059-0.098	0.074-0.123	0.089-0.149	0.098-0.163	0.116-0.194	0.141-0.235
	6.2 ○	42	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.135-0.225	0.161-0.269
	6.3 ○	35	0.040-0.066	0.045-0.075	0.051-0.085	0.059-0.098	0.074-0.123	0.089-0.149	0.098-0.163	0.116-0.194	0.141-0.235
	6.4 ○	20	0.040-0.066	0.045-0.075	0.051-0.085	0.059-0.098	0.074-0.123	0.089-0.149	0.098-0.163	0.116-0.194	0.141-0.235
N	7.1 ●	42	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.135-0.225	0.161-0.269
	7.2 ●	39	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.135-0.225	0.161-0.269
	7.3 ●	39	0.040-0.066	0.045-0.075	0.051-0.085	0.059-0.098	0.074-0.123	0.089-0.149	0.098-0.163	0.116-0.194	0.141-0.235
	7.4 ●	32	0.040-0.066	0.045-0.075	0.051-0.085	0.059-0.098	0.074-0.123	0.089-0.149	0.098-0.163	0.116-0.194	0.141-0.235
Syn	8.1 ●	39	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.158-0.263	0.186-0.310
	8.2 ●	45	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.135-0.225	0.161-0.269



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Parameters based on ideal conditions.
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184, 185 Bright Finish

Material	Ø	Vc m/min	3	4	5	6	8	10	12	16	20
			F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	1.1	35	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.135-0.225	0.161-0.269
	1.2	30	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.135-0.225	0.161-0.269
	1.3	27	0.033-0.055	0.038-0.063	0.042-0.070	0.048-0.080	0.060-0.100	0.074-0.123	0.083-0.138	0.098-0.163	0.120-0.200
	1.4	21	0.033-0.055	0.038-0.063	0.042-0.070	0.048-0.080	0.060-0.100	0.074-0.123	0.083-0.138	0.098-0.163	0.120-0.200
	1.5	14	0.033-0.055	0.038-0.063	0.042-0.070	0.048-0.080	0.060-0.100	0.074-0.123	0.083-0.138	0.098-0.163	0.120-0.200
M	1.6	10	0.028-0.046	0.031-0.051	0.035-0.058	0.040-0.066	0.050-0.084	0.060-0.100	0.068-0.113	0.081-0.135	0.101-0.169
	2.1	16	0.033-0.055	0.038-0.063	0.042-0.070	0.048-0.080	0.060-0.100	0.074-0.123	0.083-0.138	0.098-0.163	0.120-0.200
	2.2	9	0.040-0.066	0.045-0.075	0.051-0.085	0.059-0.098	0.074-0.123	0.089-0.149	0.098-0.163	0.116-0.194	0.141-0.235
K	2.3	10	0.028-0.046	0.031-0.051	0.035-0.058	0.040-0.066	0.050-0.084	0.060-0.100	0.068-0.113	0.081-0.135	0.101-0.169
	3.1	32	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.135-0.225	0.161-0.269
	3.2	27	0.033-0.055	0.038-0.063	0.042-0.070	0.048-0.080	0.060-0.100	0.074-0.123	0.083-0.138	0.098-0.163	0.120-0.200
Cu	3.3	20	0.033-0.055	0.038-0.063	0.042-0.070	0.048-0.080	0.060-0.100	0.074-0.123	0.083-0.138	0.098-0.163	0.120-0.200
	3.4	16	0.028-0.046	0.031-0.051	0.035-0.058	0.040-0.066	0.050-0.084	0.060-0.100	0.068-0.113	0.081-0.135	0.101-0.169
	6.1	27	0.040-0.066	0.045-0.075	0.051-0.085	0.059-0.098	0.074-0.123	0.089-0.149	0.098-0.163	0.116-0.194	0.141-0.235
N	6.2	33	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.135-0.225	0.161-0.269
	6.3	27	0.040-0.066	0.045-0.075	0.051-0.085	0.059-0.098	0.074-0.123	0.089-0.149	0.098-0.163	0.116-0.194	0.141-0.235
	6.4	16	0.040-0.066	0.045-0.075	0.051-0.085	0.059-0.098	0.074-0.123	0.089-0.149	0.098-0.163	0.116-0.194	0.141-0.235
Syn	7.1	33	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.135-0.225	0.161-0.269
	7.2	30	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.135-0.225	0.161-0.269
	7.3	30	0.040-0.066	0.045-0.075	0.051-0.085	0.059-0.098	0.074-0.123	0.089-0.149	0.098-0.163	0.116-0.194	0.141-0.235
Syn	8.1	30	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.158-0.263	0.186-0.310
	8.2	35	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.135-0.225	0.161-0.269

114, 115 Bright Finish, 138, 139, 1NA

Material	Ø	Vc m/min	1	2	3	4	5	6	8	10
			F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	1.1	35	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331
	1.2	30	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331
	1.3	25	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238
	1.4	20	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206
	1.5	13	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175
M	1.6	9	0.012-0.020	0.029-0.048	0.040-0.066	0.045-0.075	0.051-0.085	0.059-0.098	0.074-0.123	0.089-0.149
	2.1	15	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175
	2.2	8	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238
K	2.3	10	0.011-0.019	0.024-0.040	0.033-0.055	0.038-0.063	0.042-0.070	0.048-0.080	0.060-0.100	0.074-0.123
	3.1	30	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331
	3.2	24	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206
Cu	3.3	20	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175
	3.4	14	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175
	6.1	35	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238
N	6.2	33	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331
	6.3	27	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285
	6.4	16	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238
Syn	7.1	33	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373
	7.2	30	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331
	7.3	27	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285
Syn	8.1	30	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373
	8.2	28	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285
	8.3	14	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206

Parameters based on ideal conditions.
Please adjust parameters accordingly to real applications.



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114, 115 TiN Coated

Material	Ø	Vc m/min	1	2	3	4	5	6	8	10
			F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	1.1	47	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331
	1.2	41	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331
	1.3	34	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238
	1.4	27	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206
	1.5	18	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175
	1.6	12	0.012-0.020	0.029-0.048	0.040-0.066	0.045-0.075	0.051-0.085	0.059-0.098	0.074-0.123	0.089-0.149
M	2.1	20	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175
	2.2	11	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238
	2.3	14	0.011-0.019	0.024-0.040	0.033-0.055	0.038-0.063	0.042-0.070	0.048-0.080	0.060-0.100	0.074-0.123
K	3.1	41	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331
	3.2	32	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206
	3.3	27	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175
	3.4	19	0.013-0.021	0.032-0.054	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175
Cu	6.1	47	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238
	6.2	45	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331
	6.3	36	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285
	6.4	22	0.014-0.024	0.042-0.070	0.063-0.105	0.072-0.120	0.082-0.136	0.095-0.158	0.120-0.200	0.143-0.238
N	7.1	45	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373
	7.2	41	0.016-0.026	0.057-0.095	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331
	7.3	36	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285
	7.4	30	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285
Syn	8.1	41	0.018-0.030	0.063-0.105	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373
	8.2	38	0.015-0.025	0.050-0.083	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285
	8.3	19	0.014-0.023	0.038-0.063	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206



Download the Somta Tools app to
access machining data on your
mobile or desktop



Parameters based on ideal conditions.
Please adjust parameters accordingly to real applications.



shaping your dreams



OSG GROUP COMPANY

M O R S E T A P E R S H A N K D R I L L S






X-Ratio Morse Taper Shank Drills

For general purpose drilling.



Codes
2X1 - 2X4

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

Properties		
 STANDARD POINT		
mm	DIN 345	HSS
TYPE N		
		BRIGHT FINISH SHANK & POINT
pg 83		

d	l ₂	l ₁	Code	Price	d	l ₂	l ₁	Code	Price
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No. 1 Morse Taper Shank

6	57	138	2X10600		10.5	87	168	2X11050	
6.5	63	144	2X10650		11	94	175	2X11100	
7	69	150	2X10700		11.5	94	175	2X11150	
7.5	69	150	2X10750		12	101	182	2X11200	
8	75	156	2X10800		12.5	101	182	2X11250	
8.5	75	156	2X10850		13	101	182	2X11300	
9	81	162	2X10900		13.5	108	189	2X11350	
9.5	81	162	2X10950		14	108	189	2X11400	
10	87	168	2X11000						

No. 2 Morse Taper Shank

(14)	114	212	2X21400		19	135	233	2X21900	
14.5	114	212	2X21450		19.5	140	238	2X21950	
15	114	212	2X21500		20	140	238	2X22000	
15.5	120	218	2X21550		20.5	145	243	2X22050	
16	120	218	2X21600		21	145	243	2X22100	
16.5	125	223	2X21650		21.5	150	248	2X22150	
17	125	223	2X21700		22	150	248	2X22200	
17.5	130	228	2X21750		22.5	155	253	2X22250	
18	130	228	2X21800		23	155	253	2X22300	
18.5	135	233	2X21850						

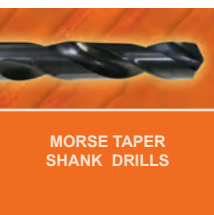
No. 3 Morse Taper Shank

23.5	155	276	2X32350		28	170	291	2X32800	
24	160	281	2X32400		28.5	175	296	2X32850	
24.5	160	281	2X32450		29	175	296	2X32900	
25	160	281	2X32500		29.5	175	296	2X32950	
25.5	165	286	2X32550		30	175	296	2X33000	
26	165	286	2X32600		30.5	180	301	2X33050	
26.5	165	286	2X32650		31	180	301	2X33100	
27	170	291	2X32700		31.5	180	301	2X33150	
27.5	170	291	2X32750		(32)	185	306	2X33200	

No. 4 Morse Taper Shank

32	185	334	2X43200	
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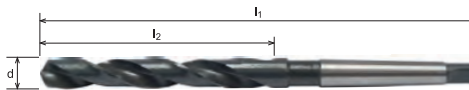
() Not to DIN 345





Morse Taper Shank Drills

For precision drilling.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	○					●	●	○	○							○	○	○	○	○	○	○	○							

d		l ₂	l ₁	Code	Price	d		l ₂	l ₁	Code	Price
mm	inch					mm	inch				

No. 1 Morse Taper Shank

3		33	114	2010300		9.922	25/64	87	168	2110992	
3.5		39	120	2010350		10		87	168	2011000	
4		43	124	2010400		10.319	13/32	87	168	2111032	
4.5		47	128	2010450		10.5		87	168	2011050	
5		52	133	2010500		10.716	27/64	94	175	2111072	
5.5		57	138	2010550		11		94	175	2011100	
6		57	138	2010600		11.112	7/16	94	175	2111111	
6.350	1/4	63	144	2110635		11.5		94	175	2011150	
6.5		63	144	2010650		11.906	15/32	101	182	2111191	
7		69	150	2010700		12		101	182	2011200	
7.5		69	150	2010750		12.5		101	182	2011250	
7.937	5/16	75	156	2110794		12.700	1/2	101	182	2111270	
8		75	156	2010800		13		101	182	2011300	
8.5		75	156	2010850		13.494	17/32	108	189	2111349	
9		81	162	2010900		13.5		108	189	2011350	
9.5		81	162	2010950		14		108	189	2011400	
9.525	3/8	87	168	2110953							

No. 2 Morse Taper Shank

(14)		114	212	2021400		18.256	23/32	135	233	2121826	
14.287	9/16	114	212	2121429		18.5		135	233	2021850	
14.5		114	212	2021450		18.653	47/64	135	233	2121865	
14.684	37/64	114	212	2121468		19		135	233	2021900	
15		114	212	2021500		19.050	3/4	140	238	2121905	
15.081	19/32	120	218	2121508		19.5		140	238	2021950	
15.478	39/64	120	218	2121548		20		140	238	2022000	
15.5		120	218	2021550		20.5		145	243	2022050	
15.875	5/8	120	218	2121588		20.637	13/16	145	243	2122064	
16		120	218	2021600		21		145	243	2022100	
16.272	41/64	125	223	2121627		21.431	27/32	150	248	2122143	
16.5		125	223	2021650		21.5		150	248	2022150	
16.669	21/32	125	223	2121667		22		150	248	2022200	
17		125	223	2021700		22.225	7/8	150	248	2122223	
17.462	11/16	130	228	2121746		22.5		155	253	2022250	
17.5		130	228	2021750		23		155	253	2022300	
18		130	228	2021800							

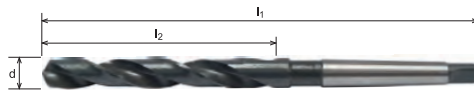
No. 3 Morse Taper Shank

23.5		155	276	2032350		28.5		175	296	2032850	
23.812	15/16	160	281	2132381		28.575	1.1/8	175	296	2132858	
24		160	281	2032400		29		175	296	2032900	
24.5		160	281	2032450		29.5		175	296	2032950	
25		160	281	2032500		30		175	296	2033000	
25.400	1"	165	286	2132540		30.162	1.3/16	180	301	2133016	
25.5		165	286	2032550		30.5		180	301	2033050	
26		165	286	2032600		31		180	301	2033100	
26.5		165	286	2032650		31.5		180	301	2033150	
26.987	1.1/16	170	291	2132699		31.750	1.1/4	185	306	2133175	
27		170	291	2032700		(32)		185	306	2033200	
27.5		170	291	2032750							
28		170	291	2032800							

Continued on next page...

Codes		
201 - 205		
211 - 214		
Properties		
THINNED POINT		
mm inch	DIN 345	HSS
TYPE N	118°	h8
30°	MTS 1 - 5	BRIGHT FINISH SHANK & POINT
pg 83		









Codes
201 - 205
211 - 214

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	○	○					●	●	○	○							○	○	○	○	○	○	○	○							

d		l2	l1	Code	Price	d		l2	l1	Code	Price
mm	inch					mm	inch				

Properties		
	THINNED POINT	
	mm inch	DIN 345 HSS
TYPE N		
30°		BRIGHT FINISH SHANK & POINT
pg 83		

No. 4 Morse Taper Shank										
... from previous page						41	205	354	2044100	
32	185	334	2043200	41.275	1.5/8	205	354	2144128		
32.5	185	334	2043250	41.5		205	354	2044150		
33	185	334	2043300	42		205	354	2044200		
33.337	1.5/16	185	334	2143334	42.5		205	354	2044250	
33.5		185	334	2043350	43		210	359	2044300	
34		190	339	2043400	43.5		210	359	2044350	
34.5		190	339	2043450	44		210	359	2044400	
34.925	1.3/8	190	339	2143493	44.450	1.3/4	210	359	2144445	
35		190	339	2043500	44.5		210	359	2044450	
35.5		190	339	2043550	45		210	359	2044500	
36		195	344	2043600	45.5		215	364	2044550	
36.5		195	344	2043650	46		215	364	2044600	
36.512	1.7/16	195	344	2143651	46.5		215	364	2044650	
37		195	344	2043700	47		215	364	2044700	
37.5		195	344	2043750	47.5		215	364	2044750	
38		200	349	2043800	47.625	1.7/8	220	369	2144763	
38.100	1.1/2	200	349	2143810	48		220	369	2044800	
38.5		200	349	2043850	48.5		220	369	2044850	
39		200	349	2043900	49		220	369	2044900	
39.5		200	349	2043950	49.5		220	369	2044950	
39.687	1.9/16	200	349	2143969	50		220	369	2045000	
40		200	349	2044000	50.5		225	374	2045050	
40.5		205	354	2044050	50.800	2"	225	374	2145080	

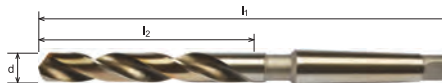
No. 5 Morse Taper Shank										
51	225	412	2055100	60		235	422	2056000		
51.5	225	412	2055150	61		240	427	2056100		
52	225	412	2055200	62		240	427	2056200		
52.5	225	412	2055250	63		240	427	2056300		
53	225	412	2055300	64		245	432	2056400		
53.5	230	417	2055350	65		245	432	2056500		
54	230	417	2055400	66		245	432	2056600		
54.5	230	417	2055450	67		245	432	2056700		
55	230	417	2055500	68		250	437	2056800		
55.5	230	417	2055550	69		250	437	2056900		
56	230	417	2055600	70		250	437	2057000		
56.5	235	422	2055650	71		250	437	2057100		
57	235	422	2055700	72		255	442	2057200		
57.5	235	422	2055750	73		255	442	2057300		
58	235	422	2055800	74		255	442	2057400		
58.5	235	422	2055850	75		255	442	2057500		
59	235	422	2055900	76		260	447	2057600		
59.5	235	422	2055950							

() Not to DIN 345



Heavy Duty MTS Drills

For drilling high tensile steels and other difficult materials.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

d	l ₂	l ₁	Code	Price	d	l ₂	l ₁	Code	Price
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No. 1 Morse Taper Shank

14	108	189	2081400						
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No. 2 Morse Taper Shank

14.5	114	212	2081450	18.5	135	233	2081850
15	114	212	2081500	19	135	233	2081900
15.5	120	218	2081550	19.5	140	238	2081950
16	120	218	2081600	20	140	238	2082000
16.5	125	223	2081650	21	145	243	2082100
17	125	223	2081700	22	150	248	2082200
17.5	130	228	2081750	22.5	155	253	2082250
18	130	228	2081800	23	155	253	2082300

No. 3 Morse Taper Shank

24	160	281	2082400	27	170	291	2082700
24.5	160	281	2082450	28	170	291	2082800
25	160	281	2082500	29	175	296	2082900
25.5	165	286	2082550	30	175	296	2083000
26	165	286	2082600	31	180	301	2083100

No. 4 Morse Taper Shank

32	185	334	2083200	35	190	339	2083500
33	185	334	2083300	38	200	349	2083800
34	190	339	2083400				

Code

208

Properties



**SPLIT
POINT**

mm

**DIN
345**

**HSS
Co5**

**TYPE
N**



h8



**GOLD
OXIDE
FINISH**



pg 84



pg 86

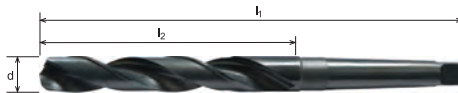


pg 249









MTS Chipbreaker Drills

High performance production drilling.



Code
2A1

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	○	○				●	●	○	○							○	○	○	○	○	○	○	○							

Properties		
 CONICAL POINT CHIPBREAKER FORM		
mm inch	DIN 345	HSS
TYPE N	 118°	 h8
 30°	 MTS 1 - 4	BLUE FINISH
 pg 83		

d		l ₂	l ₁	Code	Price	d		l ₂	l ₁	Code	Price
mm	inch					mm	inch				
No. 1 Morse Taper Shank											
10		87	168	2A11000		11.906	15/32	101	182	2A11191	
10.2		87	168	2A11020		12		101	182	2A11200	
10.25		87	168	2A11025		12.2		101	182	2A11220	
10.5		87	168	2A11050		12.303	31/64	101	182	2A11231	
10.6		87	168	2A11060		12.5		101	182	2A11250	
10.75		94	175	2A11075		12.75		101	182	2A11275	
11		94	175	2A11100		13		101	182	2A11300	
11.112	7/16	94	175	2A11111		13.494	17/32	108	189	2A11349	
11.2		94	175	2A11120		13.5		108	189	2A11350	
11.5		94	175	2A11150		13.75		108	189	2A11375	
11.7		94	175	2A11170		13.891	35/64	108	189	2A11389	
11.8		94	175	2A11180		14		108	189	2A11400	
No. 2 Morse Taper Shank											
(14)		114	212	2A11401		18.25		135	233	2A11825	
14.2		114	212	2A11420		18.256	23/32	135	233	2A11826	
14.25		114	212	2A11425		18.5		135	233	2A11850	
14.287	9/16	114	212	2A11429		18.7		135	233	2A11870	
14.5		114	212	2A11450		18.75		135	233	2A11875	
14.684	37/64	114	212	2A11468		19		135	233	2A11900	
14.75		114	212	2A11475		19.050	3/4	140	238	2A11905	
15		114	212	2A11500		19.25		140	238	2A11925	
15.081	19/32	120	218	2A11508		19.4		140	238	2A11940	
15.25		120	218	2A11525		19.447	49/64	140	238	2A11945	
15.5		120	218	2A11550		19.5		140	238	2A11950	
15.6		120	218	2A11560		19.75		140	238	2A11975	
15.75		120	218	2A11575		19.844	25/32	140	238	2A11984	
15.875	5/8	120	218	2A11588		20		140	238	2A12000	
15.9		120	218	2A11590		20.25		145	243	2A12025	
16		120	218	2A11600		20.5		145	243	2A12050	
16.1		125	223	2A11610		20.637	13/16	145	243	2A12064	
16.25		125	223	2A11625		21		145	243	2A12100	
16.3		125	223	2A11630		21.034	53/64	145	243	2A12103	
16.5		125	223	2A11650		21.25		150	248	2A12125	
16.669	21/32	125	223	2A11667		21.5		150	248	2A12150	
16.75		125	223	2A11675		21.828	55/64	150	248	2A12183	
17		125	223	2A11700		22		150	248	2A12200	
17.25		130	228	2A11725		22.25		150	248	2A12225	
17.462	11/16	130	228	2A11746		22.5		155	253	2A12250	
17.5		130	228	2A11750		23		155	253	2A12300	
18		130	228	2A11800		23.019	29/32	155	253	2A12302	
18.2		135	233	2A11820							
No. 3 Morse Taper Shank											
23.25		155	276	2A12325		25		160	281	2A12500	
23.416	59/64	155	276	2A12342		25.003	63/64	165	286	2A12499	
23.5		155	276	2A12350		25.25		165	286	2A12525	
23.75		160	281	2A12375		25.400	1"	165	286	2A12539	
23.812	15/16	160	281	2A12381		25.5		165	286	2A12550	
24		160	281	2A12400		25.797	1.1/64	165	286	2A12579	
24.5		160	281	2A12450		Continued on next page.					

Continued on next page...



MTS Chipbreaker Drills

High performance production drilling.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	○					●	●	○	○								○	○	○	○	○	○	○	○						

d		l2	l1	Code	Price	d		l2	l1	Code	Price
mm	inch					mm	inch				

No. 3 Morse Taper Shank

... from previous page						28.575	1.1/8	175	296	2A12858	
26		165	286	2A12600		29		175	296	2A12900	
26.194	1.1/32	165	286	2A12619		29.369	1.5/32	175	296	2A12937	
26.5		165	286	2A12650		29.5		175	296	2A12950	
26.987	1.1/16	170	291	2A12699		30		175	296	2A13000	
27		170	291	2A12700		31		180	301	2A13100	
27.5		170	291	2A12750		31.5		180	301	2A13150	
28		170	291	2A12800		31.750	1.1/4	185	306	2A13174	
28.5		175	296	2A12850		(32)		185	306	2A13200	

No. 4 Morse Taper Shank

32		185	334	2A13201		39		200	349	2A13900	
32.147	1.17/64	185	334	2A13215		39.5		200	349	2A13950	
32.5		185	334	2A13250		40		200	349	2A14000	
33		185	334	2A13300		40.5		205	354	2A14050	
33.337	1.5/16	185	334	2A13334		41		205	354	2A14100	
33.5		185	334	2A13350		42		205	354	2A14200	
34		190	339	2A13400		43		210	359	2A14300	
34.131	1.11/32	190	339	2A13413		44		210	359	2A14400	
34.5		190	339	2A13450		44.450	1.3/4	210	359	2A14445	
34.925	1.3/8	190	339	2A13493		44.5		210	359	2A14450	
35		190	339	2A13500		45		210	359	2A14500	
36		195	344	2A13600		45.5		215	364	2A14550	
36.5		195	344	2A13650		46		215	364	2A14600	
37		195	344	2A13700		47		215	364	2A14700	
38		200	349	2A13800		48		220	369	2A14800	
38.100	1.1/2	200	349	2A13809		49		220	369	2A14900	
38.5		200	349	2A13850		50		220	369	2A15000	

Not available once current stock is depleted

() Not to DIN 345



Code

2A1

Properties



CONICAL
POINT
CHIPBREAKER
FORM

mm
inch

DIN
345

HSS

TYPE
N

118°

h8

30°
MIT S 1 - 4

BLUE
FINISH

pg 83

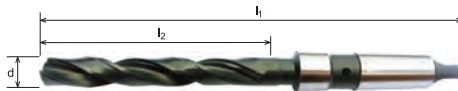




OSG GROUP COMPANY

MTS Oil Tube Chipbreaker Drills Cross Hole Feed

High performance production drilling.



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	○	○					●	●	○	○							○	○	○	○	○	○	○	○							

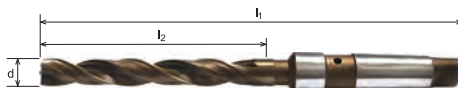
d		l ₂	l ₁	Code	Price
mm	inch				
No. 3 Morse Taper Shank					
12		111	228	2A21200	
14		124	241	2A21400	
15.875	5/8	124	244	2A21588	
16		124	244	2A21600	
18		130	250	2A21800	
20		140	260	2A22000	
22		149	270	2A22200	
24		158	279	2A22400	
26		165	286	2A22600	

Code
2A2

Properties		
mm inch	WORKS STD.	HSS
TYPE N		
	30°	MTS 3
BLUE FINISH		pg 83

MTS Oil Tube Chipbreaker Drills Cross Hole Feed

High performance production drilling.



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

d	mm Equiv.	l ₂	l ₁	Code	Price
No. 3 Morse Taper Shank					
9/16	14.287	124	241	2A71429	
11/16	17.462	130	250	2A71746	
13/16	20.637	146	266	2A72064	
7/8	22.225	149	270	2A72223	
15/16	23.812	158	279	2A72381	
1.1/16	26.987	168	289	2A72699	
No. 4 Morse Taper Shank					
1.1/8	28.575	174	324	2A72858	
1.3/16	30.162	181	330	2A73016	

Not available once current stock is depleted

Code
2A7

Properties		
inch	WORKS STD.	HSS Co5
TYPE N		
	30°	MTS 3 - 4
GOLD OXIDE FINISH		pg 84



MORSE TAPER
SHANK DRILLS



shaping your dreams

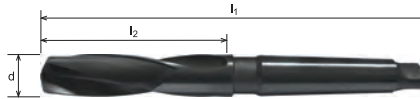
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MTS Armour Piercing Drills

Heavy duty drilling in work hardening and heat treated steels.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	○	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

d		l ₂	l ₁	Code	Price	d		l ₂	l ₁	Code	Price
mm	inch					mm	inch				

No. 1 Morse Taper Shank

10		56	140	2611000							
----	--	----	-----	---------	--	--	--	--	--	--	--

No. 2 Morse Taper Shank

11		76	175	2611100	15		89	187	2611500
12		81	179	2611200	16		89	187	2611600
13		81	179	2611300	17		92	190	2611700
14		86	184	2611400	18		92	190	2611800
14.287	9/16	86	184	2611429					

No. 3 Morse Taper Shank

19		95	213	2611900	22		105	222	2612200
20		95	213	2612000	24		105	222	2612400
21		102	219	2612100	25		108	225	2612500

No. 4 Morse Taper Shank

26		124	270	2612600	36		146	292	2613600
28		124	270	2612800	38		149	295	2613800
30		124	270	2613000	40		152	298	2614000
32		133	280	2613200	45		152	298	2614500
35		136	292	2613500					

No. 5 Morse Taper Shank

50		152	356	2615000					
----	--	-----	-----	---------	--	--	--	--	--

Not available once current stock is depleted



Code
261

Properties		
NOTCHED POINT		
mm inch	WORKS STD.	HSS Co8
TYPE H	130°	h8
15°	MTS 1 - 5	BLUE FINISH
pg 84		



MTS Extra Length Drills

For extra deep hole drilling.



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	○	○					●	●	○	○								○	○	○	○	○	○	○	○						

d	l ₂	l ₁	Code	Price	d	l ₂	l ₁	Code	Price
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No. 1 Morse Taper Shank

10	200	315	2421000		12	300	400	2441200	
10.5	200	315	2421050		13	200	315	2421300	
11	200	315	2421100		13	300	400	2441300	
11	300	400	2441100		14	200	315	2421400	
11.5	200	315	2421150		14	300	400	2441400	
12	200	315	2421200						

No. 2 Morse Taper Shank

15	200	315	2421500		19	375	500	2451900	
15	300	400	2441500		20	200	315	2422000	
16	200	315	2421600		20	300	400	2442000	
16	300	400	2441600		20	375	500	2452000	
16	375	500	2451600		21	200	315	2422100	
17	200	315	2421700		21	300	400	2442100	
17	300	400	2441700		21	375	500	2452100	
17	375	500	2451700		22	200	315	2422200	
18	200	315	2421800		22	300	400	2442200	
18	300	400	2441800		22	375	500	2452200	
18	375	500	2451800		23	200	315	2422300	
19	200	315	2421900		23	300	400	2442300	
19	300	400	2441900		23	375	500	2452300	

No. 3 Morse Taper Shank

24	300	450	2442400		27	375	500	2452700	
24	375	500	2452400		28	300	450	2442800	
25	300	450	2442500		28	375	500	2452800	
25	375	500	2452500		29	300	450	2442900	
26	300	450	2442600		29	375	500	2452900	
26	375	500	2452600		30	300	450	2443000	
27	300	450	2442700		30	375	500	2453000	

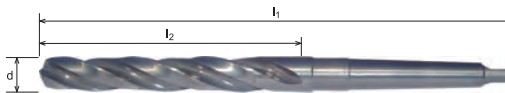
No. 4 Morse Taper Shank

32	300	450	2443200		42	300	450	2444200	
32	375	530	2453200		42	375	530	2454200	
35	300	450	2443500		45	300	450	2444500	
35	375	530	2453500		45	375	530	2454500	
38	300	450	2443800		48	300	450	2444800	
38	375	530	2453800		48	375	530	2454800	
40	300	450	2444000		50	300	450	2445000	
40	375	530	2454000		50	375	530	2455000	



MTS Core Drills

For enlarging diameters of existing holes whether drilled, punched or cast.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	○					●	●	○	○							○	○	○	○	○	○	○	○							

d	l ₂	l ₁	No. of Flutes	Code	Price	d	l ₂	l ₁	No. of Flutes	Code	Price
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No. 1 Morse Taper Shank

14	108	189	3	2211400							
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No. 2 Morse Taper Shank

16	120	218	3	2221600		20	140	238	4	2222000	
17	125	223	3	2221700		21	145	243	4	2222100	
18	130	228	3	2221800		22	150	248	4	2222200	
19	135	233	3	2221900		23	155	253	4	2222300	

No. 3 Morse Taper Shank

24	160	281	4	2232400		28	170	291	4	2232800	
25	160	281	4	2232500		30	175	296	4	2233000	
26	165	286	4	2232600		31	180	301	4	2233100	
27	170	291	4	2232700							

No. 4 Morse Taper Shank

32	185	334	4	2243200		37	195	344	4	2243700	
33	185	334	4	2243300		38	200	349	4	2243800	
34	190	339	4	2243400		40	200	349	4	2244000	
35	190	339	4	2243500		41	205	354	4	2244100	
36	195	344	4	2243600		42	205	354	4	2244200	

Not available once current stock is depleted



Codes

221 - 224

Properties

mm	DIN 343	HSS
TYPE N		
25°		
pg 83	MTS 1 - 4	BLUE FINISH

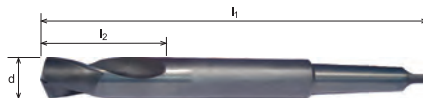




OSG GROUP COMPANY

MTS Rail Drills

For drilling manganese rails
and other tough steels.



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	●	●	○	●	●	○	○	○	○	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

d	l ₂	l ₁	Code	Price
No. 3 Morse Taper Shank				
22	100	281	2792200	
26	100	286	2792600	
28	100	291	2792800	
32	100	306	2793200	
35	100	312	2793500	

Properties		
NOTCHED POINT		
mm	WORKS STD.	HSS Co8
TYPE H	135°	20°
MTS 3	BLUE FINISH	pg 84



MORSE TAPER
SHANK DRILLS



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JUNE 2023 V3 SOMTA CATALOGUE

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Morse Taper Shank Drills Cutting Data



If you have any cutting tool problem,
please feel free to contact our technical sales representatives.

Download the Somta Tools app to access machining data on your mobile or desktop.

2X1 - 2X4

Material	Ø	Vc m/min	6	8	10	12	15	16	20	25	30	40
			F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	1.1	35	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388	0.240-0.400	0.270-0.450	0.300-0.500	0.315-0.525	0.330-0.550
	1.2	30	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388	0.240-0.400	0.270-0.450	0.300-0.500	0.315-0.525	0.330-0.550
	1.3	25	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253	0.158-0.263	0.186-0.310	0.206-0.344	0.221-0.369	0.240-0.400
	1.4	20	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253	0.158-0.263	0.186-0.310	0.206-0.344	0.221-0.369	0.240-0.400
K	3.1	30	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388	0.240-0.400	0.270-0.450	0.300-0.500	0.315-0.525	0.330-0.550
	3.2	24	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216	0.135-0.225	0.161-0.269	0.180-0.300	0.195-0.325	0.214-0.356
	6.1	35	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253	0.158-0.263	0.186-0.310	0.206-0.344	0.221-0.369	0.240-0.400
	6.2	35	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388	0.240-0.400	0.270-0.450	0.300-0.500	0.315-0.525	0.330-0.550
Cu	6.3	35	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350	0.240-0.400	0.266-0.444	0.281-0.469	0.299-0.498
	6.4	35	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350	0.240-0.400	0.266-0.444	0.281-0.469	0.299-0.498
	7.1	26	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253	0.158-0.263	0.186-0.310	0.206-0.344	0.221-0.369	0.240-0.400
	7.2	26	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436	0.270-0.450	0.304-0.506	0.334-0.556	0.349-0.581	0.364-0.606
N	7.3	30	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388	0.240-0.400	0.270-0.450	0.300-0.500	0.315-0.525	0.330-0.550
	7.4	28	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350	0.240-0.400	0.266-0.444	0.281-0.469	0.299-0.498
	7.4	23	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350	0.240-0.400	0.266-0.444	0.281-0.469	0.299-0.498

201 - 205, 211 - 214, 221 - 224 242, 244 - 245, 2A1, 2A2

Material	Ø	Vc m/min	3	4	5	6	8	10	12	15	16	20	25	30
			F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	1.1	35	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388	0.240-0.400	0.270-0.450	0.300-0.500	0.315-0.525
	1.2	30	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388	0.240-0.400	0.270-0.450	0.300-0.500	0.315-0.525
	1.3	25	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253	0.158-0.263	0.186-0.310	0.206-0.344	0.221-0.369
	1.4	20	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253	0.158-0.263	0.186-0.310	0.206-0.344	0.221-0.369
K	1.5	12	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216	0.135-0.225	0.161-0.269	0.180-0.300	0.195-0.325
	1.6	9	0.040-0.066	0.045-0.075	0.051-0.085	0.059-0.098	0.074-0.123	0.089-0.149	0.098-0.163	0.112-0.186	0.116-0.194	0.141-0.235	0.158-0.263	0.171-0.285
	3.1	30	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388	0.240-0.400	0.270-0.450	0.300-0.500	0.315-0.525
	3.2	24	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216	0.135-0.225	0.161-0.269	0.180-0.300	0.195-0.325
Cu	3.3	20	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216	0.135-0.225	0.161-0.269	0.180-0.300	0.195-0.325
	3.4	14	0.047-0.078	0.053-0.089	0.060-0.100	0.069-0.115	0.086-0.144	0.105-0.175	0.113-0.188	0.130-0.216	0.135-0.225	0.161-0.269	0.180-0.300	0.195-0.325
	6.1	35	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253	0.158-0.263	0.186-0.310	0.206-0.344	0.221-0.369
	6.2	35	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388	0.240-0.400	0.270-0.450	0.300-0.500	0.315-0.525
N	6.3	35	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350	0.240-0.400	0.266-0.444	0.281-0.469
	6.4	16	0.055-0.091	0.063-0.105	0.071-0.119	0.082-0.136	0.104-0.173	0.124-0.206	0.134-0.223	0.152-0.253	0.158-0.263	0.186-0.310	0.206-0.344	0.221-0.369
	7.1	26	0.101-0.169	0.114-0.190	0.128-0.213	0.148-0.246	0.188-0.313	0.224-0.373	0.236-0.394	0.262-0.436	0.270-0.450	0.304-0.506	0.334-0.556	0.349-0.581
	7.2	30	0.089-0.149	0.101-0.168	0.113-0.188	0.130-0.216	0.165-0.275	0.199-0.331	0.210-0.350	0.233-0.388	0.240-0.400	0.270-0.450	0.300-0.500	0.315-0.525
N	7.3	28	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350	0.240-0.400	0.266-0.444	0.281-0.469
	7.4	23	0.077-0.128	0.087-0.145	0.098-0.163	0.113-0.188	0.143-0.238	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350	0.240-0.400	0.266-0.444	0.281-0.469

Material	Ø	Vc m/min	40	50 - 80
			F (mm/rev.)	F (mm/rev.)
P	1.1	35	0.330-0.550	0.345-0.575
	1.2	30	0.330-0.550	0.345-0.575
	1.3	25	0.240-0.400	0.257-0.429
	1.4	20	0.240-0.400	0.257-0.429
K	1.5	12	0.214-0.356	0.233-0.388
	1.6	9	0.190-0.316	0.206-0.344
	3.1	30	0.330-0.550	0.345-0.575
	3.2	24	0.214-0.356	0.233-0.388
Cu	3.3	20	0.214-0.356	0.233-0.388
	3.4	14	0.214-0.356	0.233-0.388
	6.1	35	0.240-0.400	0.257-0.429
	6.2	35	0.330-0.550	0.345-0.575
N	6.3	35	0.299-0.498	0.314-0.523
	6.4	16	0.240-0.400	0.257-0.429
	7.1	26	0.364-0.606	0.377-0.629
	7.2	30	0.330-0.550	0.345-0.575
N	7.3	28	0.299-0.498	0.314-0.523
	7.4	23	0.299-0.498	0.314-0.523

Parameters based on ideal conditions.
Please adjust parameters accordingly to real applications.



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208, 2A7

Material	Ø Vc m/min	12	15	16	20	25	30	40
		F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	1.1 ● 35	0.236-0.394	0.262-0.436	0.270-0.450	0.304-0.506	0.334-0.556	0.349-0.581	0.364-0.606
	1.2 ● 30	0.182-0.304	0.203-0.339	0.210-0.350	0.240-0.400	0.266-0.444	0.281-0.469	0.299-0.498
	1.3 ● 27	0.154-0.256	0.173-0.289	0.180-0.300	0.210-0.350	0.233-0.388	0.248-0.413	0.266-0.444
	1.4 ● 23	0.134-0.223	0.152-0.253	0.158-0.263	0.186-0.310	0.206-0.344	0.221-0.369	0.240-0.400
	1.5 ● 17	0.113-0.188	0.130-0.216	0.135-0.225	0.161-0.269	0.180-0.300	0.195-0.325	0.214-0.356
M	1.6 ● 10	0.098-0.163	0.112-0.186	0.116-0.194	0.141-0.235	0.158-0.263	0.171-0.285	0.190-0.316
	2.1 ● 24	0.113-0.188	0.130-0.216	0.135-0.225	0.161-0.269	0.180-0.300	0.195-0.325	0.214-0.356
	2.2 ● 11	0.154-0.256	0.173-0.289	0.180-0.300	0.210-0.350	0.233-0.388	0.248-0.413	0.266-0.444
K	2.3 ● 17	0.083-0.138	0.094-0.156	0.098-0.163	0.120-0.200	0.135-0.225	0.146-0.244	0.165-0.275
	3.1 ● 35	0.236-0.394	0.262-0.436	0.270-0.450	0.304-0.506	0.334-0.556	0.349-0.581	0.364-0.606
	3.2 ● 28	0.154-0.256	0.173-0.289	0.180-0.300	0.210-0.350	0.233-0.388	0.248-0.413	0.266-0.444
	3.3 ● 22	0.113-0.188	0.130-0.216	0.135-0.225	0.161-0.269	0.180-0.300	0.195-0.325	0.214-0.356
Ti	3.4 ● 17	0.113-0.188	0.130-0.216	0.135-0.225	0.161-0.269	0.180-0.300	0.195-0.325	0.214-0.356
	4.1 ○ 28	0.154-0.256	0.173-0.289	0.180-0.300	0.210-0.350	0.233-0.388	0.248-0.413	0.266-0.444
	4.2 ○ 20	0.098-0.163	0.112-0.186	0.116-0.194	0.141-0.235	0.158-0.263	0.171-0.285	0.190-0.316
Ni	4.3 ○ 11	0.083-0.138	0.094-0.156	0.098-0.163	0.120-0.200	0.135-0.225	0.146-0.244	0.165-0.275
	5.1 ○ 15	0.154-0.256	0.173-0.289	0.180-0.300	0.210-0.350	0.233-0.388	0.248-0.413	0.266-0.444
	5.2 ○ 7	0.113-0.188	0.130-0.216	0.135-0.225	0.161-0.269	0.180-0.300	0.195-0.325	0.214-0.356
Cu	5.3 ○ 6	0.068-0.113	0.077-0.129	0.081-0.135	0.101-0.169	0.115-0.191	0.124-0.206	0.141-0.235
	6.1 ○ 38	0.289-0.481	0.314-0.524	0.323-0.538	0.364-0.606	0.394-0.656	0.409-0.681	0.426-0.710
	6.2 ○ 40	0.236-0.394	0.262-0.436	0.270-0.450	0.304-0.506	0.334-0.556	0.349-0.581	0.364-0.606
N	6.3 ○ 27	0.182-0.304	0.203-0.339	0.210-0.350	0.240-0.400	0.266-0.444	0.281-0.469	0.299-0.498
	6.4 ○ 21	0.134-0.223	0.152-0.253	0.158-0.263	0.186-0.310	0.206-0.344	0.221-0.369	0.240-0.400
	7.1 ○ 33	0.236-0.394	0.262-0.436	0.270-0.450	0.304-0.506	0.334-0.556	0.349-0.581	0.364-0.606
Syn	7.2 ○ 30	0.210-0.350	0.233-0.388	0.240-0.400	0.270-0.450	0.300-0.500	0.315-0.525	0.330-0.550
	7.3 ○ 30	0.182-0.304	0.203-0.339	0.210-0.350	0.240-0.400	0.266-0.444	0.281-0.469	0.299-0.498
	7.4 ○ 27	0.134-0.223	0.152-0.253	0.158-0.263	0.186-0.310	0.206-0.344	0.221-0.369	0.240-0.400
Syn	8.1 ○ 35	0.263-0.438	0.291-0.485	0.300-0.500	0.338-0.563	0.368-0.613	0.383-0.638	0.398-0.663
	8.2 ○ 28	0.236-0.394	0.262-0.436	0.270-0.450	0.304-0.506	0.334-0.556	0.349-0.581	0.364-0.606
	8.3 ○ 20	0.182-0.304	0.203-0.339	0.210-0.350	0.240-0.400	0.266-0.444	0.281-0.469	0.299-0.498

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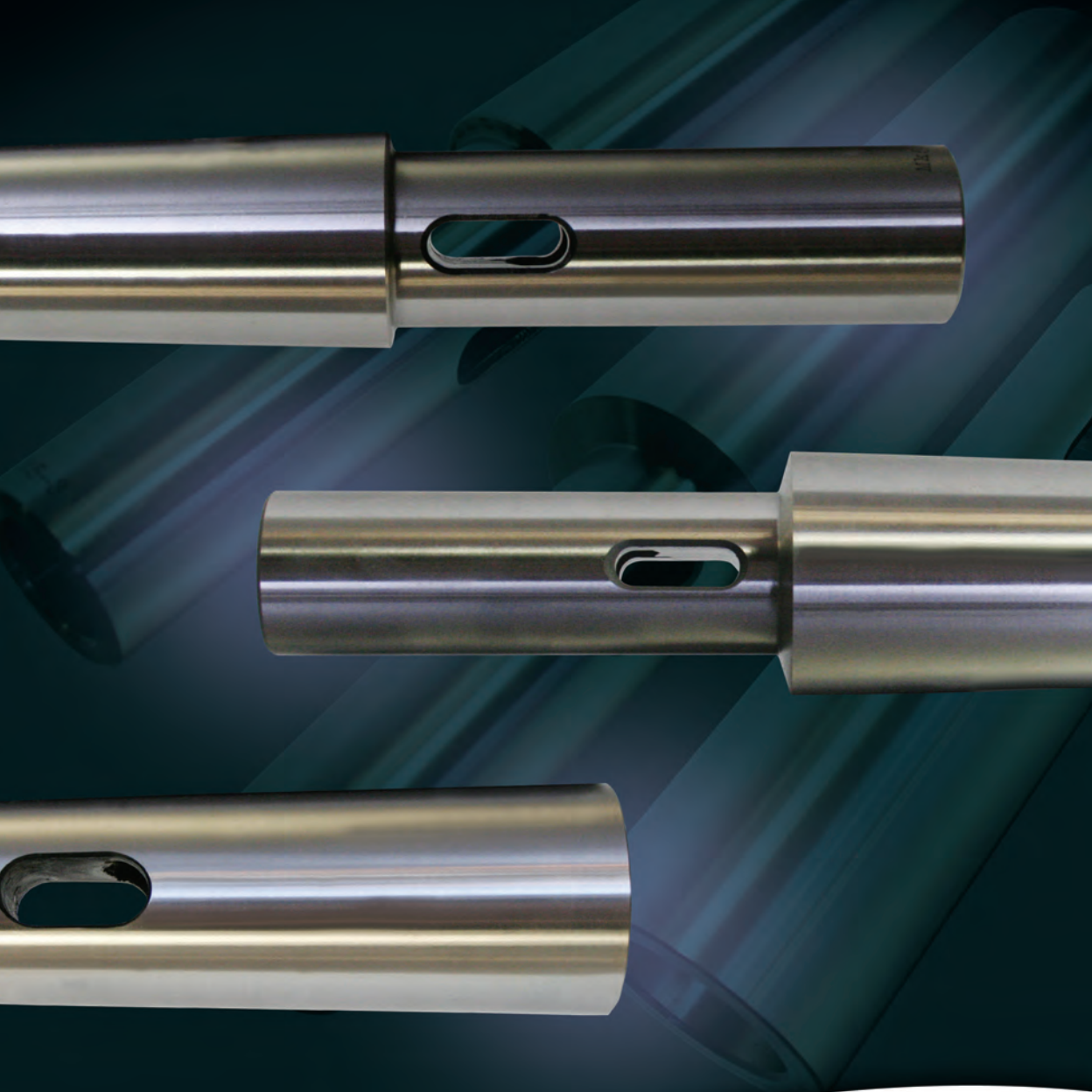
Material	Ø Vc m/min	10	12	15	16	20	25	30	40	50
		F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	1.1 ○ 35	0.224-0.373	0.236-0.394	0.262-0.436	0.270-0.450	0.304-0.506	0.334-0.556	0.349-0.581	0.364-0.606	0.377-0.629
	1.2 ○ 30	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350	0.240-0.400	0.266-0.444	0.281-0.469	0.299-0.498	0.314-0.523
	1.3 ○ 27	0.143-0.238	0.154-0.256	0.173-0.289	0.180-0.300	0.210-0.350	0.233-0.388	0.248-0.413	0.266-0.444	0.281-0.469
	1.4 ○ 23	0.124-0.206	0.134-0.223	0.152-0.253	0.158-0.263	0.186-0.310	0.206-0.344	0.221-0.369	0.240-0.400	0.257-0.429
	1.5 ● 17	0.105-0.175	0.113-0.188	0.130-0.216	0.135-0.225	0.161-0.269	0.180-0.300	0.195-0.325	0.214-0.356	0.233-0.388
M	1.6 ● 10	0.089-0.149	0.098-0.163	0.112-0.186	0.116-0.194	0.141-0.235	0.158-0.263	0.171-0.285	0.190-0.316	0.206-0.344
	2.1 ○ 24	0.105-0.175	0.113-0.188	0.130-0.216	0.135-0.225	0.161-0.269	0.180-0.300	0.195-0.325	0.214-0.356	0.233-0.388
	2.2 ● 11	0.143-0.238	0.154-0.256	0.173-0.289	0.180-0.300	0.210-0.350	0.233-0.388	0.248-0.413	0.266-0.444	0.281-0.469
K	2.3 ● 17	0.074-0.123	0.083-0.138	0.094-0.156	0.098-0.163	0.120-0.200	0.135-0.225	0.146-0.244	0.165-0.275	0.180-0.300
	3.1 ○ 35	0.224-0.373	0.236-0.394	0.262-0.436	0.270-0.450	0.304-0.506	0.334-0.556	0.349-0.581	0.364-0.606	0.377-0.629
	3.2 ○ 28	0.143-0.238	0.154-0.256	0.173-0.289	0.180-0.300	0.210-0.350	0.233-0.388	0.248-0.413	0.266-0.444	0.281-0.469
	3.3 ○ 22	0.105-0.175	0.113-0.188	0.130-0.216	0.135-0.225	0.161-0.269	0.180-0.300	0.195-0.325	0.214-0.356	0.233-0.388
Ti	3.4 ● 17	0.105-0.175	0.113-0.188	0.130-0.216	0.135-0.225	0.161-0.269	0.180-0.300	0.195-0.325	0.214-0.356	0.233-0.388
	4.1 ○ 28	0.143-0.238	0.154-0.256	0.173-0.289	0.180-0.300	0.210-0.350	0.233-0.388	0.248-0.413	0.266-0.444	0.281-0.469
	4.2 ○ 20	0.089-0.149	0.098-0.163	0.112-0.186	0.116-0.194	0.141-0.235	0.158-0.263	0.171-0.285	0.190-0.316	0.206-0.344
Ni	4.3 ○ 11	0.074-0.123	0.083-0.138	0.094-0.156	0.098-0.163	0.120-0.200	0.135-0.225	0.146-0.244	0.165-0.275	0.180-0.300
	5.1 ○ 15	0.143-0.238	0.154-0.256	0.173-0.289	0.180-0.300	0.210-0.350	0.233-0.388	0.248-0.413	0.266-0.444	0.281-0.469
	5.2 ○ 7	0.105-0.175	0.113-0.188	0.130-0.216	0.135-0.225	0.161-0.269	0.180-0.300	0.195-0.325	0.214-0.356	0.233-0.388
Cu	5.3 ○ 6	0.060-0.100	0.068-0.113	0.077-0.129	0.081-0.135	0.101-0.169	0.115-0.191	0.124-0.206	0.141-0.235	0.156-0.260
	6.1 ○ 38	0.270-0.450	0.289-0.481	0.314-0.524	0.323-0.538	0.364-0.606	0.394-0.656	0.409-0.681	0.426-0.710	0.441-0.735
	6.2 ○ 40	0.224-0.373	0.236-0.394	0.262-0.436	0.270-0.450	0.304-0.506	0.334-0.556	0.349-0.581	0.364-0.606	0.377-0.629
Cu	6.3 ○ 27	0.171-0.285	0.182-0.304	0.203-0.339	0.210-0.350	0.240-0.400	0.266-0.444	0.281-0.469	0.299-0.498	0.314-0.523
	6.4 ○ 21	0.124-0.206	0.134-0.223	0.152-0.253	0.158-0.263	0.186-0.310	0.206-0.344	0.221-0.369	0.240-0.400	0.257-0.429



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Parameters based on ideal conditions.
Please adjust parameters accordingly to real applications.



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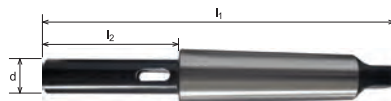
S O C K E T S & S L E E V E S




OSG GROUP COMPANY

Extension Sockets

For extending spindle to take larger, smaller or the same size Morse Taper Shank.




Code
282

Properties
DIN 228  MTS 1 - 5

Morse Taper Inside	d	l ₂	l ₁	Morse Taper Shank	Code	Price
1	20	76	145	1	2820010	
1	20	76	160	2	2820020	
1	20	76	175	3	2820023	
1	20	76	200	4	2820025	
2	30	91	160	1	2820030	
2	30	91	175	2	2820070	
2	30	91	194	3	2820040	
2	30	91	215	4	2820050	
2	30	91	247	5	2820060	
3	36	112	196	2	2820063	
3	36	112	215	3	2820067	
3	36	112	240	4	2820075	
3	36	112	268	5	2820078	
4	48	137	240	3	2820083	
4	48	137	265	4	2820087	
4	48	137	300	5	2820090	
5	63	172	300	4	2820100	
5	63	172	335	5	2820110	

Code
283

Properties
DIN 228  MTS 1 - 6



Reduction Sleeves

To reduce the machine taper to suit smaller Morse Taper Shank on tool in use.



Morse Taper Inside	Morse Taper Shank	Code	Price
0	1	2830010	
1	2	2830020	
1	3	2830025	
2	3	2830030	
2	4	2830035	
2	5	2830038	
3	4	2830040	
3	5	2830045	
4	5	2830050	
5	6	2830060	



SOCKETS
& SLEEVES



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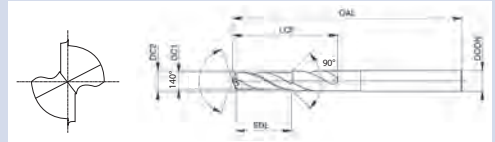
H I G H P E R F O R M A N C E D R I L L I N G

HYP-HP-SC-3D

Drilling | Solid carbide | 3xD



- Carbide step drill with EgiAs coating
- Up to 3xD
- General purpose
- For tap drill holes



P ○	P ●	P ●	P ●	M ○	K ●	K ●	H ●	H ○
C: ≤0,2%	C: 0,25-0,4%	C: ≥0,45%	SCM	INOX	GG	GGG	25-35 HRC	35-45 HRC



EDP	For threading	DC1	DC2	DCON	SDL	LCF	OAL	Price
OSG-42-EP0201138	M3x0,5	2,5	6	6	9	13	66	
OSG-42-EP0201144	M4x0,7	3,3	6	6	12	16	66	
OSG-42-EP0201149	M5x0,8	4,2	6	6	15	18	66	
OSG-42-EP0201155	M6x1	5	8	8	18	23	79	
OSG-42-EP0201161	M8x1,25	6,8	10	10	24	29	89	
OSG-42-EP0201169	M10x1,5	8,5	12	12	30	35	89	
OSG-42-EP0201179	M12x1,75	10,2	14	14	36	41	112	

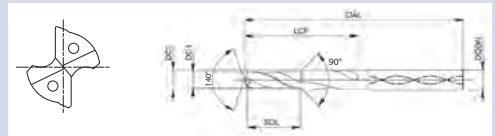
Available on request

HYP-HPO-SC-3D

Drilling | Solid carbide | 3xD



- Carbide step drill with internal coolant, EgiAs coating
- Up to 3xD
- General purpose
- For tap drill holes

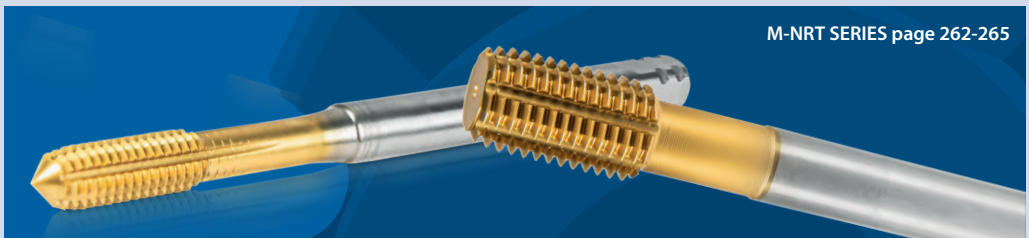


P ○	P ●	P ●	P ●	M ○	K ●	K ●	H ●	H ○
C: ≤0,2%	C: 0,25-0,4%	C: ≥0,45%	SCM	INOX	GG	GGG	25-35 HRC	35-45 HRC



EDP	For threading	DC1	DC2	DCON	SDL	LCF	OAL	Price
OSG-42-EP0202144	M4x0,7	3,3	6	6	12	16	66	
OSG-42-EP0202149	M5x0,8	4,2	6	6	15	18	66	
OSG-42-EP0202155	M6x1	5	8	8	18	23	79	
OSG-42-EP0202161	M8x1,25	6,8	10	10	24	29	89	
OSG-42-EP0202169	M10x1,5	8,5	12	12	30	35	89	
OSG-42-EP0202179	M12x1,75	10,2	14	14	36	41	112	

Available on request



M-NRT SERIES page 262-265



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OSG GROUP COMPANY

HYP-HPO-3D

Drilling | Solid carbide | 3xD



- Carbide drill with internal coolant, WDI coating
- Up to 3xD
- General purpose



EDP	D	L	I	d	Price
OSG-42-30210300	3	62	20	6	
OSG-42-30210310	3,1	62	20	6	
OSG-42-30210317	3,17 (1/8)	62	20	6	
OSG-42-30210320	3,2	62	20	6	
OSG-42-30210330	3,3	62	20	6	
OSG-42-30210340	3,4	62	20	6	
OSG-42-30210350	3,5	62	20	6	
OSG-42-30210357	3,57 (9/64)	62	20	6	
OSG-42-30210360	3,6	62	20	6	
OSG-42-30210370	3,7	62	20	6	
OSG-42-30210380	3,8	66	24	6	
OSG-42-30210390	3,9	66	24	6	
OSG-42-30210397	3,97 (5/32)	66	24	6	
OSG-42-30210400	4	66	24	6	
OSG-42-30210410	4,1	66	24	6	
OSG-42-30210420	4,2	66	24	6	
OSG-42-30210430	4,3	66	24	6	
OSG-42-30210437	4,37 (11/64)	66	24	6	
OSG-42-30210440	4,4	66	24	6	
OSG-42-30210450	4,5	66	24	6	
OSG-42-30210460	4,6	66	24	6	
OSG-42-30210465	4,65	66	24	6	
OSG-42-30210470	4,7	66	24	6	
OSG-42-30210476	4,76 (3/16)	66	24	6	
OSG-42-30210480	4,8	66	28	6	
OSG-42-30210490	4,9	66	28	6	
OSG-42-30210500	5	66	28	6	
OSG-42-30210510	5,1	66	28	6	
OSG-42-30210516	5,16 (13/64)	66	28	6	
OSG-42-30210520	5,2	66	28	6	
OSG-42-30210530	5,3	66	28	6	
OSG-42-30210540	5,4	66	28	6	
OSG-42-30210550	5,5	66	28	6	
OSG-42-30210555	5,55	66	28	6	
OSG-42-30210556	5,56 (7/32)	66	28	6	
OSG-42-30210560	5,6	66	28	6	
OSG-42-30210570	5,7	66	28	6	
OSG-42-30210580	5,8	66	28	6	
OSG-42-30210590	5,9	66	28	6	
OSG-42-30210595	5,95 (15/64)	66	28	6	
OSG-42-30210600	6	66	28	6	
OSG-42-30210610	6,1	79	34	8	
OSG-42-30210620	6,2	79	34	8	
OSG-42-30210630	6,3	79	34	8	
OSG-42-30210635	6,35 (1/4)	79	34	8	
OSG-42-30210640	6,4	79	34	8	
OSG-42-30210650	6,5	79	34	8	
OSG-42-30210660	6,6	79	34	8	
OSG-42-30210670	6,7	79	34	8	
OSG-42-30210675	6,75 (17/64)	79	34	8	
OSG-42-30210680	6,8	79	34	8	
OSG-42-30210690	6,9	79	34	8	
OSG-42-30210700	7	79	34	8	
OSG-42-30210710	7,1	79	41	8	
OSG-42-30210714	7,14 (9/32)	79	41	8	
OSG-42-30210720	7,2	79	41	8	
OSG-42-30210730	7,3	79	41	8	
OSG-42-30210740	7,4	79	41	8	
OSG-42-30210750	7,5	79	41	8	
OSG-42-30210754	7,54 (19/64)	79	41	8	
OSG-42-30210760	7,6	79	41	8	
OSG-42-30210770	7,7	79	41	8	

EDP	D	L	I	d	Price
OSG-42-30210780	7,8	79	41	8	
OSG-42-30210790	7,9	79	41	8	
OSG-42-30210794	7,94 (5/16)	79	41	8	
OSG-42-30210800	8	79	41	8	
OSG-42-30210810	8,1	89	47	10	
OSG-42-30210820	8,2	89	47	10	
OSG-42-30210830	8,3	89	47	10	
OSG-42-30210833	8,33 (21/64)	89	47	10	
OSG-42-30210840	8,4	89	47	10	
OSG-42-30210850	8,5	89	47	10	
OSG-42-30210860	8,6	89	47	10	
OSG-42-30210870	8,7	89	47	10	
OSG-42-30210873	8,73 (11/32)	89	47	10	
OSG-42-30210880	8,8	89	47	10	
OSG-42-30210890	8,9	89	47	10	
OSG-42-30210900	9	89	47	10	
OSG-42-30210910	9,1	89	47	10	
OSG-42-30210913	9,13 (23/64)	89	47	10	
OSG-42-30210920	9,2	89	47	10	
OSG-42-30210930	9,3	89	47	10	
OSG-42-30210940	9,4	89	47	10	
OSG-42-30210950	9,5	89	47	10	
OSG-42-30210952	9,52 (3/8)	89	47	10	
OSG-42-30210960	9,6	89	47	10	
OSG-42-30210970	9,7	89	47	10	
OSG-42-30210980	9,8	89	47	10	
OSG-42-30210990	9,9	89	47	10	
OSG-42-30210992	9,92 (25/64)	89	47	10	
OSG-42-30211000	10	89	47	10	
OSG-42-30211010	10,1	102	55	12	
OSG-42-30211020	10,2	102	55	12	
OSG-42-30211030	10,3	102	55	12	
OSG-42-30211032	10,32 (13/32)	102	55	12	
OSG-42-30211040	10,4	102	55	12	
OSG-42-30211050	10,5	102	55	12	
OSG-42-30211060	10,6	102	55	12	
OSG-42-30211070	10,7	102	55	12	
OSG-42-30211072	10,72 (27/64)	102	55	12	
OSG-42-30211080	10,8	102	55	12	
OSG-42-30211090	10,9	102	55	12	
OSG-42-30211100	11	102	55	12	
OSG-42-30211110	11,1	102	55	12	
OSG-42-30211111	11,11 (7/16)	102	55	12	
OSG-42-30211120	11,2	102	55	12	
OSG-42-30211130	11,3	102	55	12	
OSG-42-30211140	11,4	102	55	12	
OSG-42-30211150	11,5	102	55	12	
OSG-42-30211151	11,51 (29/64)	102	55	12	
OSG-42-30211160	11,6	102	55	12	
OSG-42-30211170	11,7	102	55	12	
OSG-42-30211180	11,8	102	55	12	
OSG-42-30211190	11,9	102	55	12	
OSG-42-30211191	11,91 (15/32)	102	55	12	
OSG-42-30211200	12	102	55	12	
OSG-42-30211230	12,3 (31/64)	107	60	14	
OSG-42-30211250	12,5	107	60	14	
OSG-42-30211270	12,7 (1/2)	107	60	14	
OSG-42-30211300	13	107	60	14	
OSG-42-30211350	13,5	107	60	14	
OSG-42-30211400	14	107	60	14	
OSG-42-30211429	14,29 (9/16)	115	65	16	
OSG-42-30211450	14,5	115	65	16	

High Performance Drilling | Solid carbide

HYP-HPO-3D

EDP	D	L	I	d	Price
OSG-42-30211500	15	115	65	16	
OSG-42-30211550	15,5	115	65	16	
OSG-42-30211587	15,87 (5/8)	115	65	16	
OSG-42-30211600	16	115	65	16	
OSG-42-30211650	16,5	123	73	18	
OSG-42-30211700	17	123	73	18	

EDP	D	L	I	d	Price
OSG-42-30211750	17,5	123	73	18	
OSG-42-30211800	18	123	73	18	
OSG-42-30211850	18,5	131	79	20	
OSG-42-30211900	19	131	79	20	
OSG-42-30211950	19,5	131	79	20	
OSG-42-30212000	20	131	79	20	

HYP-HPO-5D

Drilling | Solid carbide | 5xD



- Carbide drill with internal coolant, WDI coating
- Up to 5xD
- General purpose



EDP	D	L	I	d	Price
OSG-42-30220100	1	55	8	3	
OSG-42-30220110	1,1	55	12	3	
OSG-42-30220120	1,2	55	12	3	
OSG-42-30220130	1,3	55	12	3	
OSG-42-30220140	1,4	55	12	3	
OSG-42-30220150	1,5	55	16	3	
OSG-42-30220160	1,6	55	16	3	
OSG-42-30220170	1,7	55	16	3	
OSG-42-30220180	1,8	55	16	3	
OSG-42-30220190	1,9	55	16	3	
OSG-42-30220200	2	57	21	4	
OSG-42-30220210	2,1	57	21	4	
OSG-42-30220220	2,2	57	21	4	
OSG-42-30220230	2,3	57	21	4	
OSG-42-30220240	2,4	57	21	4	
OSG-42-30220250	2,5	57	21	4	
OSG-42-30220260	2,6	57	21	4	
OSG-42-30220270	2,7	57	21	4	
OSG-42-30220280	2,8	57	21	4	
OSG-42-30220290	2,9	57	21	4	
OSG-42-30220300	3	66	28	6	
OSG-42-30220310	3,1	66	28	6	
OSG-42-30220317	3,17 (1/8)	66	28	6	
OSG-42-30220320	3,2	66	28	6	
OSG-42-30220330	3,3	66	28	6	
OSG-42-30220340	3,4	66	28	6	
OSG-42-30220350	3,5	66	28	6	
OSG-42-30220357	3,57 (9/64)	66	28	6	
OSG-42-30220360	3,6	66	28	6	
OSG-42-30220370	3,7	66	28	6	
OSG-42-30220380	3,8	74	36	6	
OSG-42-30220390	3,9	74	36	6	
OSG-42-30220397	3,97 (5/32)	74	36	6	
OSG-42-30220400	4	74	36	6	
OSG-42-30220410	4,1	74	36	6	
OSG-42-30220420	4,2	74	36	6	
OSG-42-30220430	4,3	74	36	6	
OSG-42-30220437	4,37 (11/64)	74	36	6	
OSG-42-30220440	4,4	74	36	6	
OSG-42-30220450	4,5	74	36	6	
OSG-42-30220460	4,6	74	36	6	
OSG-42-30220465	4,65	74	36	6	
OSG-42-30220470	4,7	74	36	6	
OSG-42-30220476	4,76 (3/16)	82	44	6	
OSG-42-30220480	4,8	82	44	6	
OSG-42-30220490	4,9	82	44	6	
OSG-42-30220500	5	82	44	6	
OSG-42-30220510	5,1	82	44	6	
OSG-42-30220516	5,16 (13/64)	82	44	6	
OSG-42-30220520	5,2	82	44	6	
OSG-42-30220530	5,3	82	44	6	
OSG-42-30220540	5,4	82	44	6	

EDP	D	L	I	d	Price
OSG-42-30220550	5,5	82	44	6	
OSG-42-30220555	5,55	82	44	6	
OSG-42-30220556	5,56 (7/32)	82	44	6	
OSG-42-30220560	5,6	82	44	6	
OSG-42-30220570	5,7	82	44	6	
OSG-42-30220580	5,8	82	44	6	
OSG-42-30220590	5,9	82	44	6	
OSG-42-30220595	5,95 (15/64)	82	44	6	
OSG-42-30220600	6	82	44	6	
OSG-42-30220610	6,1	91	53	8	
OSG-42-30220620	6,2	91	53	8	
OSG-42-30220630	6,3	91	53	8	
OSG-42-30220635	6,35 (1/4)	91	53	8	
OSG-42-30220640	6,4	91	53	8	
OSG-42-30220650	6,5	91	53	8	
OSG-42-30220660	6,6	91	53	8	
OSG-42-30220670	6,7	91	53	8	
OSG-42-30220675	6,75 (17/64)	91	53	8	
OSG-42-30220680	6,8	91	53	8	
OSG-42-30220690	6,9	91	53	8	
OSG-42-30220700	7	91	53	8	
OSG-42-30220710	7,1	91	53	8	
OSG-42-30220714	7,14 (9/32)	91	53	8	
OSG-42-30220720	7,2	91	53	8	
OSG-42-30220730	7,3	91	53	8	
OSG-42-30220740	7,4	91	53	8	
OSG-42-30220750	7,5	91	53	8	
OSG-42-30220754	7,54 (19/64)	91	53	8	
OSG-42-30220760	7,6	91	53	8	
OSG-42-30220770	7,7	91	53	8	
OSG-42-30220780	7,8	91	53	8	
OSG-42-30220790	7,9	91	53	8	
OSG-42-30220794	7,94 (5/16)	91	53	8	
OSG-42-30220800	8	91	53	8	
OSG-42-30220810	8,1	103	61	10	
OSG-42-30220820	8,2	103	61	10	
OSG-42-30220830	8,3	103	61	10	
OSG-42-30220833	8,33 (21/64)	103	61	10	
OSG-42-30220840	8,4	103	61	10	
OSG-42-30220850	8,5	103	61	10	
OSG-42-30220860	8,6	103	61	10	
OSG-42-30220870	8,7	103	61	10	
OSG-42-30220873	8,73 (11/32)	103	61	10	
OSG-42-30220880	8,8	103	61	10	
OSG-42-30220890	8,9	103	61	10	
OSG-42-30220900	9	103	61	10	
OSG-42-30220910	9,1	103	61	10	
OSG-42-30220913	9,13 (23/64)	103	61	10	
OSG-42-30220920	9,2	103	61	10	
OSG-42-30220930	9,3	103	61	10	
OSG-42-30220940	9,4	103	61	10	
OSG-42-30220950	9,5	103	61	10	



EDP	D	L	I	d	Price
OSG-42-30220952	9,52 (3/8)	103	61	10	
OSG-42-30220960	9,6	103	61	10	
OSG-42-30220970	9,7	103	61	10	
OSG-42-30220980	9,8	103	61	10	
OSG-42-30220990	9,9	103	61	10	
OSG-42-30220992	9,92 (25/64)	103	61	10	
OSG-42-30221000	10	103	61	10	
OSG-42-30221010	10,1	118	71	12	
OSG-42-30221020	10,2	118	71	12	
OSG-42-30221030	10,3	118	71	12	
OSG-42-30221032	10,32 (13/32)	118	71	12	
OSG-42-30221040	10,4	118	71	12	
OSG-42-30221050	10,5	118	71	12	
OSG-42-30221060	10,6	118	71	12	
OSG-42-30221070	10,7	118	71	12	
OSG-42-30221072	10,72 (27/64)	118	71	12	
OSG-42-30221080	10,8	118	71	12	
OSG-42-30221090	10,9	118	71	12	
OSG-42-30221100	11	118	71	12	
OSG-42-30221110	11,1	118	71	12	
OSG-42-30221111	11,11 (7/16)	118	71	12	
OSG-42-30221120	11,2	118	71	12	
OSG-42-30221130	11,3	118	71	12	
OSG-42-30221140	11,4	118	71	12	
OSG-42-30221150	11,5	118	71	12	
OSG-42-30221151	11,51 (29/64)	118	71	12	

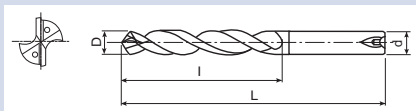
EDP	D	L	I	d	Price
OSG-42-30221160	11,6	118	71	12	
OSG-42-30221170	11,7	118	71	12	
OSG-42-30221180	11,8	118	71	12	
OSG-42-30221190	11,9	118	71	12	
OSG-42-30221191	11,91 (15/32)	118	71	12	
OSG-42-30221200	12	118	71	12	
OSG-42-30221230	12,3 (31/64)	124	77	14	
OSG-42-30221250	12,5	124	77	14	
OSG-42-30221270	12,7 (1/2)	124	77	14	
OSG-42-30221300	13	124	77	14	
OSG-42-30221350	13,5	124	77	14	
OSG-42-30221400	14	124	77	14	
OSG-42-30221429	14,29 (9/16)	133	83	16	
OSG-42-30221450	14,5	133	83	16	
OSG-42-30221500	15	133	83	16	
OSG-42-30221550	15,5	133	83	16	
OSG-42-30221587	15,87 (5/8)	133	83	16	
OSG-42-30221600	16	133	83	16	
OSG-42-30221650	16,5	143	93	18	
OSG-42-30221700	17	143	93	18	
OSG-42-30221750	17,5	143	93	18	
OSG-42-30221800	18	143	93	18	
OSG-42-30221850	18,5	153	101	20	
OSG-42-30221900	19	153	101	20	
OSG-42-30221950	19,5	153	101	20	
OSG-42-30222000	20	153	101	20	

HYP-HPO-8D

Drilling | Solid carbide | 8xD



- Carbide drill with internal coolant, WDI coating
- Up to 8xD
- General purpose



EDP	D	L	I	d	Price
OSG-42-32210300	3	72	34	4	
OSG-42-32210310	3,1	81	43	4	
OSG-42-32210317	3,17 (1/8)	81	43	4	
OSG-42-32210320	3,2	81	43	4	
OSG-42-32210330	3,3	81	43	4	
OSG-42-32210340	3,4	81	43	4	
OSG-42-32210350	3,5	81	43	4	
OSG-42-32210357	3,57 (9/64)	81	43	4	
OSG-42-32210360	3,6	81	43	4	
OSG-42-32210370	3,7	81	43	4	
OSG-42-32210380	3,8	81	43	4	
OSG-42-32210390	3,9	81	43	4	
OSG-42-32210397	3,97 (5/32)	81	43	4	
OSG-42-32210400	4	81	43	4	
OSG-42-32210410	4,1	90	50	6	
OSG-42-32210420	4,2	90	50	6	
OSG-42-32210430	4,3	90	50	6	
OSG-42-32210437	4,37 (11/64)	90	50	6	
OSG-42-32210440	4,4	90	50	6	
OSG-42-32210450	4,5	90	50	6	
OSG-42-32210460	4,6	90	50	6	
OSG-42-32210470	4,7	90	50	6	
OSG-42-32210476	4,76 (3/16)	90	50	6	
OSG-42-32210480	4,8	90	50	6	
OSG-42-32210490	4,9	90	50	6	
OSG-42-32210500	5	90	50	6	
OSG-42-32210510	5,1	97	57	6	
OSG-42-32210516	5,16 (13/64)	97	57	6	
OSG-42-32210520	5,2	97	57	6	
OSG-42-32210530	5,3	97	57	6	
OSG-42-32210540	5,4	97	57	6	
OSG-42-32210550	5,5	97	57	6	

EDP	D	L	I	d	Price
OSG-42-32210556	5,56 (7/32)	97	57	6	
OSG-42-32210560	5,6	97	57	6	
OSG-42-32210570	5,7	97	57	6	
OSG-42-32210580	5,8	97	57	6	
OSG-42-32210590	5,9	97	57	6	
OSG-42-32210595	5,95 (15/64)	97	57	6	
OSG-42-32210600	6	97	57	6	
OSG-42-32210610	6,1	106	66	8	
OSG-42-32210620	6,2	106	66	8	
OSG-42-32210630	6,3	106	66	8	
OSG-42-32210635	6,35 (1/4)	106	66	8	
OSG-42-32210640	6,4	106	66	8	
OSG-42-32210650	6,5	106	66	8	
OSG-42-32210660	6,6	106	66	8	
OSG-42-32210670	6,7	106	66	8	
OSG-42-32210675	6,75 (17/64)	106	66	8	
OSG-42-32210680	6,8	106	66	8	
OSG-42-32210690	6,9	116	76	8	
OSG-42-32210700	7	116	76	8	
OSG-42-32210710	7,1	116	76	8	
OSG-42-32210714	7,14 (9/32)	116	76	8	
OSG-42-32210720	7,2	116	76	8	
OSG-42-32210730	7,3	116	76	8	
OSG-42-32210740	7,4	116	76	8	
OSG-42-32210750	7,5	116	76	8	
OSG-42-32210754	7,54 (19/64)	116	76	8	
OSG-42-32210760	7,6	116	76	8	
OSG-42-32210770	7,7	116	76	8	
OSG-42-32210780	7,8	116	76	8	
OSG-42-32210790	7,9	116	76	8	
OSG-42-32210794	7,94 (5/16)	116	76	8	
OSG-42-32210800	8	116	76	8	

EDP	D	L	I	d	Price
OSG-42-32210810	8,1	131	87	10	
OSG-42-32210820	8,2	131	87	10	
OSG-42-32210830	8,3	131	87	10	
OSG-42-32210833	8,33 (21/64)	131	87	10	
OSG-42-32210840	8,4	131	87	10	
OSG-42-32210850	8,5	131	87	10	
OSG-42-32210860	8,6	131	87	10	
OSG-42-32210870	8,7	131	87	10	
OSG-42-32210873	8,73 (11/32)	131	87	10	
OSG-42-32210880	8,8	131	87	10	
OSG-42-32210890	8,9	131	87	10	
OSG-42-32210900	9	131	87	10	
OSG-42-32210910	9,1	139	95	10	
OSG-42-32210913	9,13 (23/64)	139	95	10	
OSG-42-32210920	9,2	139	95	10	
OSG-42-32210930	9,3	139	95	10	
OSG-42-32210940	9,4	139	95	10	
OSG-42-32210950	9,5	139	95	10	
OSG-42-32210952	9,52 (3/8)	139	95	10	
OSG-42-32210960	9,6	139	95	10	
OSG-42-32210970	9,7	139	95	10	
OSG-42-32210980	9,8	139	95	10	
OSG-42-32210990	9,9	139	95	10	
OSG-42-32210992	9,92 (25/64)	139	95	10	
OSG-42-32211000	10	139	95	10	
OSG-42-32211010	10,1	155	106	12	
OSG-42-32211020	10,2	155	106	12	
OSG-42-32211030	10,3	155	106	12	
OSG-42-32211032	10,32 (13/32)	155	106	12	
OSG-42-32211040	10,4	155	106	12	
OSG-42-32211050	10,5	155	106	12	
OSG-42-32211060	10,6	155	106	12	
OSG-42-32211070	10,7	155	106	12	
OSG-42-32211072	10,72 (27/64)	155	106	12	
OSG-42-32211080	10,8	155	106	12	

EDP	D	L	I	d	Price
OSG-42-32211090	10,9	155	106	12	
OSG-42-32211100	11	155	106	12	
OSG-42-32211110	11,1	163	114	12	
OSG-42-32211111	11,11 (7/16)	163	114	12	
OSG-42-32211120	11,2	163	114	12	
OSG-42-32211130	11,3	163	114	12	
OSG-42-32211140	11,4	163	114	12	
OSG-42-32211150	11,5	163	114	12	
OSG-42-32211151	11,51 (29/64)	163	114	12	
OSG-42-32211160	11,6	163	114	12	
OSG-42-32211170	11,7	163	114	12	
OSG-42-32211180	11,8	163	114	12	
OSG-42-32211190	11,9	163	114	12	
OSG-42-32211191	11,91 (15/32)	163	114	12	
OSG-42-32211200	12	163	114	12	
OSG-42-32211230	12,3 (31/64)	182	133	14	
OSG-42-32211250	12,5	182	133	14	
OSG-42-32211270	12,7 (1/2)	182	133	14	
OSG-42-32211300	13	182	133	14	
OSG-42-32211350	13,5	182	133	14	
OSG-42-32211400	14	182	133	14	
OSG-42-32211429	14,29 (9/16)	204	152	16	
OSG-42-32211450	14,5	204	152	16	
OSG-42-32211500	15	204	152	16	
OSG-42-32211550	15,5	204	152	16	
OSG-42-32211587	15,87 (5/8)	204	152	16	
OSG-42-32211600	16	204	152	16	
OSG-42-32211650	16,5	223	171	18	
OSG-42-32211700	17	223	171	18	
OSG-42-32211750	17,5	223	171	18	
OSG-42-32211800	18	223	171	18	
OSG-42-32211850	18,5	244	190	20	
OSG-42-32211900	19	244	190	20	
OSG-42-32211950	19,5	244	190	20	
OSG-42-32212000	20	244	190	20	

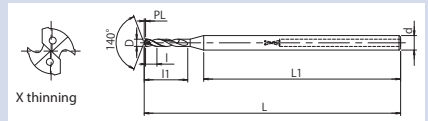
Available on request

ADO-MICRO 2D

Drilling | Solid carbide | 2xD



- First choice in quality and performance
- 2 flute carbide drill with internal coolant, IchAda coating
- Up to 2xD



P C: ≤0,2%	P C: 0,25-0,4%	P C: ≥0,45%	P SCM	M INOX	K GG	K GGG	N ACADC	S Ti	H 25-35 HRC	H 35-45 HRC	H 45-52 HRC
A	CARBIDE	IchAda	±30°	+0,001~+0,010	SHRINK	FIT	140°				

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EDP	D	L	L1	I	I1	PL	d	Price
OSG-42-8732001	0,7	47	38,5	1,4	4,2	0,1	3	
OSG-42-8732002	0,75	47	38,3	1,5	4,5	0,1	3	
OSG-42-8732003	0,8	50	41,1	1,6	4,8	0,1	3	
OSG-42-8732004	0,85	50	40,9	1,7	5,1	0,2	3	
OSG-42-8732005	0,9	50	40,7	1,8	5,4	0,2	3	
OSG-42-8732006	0,95	50	40,5	1,9	5,7	0,2	3	
OSG-42-8732007	1	53	42,8	2	6	0,2	3	
OSG-42-8732008	1,1	53	42,4	2,2	6,6	0,2	3	
OSG-42-8732009	1,2	53	41,9	2,4	7,2	0,2	3	
OSG-42-8732010	1,3	53	41,5	2,6	7,8	0,2	3	
OSG-42-8732011	1,4	53	41,1	2,8	8,4	0,3	3	
OSG-42-8732012	1,5	53	40,7	3	9	0,3	3	
OSG-42-8732013	1,6	53	40,3	3,2	9,6	0,3	3	
OSG-42-8732014	1,7	53	39,9	3,4	10,2	0,3	3	
OSG-42-8732015	1,8	53	39,5	3,6	10,8	0,3	3	



THE TOOLING MASTERCLASS

The A Brand is OSG's premium tooling brand. With a commitment to only the best, the A Brand emanates innovations essential for shaping the future of global manufacturing.



EDP	D	L	L1	I	I1	PL	d	Price
OSG-42-8732016	1,9	53	39	3,8	11,4	0,3	3	
OSG-42-8732017	2	58	43,6	4	12	0,4	3	

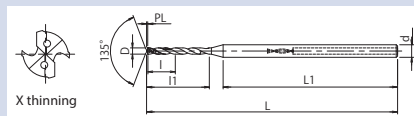
Available on request

ADO-MICRO 5D

Drilling | Solid carbide | 5xD



- First choice in quality and performance
- 2 flute carbide drill with internal coolant, IchAda coating
- Up to 5xD



P	P	P	P	M	K	K	N	S	H	H	H
C: ≤0,2%	C: 0,25-0,4%	C: ≥0,45%	SCM	INOX	GG	GGG	AC,ADC	Ti	25-35 HRC	35-45 HRC	45-52 HRC

A	CARBIDE	IchAda	±30°	0~0.009	SHRINK	FIT	135°
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EDP	D	L	L1	I	I1	PL	d	Price
OSG-42-8732018	0,7	47	35,7	3,5	7	0,1	3	
OSG-42-8732019	0,75	47	35,3	3,8	7,5	0,2	3	
OSG-42-8732020	0,8	50	37,9	4	8	0,2	3	
OSG-42-8732021	0,85	50	37,5	4,3	8,5	0,2	3	
OSG-42-8732022	0,9	50	37,1	4,5	9	0,2	3	
OSG-42-8732023	0,95	50	36,7	4,8	9,5	0,2	3	
OSG-42-8732024	1	55	40,8	5	10	0,2	3	
OSG-42-8732025	1,1	55	40	5,5	11	0,2	3	
OSG-42-8732026	1,2	60	44,1	6	12	0,2	3	
OSG-42-8732027	1,3	60	43,3	6,5	13	0,3	3	
OSG-42-8732028	1,4	60	42,5	7	14	0,3	3	
OSG-42-8732029	1,5	60	41,7	7,5	15	0,3	3	
OSG-42-88337155	1,55	60	41,3	7,8	15,5	0,3	3	
OSG-42-8732030	1,6	60	40,9	8	16	0,3	3	
OSG-42-8732031	1,7	60	40,1	8,5	17	0,4	3	
OSG-42-8732032	1,8	65	44,3	9	18	0,4	3	
OSG-42-88337184	1,84	65	43,9	9,2	18,4	0,4	3	
OSG-42-8732033	1,9	65	43,4	9,5	19	0,4	3	
OSG-42-8732034	2	65	42,6	10	20	0,4	3	

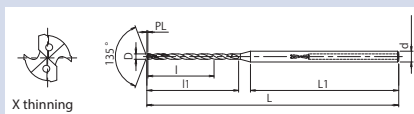
Available on request

ADO-MICRO 12D

Drilling | Solid carbide | 12xD



- First choice in quality and performance
- 2 flute carbide drill with internal coolant, IchAda coating
- Up to 12xD, long type



P	P	P	P	M	K	K	N	S	H	H	H
C: ≤0,2%	C: 0,25-0,4%	C: ≥0,45%	SCM	INOX	GG	GGG	AC,ADC	Ti	25-35 HRC	35-45 HRC	45-52 HRC

A	CARBIDE	IchAda	±30°	0~0.009	SHRINK	FIT	135°
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EDP	D	L	L1	I	I1	PL	d	Price
OSG-42-8732035	1	60	38,8	12	17	0,2	3	
OSG-42-8732036	1,1	65	42,3	13,2	18,7	0,2	3	
OSG-42-8732037	1,2	65	40,7	14,4	20,4	0,2	3	
OSG-42-8732038	1,3	65	39,2	15,6	22,1	0,3	3	
OSG-42-8732039	1,4	70	42,7	16,8	23,8	0,3	3	
OSG-42-8732040	1,5	70	41,2	18	25,5	0,3	3	
OSG-42-8732041	1,6	70	39,7	19,2	27,2	0,3	3	
OSG-42-8732042	1,7	73	41,2	20,4	28,9	0,4	3	
OSG-42-8732043	1,8	73	39,7	21,6	30,6	0,4	3	
OSG-42-8732044	1,9	73	38,1	22,8	32,3	0,4	3	

High Performance Drilling | Solid carbide

ADO-MICRO 2D/5D/12D

EDP	D	L	L1	I	I1	PL	d	Price
OSG-42-8732045	2	77	40,6	24	34	0,4	3	

ADO-MICRO 15D

Drilling | Solid carbide | 15xD

EDP	D	L	L1	I	I1	PL	d	Price
OSG-42-48337120	2	77	34,6	30	40	0,4	3	

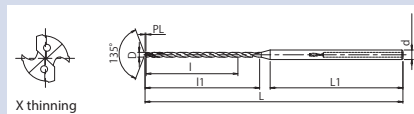
Available on request

ADO-MICRO 20D

Drilling | Solid carbide | 20xD



- First choice in quality and performance
- 2 flute carbide drill with internal coolant, IchAda coating
- Up to 20xD, long type



P	P	P	P	M	K	K	N	S	H	H	H
C: ≤0,2%	C: 0,25-0,4%	C: ≥0,45%	SCM	INOX	Gg	GGG	AC,ADC	Ti	25-35 HRC	35-45 HRC	45-52 HRC

A	CARBIDE	IchAda	±30°	0~-0.009	SHRINK	FIT	135°
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EDP	D	L	L1	I	I1	PL	d	Price
OSG-42-8732046	1	68	39,8	20	24	0,2	3	
OSG-42-8732047	1,1	75	44,6	22	26,4	0,2	3	
OSG-42-8732048	1,2	75	42,3	24	28,8	0,2	3	
OSG-42-8732049	1,3	75	40,1	26	31,2	0,3	3	
OSG-42-8732050	1,4	81	43,9	28	33,6	0,3	3	
OSG-42-8732051	1,5	81	41,7	30	36	0,3	3	
OSG-42-8732052	1,6	81	39,5	32	38,4	0,3	3	
OSG-42-8732053	1,7	88	44,3	34	40,8	0,4	3	
OSG-42-8732054	1,8	88	42,1	36	43,2	0,4	3	
OSG-42-8732055	1,9	88	39,8	38	45,6	0,4	3	
OSG-42-8732056	2	95	44,6	40	48	0,4	3	

ADO-MICRO 25D

Drilling | Solid carbide | 25xD

EDP	D	L	L1	I	I1	PL	d	Price
OSG-42-48337320	2	105	44,6	50	58	0,4	3	

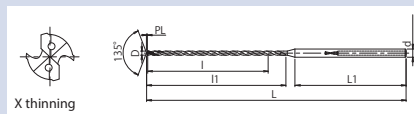
Available on request

ADO-MICRO 30D

Drilling | Solid carbide | 30xD



- First choice in quality and performance
- 2 flute carbide drill with internal coolant, IchAda coating
- Up to 30xD, long type



P	P	P	P	M	K	K	N	S	H	H	H
C: ≤0,2%	C: 0,25-0,4%	C: ≥0,45%	SCM	INOX	Gg	GGG	AC,ADC	Ti	25-35 HRC	35-45 HRC	45-52 HRC

A	CARBIDE	IchAda	±30°	0~-0.009	SHRINK	FIT	135°
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EDP	D	L	L1	I	I1	PL	d	Price
OSG-42-8732057	1	77	38,8	30	34	0,2	3	



EDP	D	L	L1	I	I1	PL	d	Price
OSG-42-8732058	1,1	86	44,6	33	37,4	0,2	3	
OSG-42-8732059	1,2	86	41,3	36	40,8	0,2	3	
OSG-42-8732060	1,3	86	38,1	39	44,2	0,3	3	
OSG-42-8732061	1,4	95	43,9	42	47,6	0,3	3	
OSG-42-8732062	1,5	95	40,7	45	51	0,3	3	
OSG-42-8732063	1,6	101	43,5	48	54,4	0,3	3	
OSG-42-8732064	1,7	101	40,3	51	57,8	0,4	3	
OSG-42-8732065	1,8	107	43,1	54	61,2	0,4	3	
OSG-42-8732066	1,9	107	39,8	57	64,6	0,4	3	
OSG-42-8732067	2	112	41,6	60	68	0,4	3	

Available on request

ADF-2D

Drilling | Solid carbide | Flat drills



- First choice in quality and performance
- Carbide drill with EgiAs coating
- Up to 2xD
- Flat drilling application

P C: ≤0,2%	P C: 0,25-0,4%	P C: ≥0,45%	P SCM	K GG	K GGG	N Al	N AC,ADC	H 25-35 HRC	H 35-45 HRC	H 45-52 HRC
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A	CARBIDE	EgiAs	IchAda	h8	0-0.009	20°	SHRINK	FIT
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EDP	D	L	I	I1	d	Type	Price
OSG-42-3330020	0,2	40	0,7	0,6	3	1	
OSG-42-3330025	0,25	40	0,9	0,8	3	1	
OSG-42-3330030	0,3	40	1	0,9	3	1	
OSG-42-3330035	0,35	40	1,2	1,1	3	1	
OSG-42-48315037	0,37	40	1,2	1,4	3	1	
OSG-42-3330040	0,4	40	1,3	1,2	3	1	
OSG-42-3330045	0,45	40	1,5	1,4	3	1	
OSG-42-48315046	0,46	40	1,7	1,5	3	1	
OSG-42-3330050	0,5	40	1,9	1,7	3	1	
OSG-42-3330055	0,55	40	2,1	1,9	3	1	
OSG-42-3330060	0,6	40	2,2	2,0	3	1	
OSG-42-48315062	0,62	40	2,1	2,3	3	1	
OSG-42-3330065	0,65	40	2,4	2,2	3	1	
OSG-42-3330070	0,7	40	2,6	2,4	3	1	
OSG-42-3330071	0,71	40	2,6	2,4	3	1	
OSG-42-3330072	0,72	40	2,6	2,4	3	1	
OSG-42-3330074	0,74	40	2,7	2,5	3	1	
OSG-42-3330075	0,75	40	2,8	2,6	3	1	
OSG-42-3330080	0,8	40	2,9	2,7	3	1	
OSG-42-3330081	0,81	40	3	2,8	3	1	
OSG-42-3330085	0,85	40	3,1	2,9	3	1	
OSG-42-3330089	0,89	40	3,2	3,0	3	1	
OSG-42-3330090	0,9	40	3,3	3,1	3	1	
OSG-42-3330091	0,91	40	3,3	3,1	3	1	
OSG-42-3330092	0,92	40	3,3	3,1	3	1	
OSG-42-3330095	0,95	40	3,4	3,2	3	1	
OSG-42-3330100	1	45	4,3	4,0	3	1	
OSG-42-48315104	1,04	45	4,5	4,2	3	1	
OSG-42-48315105	1,05	45	4,5	4,2	3	1	
OSG-42-3330109	1,09	45	4,7	4,4	3	1	
OSG-42-3330110	1,1	45	4,7	4,4	3	1	
OSG-42-3330111	1,11	45	4,7	4,4	3	1	
OSG-42-3330112	1,12	45	4,8	4,5	3	1	
OSG-42-48315115	1,15	45	4,9	4,6	3	1	
OSG-42-3330120	1,2	45	5,1	5,0	3	1	
OSG-42-3330125	1,25	45	5,3	5,0	3	1	
OSG-42-3330126	1,26	45	5,3	5,1	3	1	
OSG-42-3330127	1,27	45	5,4	5,1	3	1	
OSG-42-3330128	1,28	45	5,4	5,2	3	1	
OSG-42-3330129	1,29	45	5,5	5,2	3	1	
OSG-42-3330130	1,3	45	5,5	5,2	3	1	
OSG-42-48315132	1,32	45	5,6	5,3	3	1	

EDP	D	L	I	I1	d	Type	Price
OSG-42-48315133	1,33	45	5,6	5,3	3	1	
OSG-42-3330135	1,35	45	5,7	5,4	3	1	
OSG-42-3330140	1,40	45	5,9	5,6	3	1	
OSG-42-48315143	1,43	45	6,0	5,7	3	1	
OSG-42-3330144	1,44	45	6,1	5,8	3	1	
OSG-42-3330145	1,45	45	6,1	5,8	3	1	
OSG-42-3330146	1,46	45	6,1	5,8	3	1	
OSG-42-3330147	1,47	45	6,2	5,9	3	1	
OSG-42-3330148	1,48	45	6,2	5,9	3	1	
OSG-42-3330150	1,5	45	6,3	6,0	3	1	
OSG-42-48315152	1,52	45	6,4	6,1	3	1	
OSG-42-3330153	1,53	45	6,4	6,1	3	1	
OSG-42-3330154	1,54	45	6,5	6,2	3	1	
OSG-42-3330155	1,55	45	6,5	6,2	3	1	
OSG-42-3330156	1,56	45	6,5	6,2	3	1	
OSG-42-3330157	1,57	45	6,6	6,3	3	1	
OSG-42-3330158	1,58	45	6,6	6,3	3	1	
OSG-42-3330160	1,6	45	6,7	6,4	3	1	
OSG-42-48315165	1,65	45	6,9	6,6	3	1	
OSG-42-48315167	1,67	45	7	6,7	3	1	
OSG-42-48315168	1,68	45	7	6,7	3	1	
OSG-42-3330170	1,7	45	7,1	6,8	3	1	
OSG-42-3330175	1,75	45	7,3	7,0	3	1	
OSG-42-3330180	1,8	45	7,5	7,2	3	1	
OSG-42-3330182	1,82	45	7,6	7,3	3	1	
OSG-42-3330183	1,83	45	7,6	7,3	3	1	
OSG-42-3330184	1,84	45	7,7	7,4	3	1	
OSG-42-3330185	1,85	45	7,7	7,4	3	1	
OSG-42-3330186	1,86	45	7,7	7,4	3	1	
OSG-42-3330190	1,9	45	7,9	7,6	3	1	
OSG-42-3330195	1,95	45	8,1	7,8	3	1	
OSG-42-48315199	1,99	45	8,3	8	3	1	
OSG-42-3330200	2	50	10,3	10	4	1	
OSG-42-3330210	2,1	50	10,5	10	4	1	
OSG-42-3330220	2,2	50	11	10,6	4	1	
OSG-42-3330230	2,3	50	11	10,8	4	1	
OSG-42-3330232	2,32	50	11	10,9	4	1	
OSG-42-3330240	2,4	50	12	11	4	1	
OSG-42-3330242	2,42	50	12	11,1	4	1	
OSG-42-3330250	2,5	50	12	11,2	4	1	
OSG-42-3330254	2,54	50	12	11,3	4	1	
OSG-42-3330258	2,58	50	12	11,4	4	1	

High Performance Drilling | Solid carbide

ADO-MICRO 30D/ADF-2D

EDP	D	L	I	I1	d	Type	Price
OSG-42-3330260	2,6	50	13	11,4	4	1	
OSG-42-3330270	2,7	50	13	11,6	4	1	
OSG-42-3330276	2,76	50	14	11,7	4	1	
OSG-42-3330278	2,78	50	14	11,7	4	1	
OSG-42-3330280	2,8	50	14	11,8	4	1	
OSG-42-3330290	2,9	50	14	11,9	4	1	
OSG-42-3330300	3	55	15	11,4	6	1	
OSG-42-3330303	3,03	55	15	11,5	6	1	
OSG-42-3330310	3,1	55	15	11,6	6	1	
OSG-42-3330315	3,15	55	15	11,7	6	1	
OSG-42-3330320	3,2	55	15	11,8	6	1	
OSG-42-3330330	3,3	55	15	12	6	1	
OSG-42-3330340	3,4	55	16	12,1	6	1	
OSG-42-3330350	3,5	55	16	12,3	6	1	
OSG-42-3330353	3,53	55	16	12,4	6	1	
OSG-42-3330360	3,6	55	16	12,5	6	1	
OSG-42-3330366	3,66	55	16	12,6	6	1	
OSG-42-3330368	3,68	55	16	12,7	6	1	
OSG-42-3330370	3,7	55	16	12,7	6	1	
OSG-42-3330380	3,8	60	19	17,9	6	1	
OSG-42-3330390	3,9	60	19	18,1	6	1	
OSG-42-3330400	4	60	19	18,3	6	1	
OSG-42-3330403	4,03	60	19	18,3	6	1	
OSG-42-3330410	4,1	60	19	18,5	6	1	
OSG-42-3330420	4,2	60	21	18,6	6	1	
OSG-42-3330430	4,3	60	21	18,8	6	1	
OSG-42-3330440	4,4	60	21	19	6	1	
OSG-42-3330450	4,5	60	21	19,2	6	1	
OSG-42-3330453	4,53	60	21	19,3	6	1	
OSG-42-3330460	4,6	60	21	19,4	6	1	
OSG-42-3330462	4,62	60	21	19,4	6	1	
OSG-42-3330464	4,64	60	21	19,5	6	1	
OSG-42-3330470	4,7	60	21	19,6	6	1	
OSG-42-3330480	4,8	65	24,8	24	6	1	
OSG-42-3330490	4,9	65	24,9	24	6	1	
OSG-42-3330500	5	65	25,1	24	6	1	
OSG-42-3330503	5,03	65	25,2	24	6	1	
OSG-42-3330510	5,1	65	25,3	24	6	1	
OSG-42-3330520	5,2	65	25,5	24	6	1	
OSG-42-3330530	5,3	65	25,7	24	6	1	
OSG-42-3330540	5,4	65	27	25,9	6	1	
OSG-42-3330550	5,5	65	27	26,1	6	1	
OSG-42-3330552	5,52	65	27	26,1	6	1	
OSG-42-3330554	5,54	65	27	26,1	6	1	
OSG-42-3330560	5,6	65	27	26,3	6	1	
OSG-42-3330570	5,7	65	27	26,4	6	1	
OSG-42-3330580	5,8	65	27	26,6	6	1	
OSG-42-3330590	5,9	65	27	26,8	6	1	
OSG-42-3330600	6	65	27	27	6	2	
OSG-42-3330603	6,03	70	30	32	6	2	
OSG-42-3330610	6,1	70	30	32	6	2	
OSG-42-3330620	6,2	70	30	32	6	2	
OSG-42-3330630	6,3	70	30	32	6	2	
OSG-42-3330640	6,4	70	30	32	6	2	
OSG-42-3330650	6,5	70	30	32	6	2	
OSG-42-3330653	6,53	70	30	32	6	2	
OSG-42-3330660	6,6	70	30	32	6	2	
OSG-42-3330670	6,7	70	30	32	6	2	
OSG-42-3330680	6,8	70	30	32	6	2	
OSG-42-3330690	6,9	70	30	32	6	2	
OSG-42-3330700	7	70	30	32	6	2	
OSG-42-3330703	7,03	75	34	36	6	2	
OSG-42-3330710	7,1	75	34	36	6	2	
OSG-42-3330720	7,2	75	34	36	6	2	
OSG-42-3330730	7,3	75	34	36	6	2	
OSG-42-3330740	7,4	75	34	36	6	2	
OSG-42-3330750	7,5	75	34	36	6	2	
OSG-42-3330760	7,6	75	34	36	6	2	
OSG-42-3330770	7,7	75	34	36	6	2	
OSG-42-3330780	7,8	75	34	36	6	2	
OSG-42-3330790	7,9	75	34	36	6	2	
OSG-42-3330800	8	75	34	36	8	2	
OSG-42-3330803	8,03	80	38	40	8	2	
OSG-42-3330810	8,1	80	38	40	8	2	

EDP	D	L	I	I1	d	Type	Price
OSG-42-3330820	8,2	80	38	40	8	2	
OSG-42-3330830	8,3	80	38	40	8	2	
OSG-42-3330840	8,4	80	38	40	8	2	
OSG-42-3330850	8,5	80	38	40	8	2	
OSG-42-3330853	8,53	80	38	40	8	2	
OSG-42-3330860	8,6	80	38	40	8	2	
OSG-42-3330870	8,7	80	38	40	8	2	
OSG-42-3330880	8,8	80	38	40	8	2	
OSG-42-3330890	8,9	80	38	40	8	2	
OSG-42-3330900	9	80	38	40	8	2	
OSG-42-3330903	9,03	85	42	44	8	2	
OSG-42-3330910	9,1	85	42	44	8	2	
OSG-42-3330920	9,2	85	42	44	8	2	
OSG-42-3330930	9,3	85	42	44	8	2	
OSG-42-3330940	9,4	85	42	44	8	2	
OSG-42-3330950	9,5	85	42	44	8	2	
OSG-42-3330960	9,6	85	42	44	8	2	
OSG-42-3330970	9,7	85	42	44	8	2	
OSG-42-3330980	9,8	85	42	44	8	2	
OSG-42-3330990	9,9	85	42	44	8	2	
OSG-42-3331000	10	85	42	44	10	2	
OSG-42-3331003	10,03	90	46	48	10	2	
OSG-42-3331010	10,1	90	46	48	10	2	
OSG-42-3331020	10,2	90	46	48	10	2	
OSG-42-3331030	10,3	90	46	48	10	2	
OSG-42-3331040	10,4	90	46	48	10	2	
OSG-42-3331050	10,5	90	46	48	10	2	
OSG-42-3331060	10,6	90	46	48	10	2	
OSG-42-3331070	10,7	90	46	48	10	2	
OSG-42-3331080	10,8	90	46	48	10	2	
OSG-42-3331090	10,9	90	46	48	10	2	
OSG-42-3331100	11	90	46	48	10	2	
OSG-42-3331103	11,03	95	50	52	10	2	
OSG-42-3331110	11,1	95	50	52	10	2	
OSG-42-3331120	11,2	95	50	52	10	2	
OSG-42-3331130	11,3	95	50	52	10	2	
OSG-42-3331140	11,4	95	50	52	10	2	
OSG-42-3331150	11,5	95	50	52	10	2	
OSG-42-3331160	11,6	95	50	52	10	2	
OSG-42-3331170	11,7	95	50	52	10	2	
OSG-42-3331180	11,8	95	50	52	10	2	
OSG-42-3331190	11,9	95	50	52	10	2	
OSG-42-3331200	12	95	50	52	12	2	
OSG-42-3331203	12,03	100	56	58	12	2	
OSG-42-3331210	12,1	100	56	58	12	2	
OSG-42-3331220	12,2	100	56	58	12	2	
OSG-42-3331230	12,3	100	56	58	12	2	
OSG-42-3331240	12,4	100	56	58	12	2	
OSG-42-3331250	12,5	100	56	58	12	2	
OSG-42-3331260	12,6	100	56	58	12	2	
OSG-42-3331270	12,7	100	56	58	12	2	
OSG-42-3331280	12,8	100	56	58	12	2	
OSG-42-3331290	12,9	100	56	58	12	2	
OSG-42-3331300	13	100	56	58	12	2	
OSG-42-3331310	13,1	105	60	62	12	2	
OSG-42-3331320	13,2	105	60	62	12	2	
OSG-42-3331330	13,3	105	60	62	12	2	
OSG-42-3331340	13,4	105	60	62	12	2	
OSG-42-3331350	13,5	105	60	62	12	2	
OSG-42-3331360	13,6	105	60	62	12	2	
OSG-42-3331370	13,7	105	60	62	12	2	
OSG-42-3331380	13,8	105	60	62	12	2	
OSG-42-3331390	13,9	105	60	62	12	2	
OSG-42-3331400	14	105	60	62	12	2	
OSG-42-3331410	14,1	110	64	66	12	2	
OSG-42-3331420	14,2	110	64	66	12	2	
OSG-42-3331430	14,3	110	64	66	12	2	
OSG-42-3331440	14,4	110	64	66	12	2	
OSG-42-3331450	14,5	110	64	66	12	2	
OSG-42-3331460	14,6	110	64	66	12	2	
OSG-42-3331470	14,7	110	64	66	12	2	
OSG-42-3331480	14,8	110	64	66	12	2	
OSG-42-3331490	14,9	110	64	66	12	2	
OSG-42-3331500	15	110	64	66	12	2	

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EDP	D	L	I	I1	d	Type	Price
OSG-42-3331510	15,1	115	68	70	12	2	
OSG-42-3331520	15,2	115	68	70	12	2	
OSG-42-3331530	15,3	115	68	70	12	2	
OSG-42-3331540	15,4	115	68	70	12	2	
OSG-42-3331550	15,5	115	68	70	12	2	
OSG-42-3331560	15,6	115	68	70	12	2	
OSG-42-3331570	15,7	115	68	70	12	2	
OSG-42-3331580	15,8	115	68	70	12	2	
OSG-42-3331590	15,9	115	68	70	12	2	

EDP	D	L	I	I1	d	Type	Price
OSG-42-3331600	16	115	68	70	16	2	
OSG-42-3331650	16,5	125	74	76	16	2	
OSG-42-3331700	17	125	74	76	16	2	
OSG-42-3331750	17,5	130	78	80	16	2	
OSG-42-3331800	18	130	78	80	16	2	
OSG-42-3331850	18,5	135	84	86	16	2	
OSG-42-3331900	19	135	84	86	16	2	
OSG-42-3331950	19,5	140	88	90	16	2	
OSG-42-3332000	20	140	88	90	20	2	

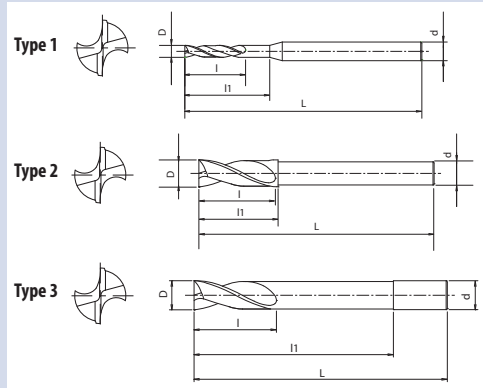
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ADFLS-2D

Drilling | Solid carbide | Flat drills



- First choice in quality and performance
- Carbide drill with EgiAs coating
- Up to 2x D
- For deep reach flat drilling application



EDP	D	L	I	I1	d	Type	Price
OSG-42-3332300	3	100	15	30	6	1	
OSG-42-3332310	3,1	100	15	31	6	1	
OSG-42-3332320	3,2	100	15	32	6	1	
OSG-42-3332330	3,3	100	15	33	6	1	
OSG-42-3332340	3,4	100	16	34	6	1	
OSG-42-3332350	3,5	100	16	35	6	1	
OSG-42-3332360	3,6	100	16	36	6	1	
OSG-42-3332370	3,7	100	16	37	6	1	
OSG-42-3332380	3,8	100	19	38	6	1	
OSG-42-3332390	3,9	100	19	39	6	1	
OSG-42-3332400	4	100	19	40	6	1	
OSG-42-3332410	4,1	100	19	41	6	1	
OSG-42-3332420	4,2	100	21	42	6	1	
OSG-42-3332430	4,3	100	21	43	6	1	
OSG-42-3332440	4,4	100	21	44	6	1	
OSG-42-3332450	4,5	100	21	45	6	1	
OSG-42-3332460	4,6	100	21	46	6	1	
OSG-42-3332470	4,7	100	21	47	6	1	
OSG-42-3332480	4,8	100	24	48	6	1	
OSG-42-3332490	4,9	100	24	49	6	1	
OSG-42-3332500	5	110	24	50	6	1	
OSG-42-3332510	5,1	110	24	51	6	1	
OSG-42-3332520	5,2	110	24	52	6	1	
OSG-42-3332530	5,3	110	24	53	6	1	
OSG-42-3332540	5,4	110	27	54	6	1	
OSG-42-3332550	5,5	110	27	55	6	1	
OSG-42-3332560	5,6	110	27	56	6	1	
OSG-42-3332570	5,7	110	27	57	6	1	
OSG-42-3332580	5,8	110	27	58	6	1	
OSG-42-3332590	5,9	110	27	59	6	1	
OSG-42-3332600	6	110	27	29	6	2	
OSG-42-3334060	6	110	27	60	6	3	
OSG-42-3332650	6,5	120	30	32	6	2	
OSG-42-3332680	6,8	120	30	32	6	2	
OSG-42-3332690	6,9	120	30	32	6	2	
OSG-42-3332700	7	120	30	32	6	2	

EDP	D	L	I	I1	d	Type	Price
OSG-42-3332740	7,4	130	34	36	6	2	
OSG-42-3332750	7,5	130	34	36	6	2	
OSG-42-3332780	7,8	130	34	36	6	2	
OSG-42-3332800	8	130	34	36	8	2	
OSG-42-3334080	8	130	34	80	8	3	
OSG-42-3332850	8,5	140	38	40	8	2	
OSG-42-3332860	8,6	140	38	40	8	2	
OSG-42-3332880	8,8	140	38	40	8	2	
OSG-42-3332900	9	140	38	40	8	2	
OSG-42-3332920	9,2	150	42	44	8	2	
OSG-42-3332950	9,5	150	42	44	8	2	
OSG-42-3332980	9,8	150	42	44	8	2	
OSG-42-3333000	10	150	42	44	10	2	
OSG-42-3334100	10	150	42	100	10	3	
OSG-42-3333030	10,3	160	46	48	10	2	
OSG-42-3333040	10,4	160	46	48	10	2	
OSG-42-3333050	10,5	160	46	48	10	2	
OSG-42-3333080	10,8	160	46	48	10	2	
OSG-42-3333100	11	160	46	48	10	2	
OSG-42-3333110	11,1	170	50	52	10	2	
OSG-42-3333150	11,5	170	50	52	10	2	
OSG-42-3333180	11,8	170	50	52	10	2	
OSG-42-3333200	12	170	50	52	12	2	
OSG-42-3334120	12	170	50	120	12	3	
OSG-42-3333250	12,5	180	56	58	12	2	
OSG-42-3333300	13	180	56	58	12	2	
OSG-42-3333500	13,5	190	60	62	12	2	
OSG-42-3333400	14	190	60	62	12	2	
OSG-42-3333450	14,5	200	64	66	12	2	
OSG-42-3333500	15	200	64	66	12	2	
OSG-42-3333550	15,5	210	68	70	12	2	
OSG-42-3333600	16	210	68	70	16	2	
OSG-42-3334160	16	210	68	160	16	3	
OSG-42-3333650	16,5	220	74	76	16	2	
OSG-42-3333700	17	220	74	76	16	2	
OSG-42-3333750	17,5	230	78	80	16	2	

High Performance Drilling | Solid carbide

ADF-2D/ADFLS-2D

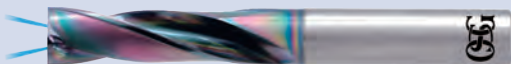
EDP	D	L	I	I1	d	Type	Price
OSG-42-3333800	18	230	78	80	16	2	
OSG-42-3333850	18,5	240	84	86	16	2	
OSG-42-3333900	19	240	84	86	16	2	

EDP	D	L	I	I1	d	Type	Price
OSG-42-3333950	19,5	250	88	90	16	2	
OSG-42-3334000	20	250	88	90	20	2	
OSG-42-3334200	20	250	88	200	20	3	

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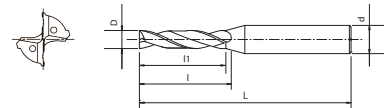
ADFO-3D

Drilling | Solid carbide | Flat drills

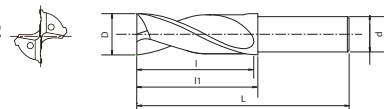


- First choice in quality and performance
- Carbide drill with internal coolant, EgiAs coating
- Up to 3xD
- Flat drilling application

Type 1



Type 2



EDP	D	L	I	I1	d	Type	Price
OSG-42-3334300	3	55	16	15	4	1	
OSG-42-3334301	3.03	55	16	15	4	1	
OSG-42-3334302	3.1	55	16	15	4	1	
OSG-42-3334303	3.15	55	16	15	4	1	
OSG-42-3334304	3.2	55	16	15	4	1	
OSG-42-3334305	3.3	55	16	15	4	1	
OSG-42-3334306	3.4	55	17	16	4	1	
OSG-42-3334307	3.5	55	17	16	4	1	
OSG-42-3334308	3.53	55	17	16	4	1	
OSG-42-3334309	3.6	55	17	16	4	1	
OSG-42-3334310	3.66	55	17	16	4	1	
OSG-42-3334311	3.68	55	17	16	4	1	
OSG-42-3334312	3.7	55	17	16	4	1	
OSG-42-3334313	3.8	60	20	19	4	1	
OSG-42-3334314	3.9	60	20	19	4	1	
OSG-42-3334315	4	60	19	20	4	2	
OSG-42-3334316	4.03	60	22	21	6	1	
OSG-42-3334317	4.1	60	22	21	6	1	
OSG-42-3334318	4.2	60	22	21	6	1	
OSG-42-3334319	4.3	60	22	21	6	1	
OSG-42-3334320	4.4	60	22	21	6	1	
OSG-42-3334321	4.5	60	22	21	6	1	
OSG-42-3334322	4.53	60	21	21	6	1	
OSG-42-3334323	4.6	60	21	21	6	1	
OSG-42-3334324	4.62	60	21	21	6	1	
OSG-42-3334325	4.64	60	21	21	6	1	
OSG-42-3334326	4.7	60	21	21	6	1	
OSG-42-3334327	4.8	65	24	24	6	1	
OSG-42-3334328	4.9	65	24	24	6	1	
OSG-42-3334329	5	65	24	24	6	1	
OSG-42-3334330	5.03	65	24	24	6	1	
OSG-42-3334331	5.1	65	24	24	6	1	
OSG-42-3334332	5.2	65	24	24	6	1	
OSG-42-3334333	5.3	65	24	24	6	1	
OSG-42-3334334	5.4	65	27	27	6	1	
OSG-42-3334335	5.5	65	27	27	6	1	
OSG-42-3334336	5.52	65	27	27	6	1	
OSG-42-3334337	5.54	65	27	27	6	1	
OSG-42-3334338	5.6	65	27	27	6	1	
OSG-42-3334339	5.7	65	27	27	6	1	
OSG-42-3334340	5.8	65	27	27	6	1	
OSG-42-3334341	5.9	65	27	27	6	1	
OSG-42-3334342	6	65	27	27	6	2	
OSG-42-3334343	6.03	70	30	30	8	1	
OSG-42-3334344	6.1	70	30	30	8	1	
OSG-42-3334345	6.2	70	31	30	8	1	
OSG-42-3334346	6.3	70	31	30	8	1	
OSG-42-3334347	6.4	70	31	30	8	1	
OSG-42-3334348	6.5	70	31	30	8	1	

EDP	D	L	I	I1	d	Type	Price
OSG-42-3334349	6.53	70	31	30	8	1	
OSG-42-3334350	6.6	70	31	30	8	1	
OSG-42-3334351	6.7	70	31	30	8	1	
OSG-42-3334352	6.8	70	31	30	8	1	
OSG-42-3334353	6.9	70	31	30	8	1	
OSG-42-3334354	7	70	31	30	8	1	
OSG-42-3334355	7.03	70	31	30	8	1	
OSG-42-3334356	7.1	75	35	34	8	1	
OSG-42-3334357	7.2	75	35	34	8	1	
OSG-42-3334358	7.3	75	35	34	8	1	
OSG-42-3334359	7.4	75	35	34	8	1	
OSG-42-3334360	7.5	75	35	34	8	1	
OSG-42-3334361	7.6	75	35	34	8	1	
OSG-42-3334362	7.7	75	35	34	8	1	
OSG-42-3334363	7.8	75	35	34	8	1	
OSG-42-3334364	7.9	75	35	34	8	1	
OSG-42-3334365	8	75	35	35	8	2	
OSG-42-3334366	8.03	80	39	38	10	1	
OSG-42-3334367	8.1	80	39	38	10	1	
OSG-42-3334368	8.2	80	39	38	10	1	
OSG-42-3334369	8.3	80	39	38	10	1	
OSG-42-3334370	8.4	80	39	38	10	1	
OSG-42-3334371	8.5	80	39	38	10	1	
OSG-42-3334372	8.53	80	39	38	10	1	
OSG-42-3334373	8.6	80	39	38	10	1	
OSG-42-3334374	8.7	80	39	38	10	1	
OSG-42-3334375	8.8	80	39	38	10	1	
OSG-42-3334376	8.9	80	39	38	10	1	
OSG-42-3334377	9	80	39	38	10	1	
OSG-42-3334378	9.03	80	39	38	10	1	
OSG-42-3334379	9.1	85	43	42	10	1	
OSG-42-3334380	9.2	85	43	42	10	1	
OSG-42-3334381	9.3	85	43	42	10	1	
OSG-42-3334382	9.4	85	43	42	10	1	
OSG-42-3334383	9.5	85	43	42	10	1	
OSG-42-3334384	9.6	85	43	42	10	1	
OSG-42-3334385	9.7	85	43	42	10	1	
OSG-42-3334386	9.8	85	43	42	10	1	
OSG-42-3334387	9.9	85	43	42	10	1	
OSG-42-3334388	10	85	42	43	10	2	
OSG-42-3334389	10.03	90	47	46	12	1	
OSG-42-3334390	10.1	90	47	46	12	1	
OSG-42-3334391	10.2	90	47	46	12	1	
OSG-42-3334392	10.3	90	47	46	12	1	
OSG-42-3334393	10.4	90	47	46	12	1	
OSG-42-3334394	10.5	90	47	46	12	1	
OSG-42-3334395	10.6	90	47	46	12	1	
OSG-42-3334396	10.7	90	47	46	12	1	
OSG-42-3334397	10.8	90	47	46	12	1	



World Class Cutting Tools

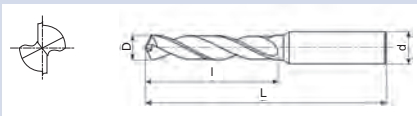
EDP	D	L	I	I1	d	Type	Price
OSG-42-3334398	10.9	90	47	46	12	1	
OSG-42-3334399	11	90	47	46	12	1	
OSG-42-3334400	11.03	90	47	46	12	1	
OSG-42-3334401	11.1	95	51	50	12	1	
OSG-42-3334402	11.2	95	51	50	12	1	
OSG-42-3334403	11.3	95	51	50	12	1	
OSG-42-3334404	11.4	95	51	50	12	1	
OSG-42-3334405	11.5	95	51	50	12	1	
OSG-42-3334406	11.6	95	51	50	12	1	
OSG-42-3334407	11.7	95	51	50	12	1	
OSG-42-3334408	11.8	95	51	50	12	1	
OSG-42-3334409	11.9	95	51	50	12	1	
OSG-42-3334410	12	95	50	51	12	2	
OSG-42-3334411	12.03	100	57	56	14	1	
OSG-42-3334412	12.1	100	57	56	14	1	
OSG-42-3334413	12.2	100	57	56	14	1	
OSG-42-3334414	12.3	100	57	56	14	1	
OSG-42-3334415	12.4	100	57	56	14	1	
OSG-42-3334416	12.5	100	57	56	14	1	
OSG-42-3334417	12.6	100	57	56	14	1	
OSG-42-3334418	12.7	100	57	56	14	1	
OSG-42-3334419	12.8	100	57	56	14	1	
OSG-42-3334420	12.9	100	57	56	14	1	
OSG-42-3334421	13	100	57	56	14	1	
OSG-42-3334422	13.1	105	61	60	14	1	
OSG-42-3334423	13.2	105	61	60	14	1	
OSG-42-3334424	13.3	105	61	60	14	1	
OSG-42-3334425	13.4	105	61	60	14	1	
OSG-42-3334426	13.5	105	61	60	14	1	
OSG-42-3334427	13.6	105	61	60	14	1	
OSG-42-3334428	13.7	105	61	60	14	1	

EDP	D	L	I	I1	d	Type	Price
OSG-42-3334429	13.8	105	61	60	14	1	
OSG-42-3334430	13.9	105	61	60	14	1	
OSG-42-3334431	14	105	61	60	14	2	
OSG-42-3334432	14.1	110	65	64	16	1	
OSG-42-3334433	14.2	110	65	64	16	1	
OSG-42-3334434	14.3	110	65	64	16	1	
OSG-42-3334435	14.4	110	65	64	16	1	
OSG-42-3334436	14.5	110	65	64	16	1	
OSG-42-3334437	14.6	110	65	65	16	1	
OSG-42-3334438	14.7	110	65	65	16	1	
OSG-42-3334439	14.8	110	65	65	16	1	
OSG-42-3334440	14.9	110	65	65	16	1	
OSG-42-3334441	15	110	65	65	16	1	
OSG-42-3334442	15.1	115	69	69	16	1	
OSG-42-3334443	15.2	115	69	69	16	1	
OSG-42-3334444	15.3	115	69	69	16	1	
OSG-42-3334445	15.4	115	69	69	16	1	
OSG-42-3334446	15.5	115	69	69	16	1	
OSG-42-3334447	15.6	115	69	69	16	1	
OSG-42-3334448	15.7	115	69	69	16	1	
OSG-42-3334449	15.8	115	69	69	16	1	
OSG-42-3334450	15.9	115	69	69	16	1	
OSG-42-3334451	16	115	69	69	16	2	
OSG-42-3334452	16.5	125	75	75	18	1	
OSG-42-3334453	17	125	75	75	18	1	
OSG-42-3334454	17.5	130	79	79	18	1	
OSG-42-3334455	18	130	79	79	18	2	
OSG-42-3334456	18.5	135	85	85	20	1	
OSG-42-3334457	19	135	85	85	20	1	
OSG-42-3334458	19.5	140	89	88	20	1	
OSG-42-3334459	20	140	88	89	20	2	

Available on request

AD-2D

Drilling | Solid carbide | 2xD



- First choice in quality and performance
- Carbide drill with EgiAs coating
- Up to 2xD
- For general purpose steels and cast iron

P	P	P	P	K	K	H	H	H
C ≤0,2%	C 0,25-0,4%	C ≥0,45%	SCM	GG	GGG	25-35 HRC	35-45 HRC	45-52 HRC

A	CARBIDE	EgiAs	30°	SHRINK FIT	140°	h8
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EDP	D	L	I	d	Price
OSG-42-8670200	2	62	14	4	
OSG-42-8670210	2,1	62	14	4	
OSG-42-8670220	2,2	62	14	4	
OSG-42-8670230	2,3	62	14	4	
OSG-42-8670240	2,4	62	14	4	
OSG-42-8670250	2,5	62	14	4	
OSG-42-8670260	2,6	62	14	4	
OSG-42-8670270	2,7	62	14	4	
OSG-42-8670276	2,76	62	14	4	
OSG-42-8670278	2,78	62	14	4	
OSG-42-8670280	2,8	62	14	4	
OSG-42-8670290	2,9	62	14	4	
OSG-42-8670300	3	66	20	4	
OSG-42-8670310	3,1	66	20	4	
OSG-42-8670320	3,2	66	20	4	
OSG-42-8670330	3,3	66	20	4	
OSG-42-8670340	3,4	66	20	4	
OSG-42-8670350	3,5	66	20	4	
OSG-42-8670360	3,6	66	20	4	
OSG-42-8670366	3,66	66	20	4	
OSG-42-8670368	3,68	66	20	4	
OSG-42-8670370	3,7	66	20	4	
OSG-42-8670380	3,8	66	24	4	
OSG-42-8670390	3,9	66	24	4	
OSG-42-8670400	4	66	24	4	

EDP	D	L	I	d	Price
OSG-42-8670410	4,1	66	24	6	
OSG-42-8670420	4,2	66	24	6	
OSG-42-8670430	4,3	66	24	6	
OSG-42-8670440	4,4	66	24	6	
OSG-42-8670450	4,5	66	24	6	
OSG-42-8670460	4,6	66	24	6	
OSG-42-8670462	4,62	66	24	6	
OSG-42-8670464	4,64	66	24	6	
OSG-42-8670470	4,7	66	24	6	
OSG-42-8670480	4,8	66	28	6	
OSG-42-8670490	4,9	66	28	6	
OSG-42-8670500	5	66	28	6	
OSG-42-8670510	5,1	66	28	6	
OSG-42-8670520	5,2	66	28	6	
OSG-42-8670530	5,3	66	28	6	
OSG-42-8670540	5,4	66	28	6	
OSG-42-8670550	5,5	66	28	6	
OSG-42-8670552	5,52	66	28	6	
OSG-42-8670554	5,54	66	28	6	
OSG-42-8670560	5,6	66	28	6	
OSG-42-8670570	5,7	66	28	6	
OSG-42-8670580	5,8	66	28	6	
OSG-42-8670590	5,9	66	28	6	
OSG-42-8670600	6	66	28	6	
OSG-42-8670610	6,1	79	34	8	

EDP	D	L	I	d	Price
OSG-42-8670620	6,2	79	34	8	
OSG-42-8670630	6,3	79	34	8	
OSG-42-8670640	6,4	79	34	8	
OSG-42-8670650	6,5	79	34	8	
OSG-42-8670660	6,6	79	34	8	
OSG-42-8670670	6,7	79	34	8	
OSG-42-8670680	6,8	79	34	8	
OSG-42-8670690	6,9	79	34	8	
OSG-42-8670700	7	79	34	8	
OSG-42-8670710	7,1	79	41	8	
OSG-42-8670720	7,2	79	41	8	
OSG-42-8670730	7,3	79	41	8	
OSG-42-8670736	7,36	79	41	8	
OSG-42-8670738	7,38	79	41	8	
OSG-42-8670740	7,4	79	41	8	
OSG-42-8670750	7,5	79	41	8	
OSG-42-8670754	7,54	79	41	8	
OSG-42-8670760	7,6	79	41	8	
OSG-42-8670770	7,7	79	41	8	
OSG-42-8670780	7,8	79	41	8	
OSG-42-8670790	7,9	79	41	8	
OSG-42-8670800	8	79	41	8	
OSG-42-8670810	8,1	89	47	10	
OSG-42-8670820	8,2	89	47	10	
OSG-42-8670830	8,3	89	47	10	
OSG-42-8670840	8,4	89	47	10	
OSG-42-8670850	8,5	89	47	10	
OSG-42-8670860	8,6	89	47	10	
OSG-42-8670870	8,7	89	47	10	
OSG-42-8670880	8,8	89	47	10	
OSG-42-8670890	8,9	89	47	10	
OSG-42-8670900	9	89	47	10	
OSG-42-8670910	9,1	89	47	10	
OSG-42-8670920	9,2	89	47	10	
OSG-42-8670930	9,3	89	47	10	
OSG-42-8670940	9,4	89	47	10	
OSG-42-8670950	9,5	89	47	10	
OSG-42-8670960	9,6	89	47	10	
OSG-42-8670970	9,7	89	47	10	
OSG-42-8670980	9,8	89	47	10	
OSG-42-8670990	9,9	89	47	10	
OSG-42-8671000	10	89	47	10	
OSG-42-8671010	10,1	102	55	12	
OSG-42-8671020	10,2	102	55	12	
OSG-42-8671030	10,3	102	55	12	
OSG-42-8671040	10,4	102	55	12	
OSG-42-8671050	10,5	102	55	12	
OSG-42-8671060	10,6	102	55	12	
OSG-42-8671070	10,7	102	55	12	
OSG-42-8671080	10,8	102	55	12	
OSG-42-8671090	10,9	102	55	12	
OSG-42-8671100	11	102	55	12	
OSG-42-8671110	11,1	102	55	12	
OSG-42-8671120	11,2	102	55	12	
OSG-42-8671130	11,3	102	55	12	

EDP	D	L	I	d	Price
OSG-42-8671140	11,4	102	55	12	
OSG-42-8671150	11,5	102	55	12	
OSG-42-8671160	11,6	102	55	12	
OSG-42-8671170	11,7	102	55	12	
OSG-42-8671180	11,8	102	55	12	
OSG-42-8671190	11,9	102	55	12	
OSG-42-8671200	12	102	55	12	
OSG-42-8671210	12,1	107	60	14	
OSG-42-8671220	12,2	107	60	14	
OSG-42-8671230	12,3	107	60	14	
OSG-42-8671240	12,4	107	60	14	
OSG-42-8671250	12,5	107	60	14	
OSG-42-8671260	12,6	107	60	14	
OSG-42-8671270	12,7	107	60	14	
OSG-42-8671280	12,8	107	60	14	
OSG-42-8671290	12,9	107	60	14	
OSG-42-8671300	13	107	60	14	
OSG-42-8671310	13,1	107	60	14	
OSG-42-8671320	13,2	107	60	14	
OSG-42-8671330	13,3	107	60	14	
OSG-42-8671340	13,4	107	60	14	
OSG-42-8671350	13,5	107	60	14	
OSG-42-8671360	13,6	107	60	14	
OSG-42-8671370	13,7	107	60	14	
OSG-42-8671380	13,8	107	60	14	
OSG-42-8671390	13,9	107	60	14	
OSG-42-8671400	14	107	60	14	
OSG-42-8671410	14,1	115	65	16	
OSG-42-8671420	14,2	115	65	16	
OSG-42-8671430	14,3	115	65	16	
OSG-42-8671440	14,4	115	65	16	
OSG-42-8671450	14,5	115	65	16	
OSG-42-8671460	14,6	115	65	16	
OSG-42-8671470	14,7	115	65	16	
OSG-42-8671480	14,8	115	65	16	
OSG-42-8671490	14,9	115	65	16	
OSG-42-8671500	15	115	65	16	
OSG-42-8671510	15,1	115	65	16	
OSG-42-8671520	15,2	115	65	16	
OSG-42-8671530	15,3	115	65	16	
OSG-42-8671540	15,4	115	65	16	
OSG-42-8671550	15,5	115	65	16	
OSG-42-8671560	15,6	115	65	16	
OSG-42-8671570	15,7	115	65	16	
OSG-42-8671580	15,8	115	65	16	
OSG-42-8671590	15,9	115	65	16	
OSG-42-8671600	16	115	65	16	
OSG-42-8671650	16,5	123	73	18	
OSG-42-8671700	17	123	73	18	
OSG-42-8671750	17,5	123	73	18	
OSG-42-8671800	18	123	73	18	
OSG-42-8671850	18,5	131	79	20	
OSG-42-8671900	19	131	79	20	
OSG-42-8671950	19,5	131	79	20	
OSG-42-8672000	20	131	79	20	

Available on request

AD-4D

Drilling | Solid carbide | 4xD



- First choice in quality and performance
- Carbide drill with EgiAs coating
- Up to 4xD
- For general purpose steels and cast iron

P	P	P	P	K	K	H	H
C: ≤0,2%	C: 0,25-0,4%	C: ≥0,45%	SCM	GG	GGG	25-35 HRC	35-45 HRC
A	CARBIDE	EgiAs	30°	SHRINK	FIT	140°	h8

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EDP	D	L	I	d	Price
OSG-42-8672200	2	66	20	4	

EDP	D	L	I	d	Price
OSG-42-8672210	2,1	66	20	4	



100

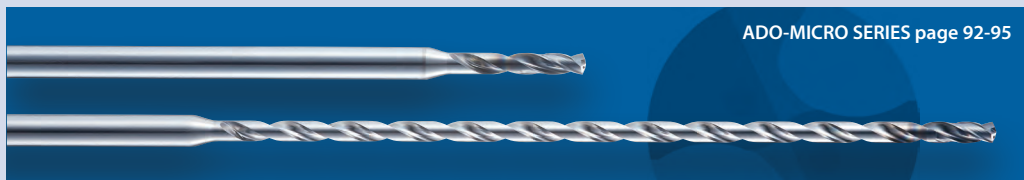
JUNE 2023 V3 SOMTA CATALOGUE

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EDP	D	L	I	d	Price
OSG-42-8672220	2,2	66	20	4	
OSG-42-8672230	2,3	66	20	4	
OSG-42-8672240	2,4	66	20	4	
OSG-42-8672250	2,5	66	20	4	
OSG-42-8672260	2,6	66	20	4	
OSG-42-8672270	2,7	66	20	4	
OSG-42-8672280	2,8	66	20	4	
OSG-42-8672290	2,9	66	20	4	
OSG-42-8672300	3	74	28	4	
OSG-42-8672310	3,1	74	28	4	
OSG-42-8672320	3,2	74	28	4	
OSG-42-8672330	3,3	74	28	4	
OSG-42-8672340	3,4	74	28	4	
OSG-42-8672350	3,5	74	28	4	
OSG-42-8672360	3,6	74	28	4	
OSG-42-8672370	3,7	74	28	4	
OSG-42-8672380	3,8	74	36	4	
OSG-42-8672390	3,9	74	36	4	
OSG-42-8672400	4	74	36	4	
OSG-42-8672410	4,1	74	36	6	
OSG-42-8672420	4,2	74	36	6	
OSG-42-8672430	4,3	74	36	6	
OSG-42-8672440	4,4	74	36	6	
OSG-42-8672450	4,5	74	36	6	
OSG-42-8672460	4,6	74	36	6	
OSG-42-8672470	4,7	74	36	6	
OSG-42-8672480	4,8	82	44	6	
OSG-42-8672490	4,9	82	44	6	
OSG-42-8672500	5	82	44	6	
OSG-42-8672510	5,1	82	44	6	
OSG-42-8672520	5,2	82	44	6	
OSG-42-8672530	5,3	82	44	6	
OSG-42-8672540	5,4	82	44	6	
OSG-42-8672550	5,5	82	44	6	
OSG-42-8672560	5,6	82	44	6	
OSG-42-8672570	5,7	82	44	6	
OSG-42-8672580	5,8	82	44	6	
OSG-42-8672590	5,9	82	44	6	
OSG-42-8672600	6	82	44	6	
OSG-42-8672610	6,1	91	53	8	
OSG-42-8672620	6,2	91	53	8	
OSG-42-8672630	6,3	91	53	8	
OSG-42-8672640	6,4	91	53	8	
OSG-42-8672650	6,5	91	53	8	
OSG-42-8672660	6,6	91	53	8	
OSG-42-8672670	6,7	91	53	8	
OSG-42-8672680	6,8	91	53	8	
OSG-42-8672690	6,9	91	53	8	
OSG-42-8672700	7	91	53	8	
OSG-42-8672710	7,1	91	53	8	
OSG-42-8672720	7,2	91	53	8	
OSG-42-8672730	7,3	91	53	8	
OSG-42-8672740	7,4	91	53	8	
OSG-42-8672750	7,5	91	53	8	
OSG-42-8672760	7,6	91	53	8	
OSG-42-8672770	7,7	91	53	8	
OSG-42-8672780	7,8	91	53	8	
OSG-42-8672790	7,9	91	53	8	
OSG-42-8672800	8	91	53	8	
OSG-42-8672810	8,1	103	61	10	
OSG-42-8672820	8,2	103	61	10	
OSG-42-8672830	8,3	103	61	10	
OSG-42-8672840	8,4	103	61	10	
OSG-42-8672850	8,5	103	61	10	
OSG-42-8672860	8,6	103	61	10	
OSG-42-8672870	8,7	103	61	10	
OSG-42-8672880	8,8	103	61	10	
OSG-42-8672890	8,9	103	61	10	
OSG-42-8672900	9	103	61	10	
OSG-42-8672910	9,1	103	61	10	
OSG-42-8672920	9,2	103	61	10	
OSG-42-8672930	9,3	103	61	10	
OSG-42-8672940	9,4	103	61	10	
OSG-42-8672950	9,5	103	61	10	

EDP	D	L	I	d	Price
OSG-42-8672960	9,6	103	61	10	
OSG-42-8672970	9,7	103	61	10	
OSG-42-8672980	9,8	103	61	10	
OSG-42-8672990	9,9	103	61	10	
OSG-42-8673000	10	103	61	10	
OSG-42-8673010	10,1	118	71	12	
OSG-42-8673020	10,2	118	71	12	
OSG-42-8673030	10,3	118	71	12	
OSG-42-8673040	10,4	118	71	12	
OSG-42-8673050	10,5	118	71	12	
OSG-42-8673060	10,6	118	71	12	
OSG-42-8673070	10,7	118	71	12	
OSG-42-8673080	10,8	118	71	12	
OSG-42-8673090	10,9	118	71	12	
OSG-42-8673100	11	118	71	12	
OSG-42-8673110	11,1	118	71	12	
OSG-42-8673120	11,2	118	71	12	
OSG-42-8673130	11,3	118	71	12	
OSG-42-8673140	11,4	118	71	12	
OSG-42-8673150	11,5	118	71	12	
OSG-42-8673160	11,6	118	71	12	
OSG-42-8673170	11,7	118	71	12	
OSG-42-8673180	11,8	118	71	12	
OSG-42-8673190	11,9	118	71	12	
OSG-42-8673200	12	118	71	12	
OSG-42-8673210	12,1	124	77	14	
OSG-42-8673220	12,2	124	77	14	
OSG-42-8673230	12,3	124	77	14	
OSG-42-8673240	12,4	124	77	14	
OSG-42-8673250	12,5	124	77	14	
OSG-42-8673260	12,6	124	77	14	
OSG-42-8673270	12,7	124	77	14	
OSG-42-8673280	12,8	124	77	14	
OSG-42-8673290	12,9	124	77	14	
OSG-42-8673300	13	124	77	14	
OSG-42-8673310	13,1	124	77	14	
OSG-42-8673320	13,2	124	77	14	
OSG-42-8673330	13,3	124	77	14	
OSG-42-8673340	13,4	124	77	14	
OSG-42-8673350	13,5	124	77	14	
OSG-42-8673360	13,6	124	77	14	
OSG-42-8673370	13,7	124	77	14	
OSG-42-8673380	13,8	124	77	14	
OSG-42-8673390	13,9	124	77	14	
OSG-42-8673400	14	124	77	14	
OSG-42-8673410	14,1	133	83	16	
OSG-42-8673420	14,2	133	83	16	
OSG-42-8673430	14,3	133	83	16	
OSG-42-8673440	14,4	133	83	16	
OSG-42-8673450	14,5	133	83	16	
OSG-42-8673460	14,6	133	83	16	
OSG-42-8673470	14,7	133	83	16	
OSG-42-8673480	14,8	133	83	16	
OSG-42-8673490	14,9	133	83	16	
OSG-42-8673500	15	133	83	16	
OSG-42-8673510	15,1	133	83	16	
OSG-42-8673520	15,2	133	83	16	
OSG-42-8673530	15,3	133	83	16	
OSG-42-8673540	15,4	133	83	16	
OSG-42-8673550	15,5	133	83	16	
OSG-42-8673560	15,6	133	83	16	
OSG-42-8673570	15,7	133	83	16	
OSG-42-8673580	15,8	133	83	16	
OSG-42-8673590	15,9	133	83	16	
OSG-42-8673600	16	133	83	16	
OSG-42-8673650	16,5	143	93	18	
OSG-42-8673700	17	143	93	18	
OSG-42-8673750	17,5	143	93	18	
OSG-42-8673800	18	143	93	18	
OSG-42-8673850	18,5	153	101	20	
OSG-42-8673900	19	153	101	20	
OSG-42-8673950	19,5	153	101	20	
OSG-42-8674000	20	153	101	20	

Available on request



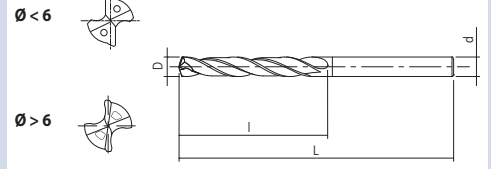
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ADO-SUS-3D

Drilling | Solid carbide | 3xD



- First choice in quality and performance
- Carbide drill with internal coolant, WXL coating
- Up to 3xD
- Designed for stainless steel and titanium alloys



EDP	D	L	I	d	Price
OSG-42-8665200	2	66	12	3	
OSG-42-8665210	2,1	66	13	3	
OSG-42-8665220	2,2	66	14	3	
OSG-42-8665230	2,3	66	14	3	
OSG-42-8665240	2,4	66	15	3	
OSG-42-8665250	2,5	66	15	3	
OSG-42-8665260	2,6	66	16	3	
OSG-42-8665270	2,7	66	17	3	
OSG-42-8665280	2,8	66	17	3	
OSG-42-8665283	2,83	66	17	3	
OSG-42-8665287	2,87	66	18	3	
OSG-42-8665290	2,9	66	18	3	
OSG-42-8665300	3	66	18	3	
OSG-42-8665310	3,1	74	19	4	
OSG-42-8665315	3,15	74	19	4	
OSG-42-8665320	3,2	74	20	4	
OSG-42-8665326	3,26	74	20	4	
OSG-42-8665330	3,3	74	20	4	
OSG-42-8665340	3,4	74	21	4	
OSG-42-8665350	3,5	74	21	4	
OSG-42-8665360	3,6	74	22	4	
OSG-42-8665370	3,7	74	23	4	
OSG-42-8665373	3,73	74	23	4	
OSG-42-8665375	3,75	74	23	4	
OSG-42-8665380	3,8	74	23	4	
OSG-42-8665390	3,9	74	24	4	
OSG-42-8665400	4	74	24	4	
OSG-42-8680410	4,1	80	25	6	
OSG-42-8680420	4,2	80	26	6	
OSG-42-8680430	4,3	80	26	6	
OSG-42-8680440	4,4	80	27	6	
OSG-42-8680445	4,45	80	27	6	
OSG-42-8680450	4,5	80	27	6	
OSG-42-8680460	4,6	80	28	6	
OSG-42-8680465	4,65	80	28	6	
OSG-42-8680470	4,7	80	29	6	
OSG-42-8680480	4,8	80	29	6	
OSG-42-8665485	4,85	80	29	6	
OSG-42-8680490	4,9	80	30	6	
OSG-42-8680500	5	80	25	6	
OSG-42-8665510	5,1	82	26	6	
OSG-42-8665520	5,2	82	26	6	
OSG-42-8665525	5,25	82	27	6	
OSG-42-8665530	5,3	82	27	6	
OSG-42-8665540	5,4	82	27	6	
OSG-42-8665550	5,5	82	28	6	
OSG-42-8680555	5,55	82	28	6	
OSG-42-8665560	5,6	82	28	6	
OSG-42-8665570	5,7	82	29	6	
OSG-42-8665580	5,8	82	29	6	
OSG-42-8665590	5,9	82	30	6	
OSG-42-8665600	6	82	30	6	
OSG-42-8680610	6,1	88	31	8	
OSG-42-8680620	6,2	88	31	8	
OSG-42-8680630	6,3	88	32	8	
OSG-42-8680640	6,4	88	32	8	
OSG-42-8680650	6,5	88	33	8	
OSG-42-8680660	6,6	88	33	8	
OSG-42-8680670	6,7	88	34	8	
OSG-42-8680680	6,8	88	34	8	

EDP	D	L	I	d	Price
OSG-42-8680690	6,9	88	35	8	
OSG-42-8680700	7	88	35	8	
OSG-42-8665710	7,1	94	36	8	
OSG-42-8665720	7,2	94	36	8	
OSG-42-8665725	7,25	94	37	8	
OSG-42-8665730	7,3	94	37	8	
OSG-42-8665740	7,4	94	37	8	
OSG-42-8680745	7,45	94	38	8	
OSG-42-8665750	7,5	94	38	8	
OSG-42-8680755	7,55	94	38	8	
OSG-42-8665760	7,6	94	38	8	
OSG-42-8665770	7,7	94	39	8	
OSG-42-8665775	7,75	94	39	8	
OSG-42-8665780	7,8	94	39	8	
OSG-42-8665790	7,9	94	40	8	
OSG-42-8665800	8	94	40	8	
OSG-42-8680810	8,1	101	41	10	
OSG-42-8680820	8,2	101	41	10	
OSG-42-8680830	8,3	101	42	10	
OSG-42-8680840	8,4	101	42	10	
OSG-42-8680850	8,5	101	43	10	
OSG-42-8680860	8,6	101	43	10	
OSG-42-8680870	8,7	101	44	10	
OSG-42-8680880	8,8	101	44	10	
OSG-42-8680890	8,9	101	45	10	
OSG-42-8680900	9	101	45	10	
OSG-42-8665910	9,1	106	46	10	
OSG-42-8665920	9,2	106	46	10	
OSG-42-8665925	9,25	106	47	10	
OSG-42-8665930	9,3	106	47	10	
OSG-42-8665940	9,4	106	47	10	
OSG-42-8665950	9,5	106	48	10	
OSG-42-8680955	9,55	106	48	10	
OSG-42-8665960	9,6	106	48	10	
OSG-42-8665970	9,7	106	49	10	
OSG-42-8665975	9,75	106	49	10	
OSG-42-8665980	9,8	106	49	10	
OSG-42-8665990	9,9	106	50	10	
OSG-42-8666000	10	106	50	10	
OSG-42-8681010	10,1	113	51	12	
OSG-42-8681020	10,2	113	51	12	
OSG-42-8681030	10,3	113	52	12	
OSG-42-8681040	10,4	113	52	12	
OSG-42-8681050	10,5	113	53	12	
OSG-42-8681060	10,6	113	53	12	
OSG-42-8681070	10,7	113	54	12	
OSG-42-8681080	10,8	113	54	12	
OSG-42-8681090	10,9	113	55	12	
OSG-42-8681100	11	113	55	12	
OSG-42-8666110	11,1	120	56	12	
OSG-42-8666120	11,2	120	56	12	
OSG-42-8666130	11,3	120	57	12	
OSG-42-8666140	11,4	120	57	12	
OSG-42-8666150	11,5	120	58	12	
OSG-42-8666160	11,6	120	58	12	
OSG-42-8666170	11,7	120	59	12	
OSG-42-8666180	11,8	120	59	12	
OSG-42-8666190	11,9	120	60	12	
OSG-42-8666200	12	120	60	12	
OSG-42-8681210	12,1	128	61	14	



EDP	D	L	I	d	Price
OSG-42-8681220	12,2	128	61	14	
OSG-42-8681230	12,3	128	62	14	
OSG-42-8681240	12,4	128	62	14	
OSG-42-8681250	12,5	128	63	14	
OSG-42-8681260	12,6	128	63	14	
OSG-42-8681270	12,7	128	64	14	
OSG-42-8681280	12,8	128	64	14	
OSG-42-8681290	12,9	128	65	14	
OSG-42-8681300	13	128	65	14	
OSG-42-8666310	13,1	134	66	14	
OSG-42-8666320	13,2	134	67	14	
OSG-42-8666330	13,3	134	68	14	
OSG-42-8666340	13,4	134	67	14	
OSG-42-8681343	13,43	134	68	14	
OSG-42-8666350	13,5	134	68	14	
OSG-42-8681355	13,55	134	68	14	
OSG-42-8666360	13,6	134	68	14	
OSG-42-8666370	13,7	134	69	14	
OSG-42-8666380	13,8	134	69	14	
OSG-42-8666390	13,9	134	70	14	
OSG-42-8666400	14	134	70	14	
OSG-42-8681410	14,1	140	71	16	
OSG-42-8681420	14,2	140	71	16	
OSG-42-8681430	14,3	140	72	16	
OSG-42-8681440	14,4	140	72	16	
OSG-42-8681450	14,5	140	73	16	
OSG-42-8681460	14,6	140	73	16	
OSG-42-8681470	14,7	140	74	16	
OSG-42-8681480	14,8	140	74	16	
OSG-42-8681490	14,9	140	75	16	

EDP	D	L	I	d	Price
OSG-42-8681500	15	140	75	16	
OSG-42-8666510	15,1	145	76	16	
OSG-42-8666520	15,2	145	76	16	
OSG-42-8666530	15,3	145	77	16	
OSG-42-8666540	15,4	145	77	16	
OSG-42-8666550	15,5	145	78	16	
OSG-42-8681555	15,55	145	78	16	
OSG-42-8666560	15,6	145	78	16	
OSG-42-8666570	15,7	145	79	16	
OSG-42-8666580	15,8	145	79	16	
OSG-42-8666590	15,9	145	80	16	
OSG-42-8666600	16	145	80	16	
OSG-42-48350161	16,1	145	80	18	
OSG-42-8681650	16,5	150	83	18	
OSG-42-8681670	16,7	150	84	18	
OSG-42-8681700	17	150	85	18	
OSG-42-8681730	17,3	155	87	18	
OSG-42-8666750	17,5	155	88	18	
OSG-42-8681755	17,55	155	88	18	
OSG-42-48350178	17,8	155	90	18	
OSG-42-8666800	18	155	90	18	
OSG-42-48350181	18,1	155	90	20	
OSG-42-8681850	18,5	160	93	20	
OSG-42-8681870	18,7	160	94	20	
OSG-42-8681900	19	160	95	20	
OSG-42-8681930	19,3	165	97	20	
OSG-42-8666950	19,5	165	98	20	
OSG-42-8681955	19,55	165	98	20	
OSG-42-8667000	20	165	100	20	

Available on request

ADO-SUS-5D

Drilling | Solid carbide | 5xD



- First choice in quality and performance
- Carbide drill with internal coolant, WXL coating
- Up to 5xD
- Designed for stainless steel and titanium alloys

P	P	P	P	M	K	K	N	S	H	H	H
C: ≤0,2%	C: 0,25-0,4%	C: ≥0,45%	SCM	INOX	GG	GGG	AC/ADC	Ti	25-35 HRC	35-45 HRC	45-52 HRC

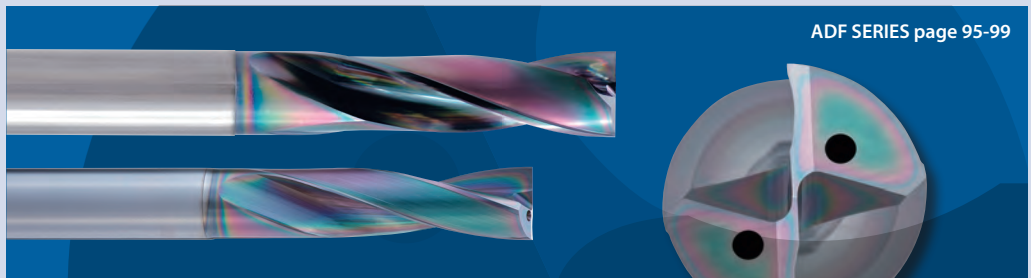


EDP	D	L	I	d	Price
OSG-42-8667200	2	70	18	3	
OSG-42-8667210	2,1	70	19	3	
OSG-42-48349215	2,15	70	20	3	
OSG-42-8667220	2,2	70	20	3	
OSG-42-48349225	2,25	70	21	3	
OSG-42-8667230	2,3	70	21	3	
OSG-42-48349235	2,35	70	22	3	
OSG-42-8667240	2,4	70	22	3	
OSG-42-8667250	2,5	70	23	3	
OSG-42-48349255	2,55	70	24	3	
OSG-42-8667260	2,6	78	24	3	
OSG-42-8667270	2,7	78	25	3	
OSG-42-8667276	2,76	78	25	3	
OSG-42-8667278	2,78	78	26	3	
OSG-42-8667280	2,8	78	26	3	
OSG-42-8667283	2,83	78	26	3	
OSG-42-8667287	2,87	78	26	3	
OSG-42-8667290	2,9	78	27	3	
OSG-42-8667300	3	78	27	3	
OSG-42-8667310	3,1	86	28	4	
OSG-42-8667315	3,15	86	29	4	
OSG-42-8667320	3,2	86	29	4	
OSG-42-8667326	3,26	86	29	4	
OSG-42-8667330	3,3	86	30	4	
OSG-42-48349335	3,35	86	31	4	
OSG-42-8667340	3,4	86	31	4	

EDP	D	L	I	d	Price
OSG-42-8667350	3,5	86	32	4	
OSG-42-8667360	3,6	86	33	4	
OSG-42-8667366	3,66	86	33	4	
OSG-42-8667368	3,68	86	34	4	
OSG-42-8667370	3,7	86	34	4	
OSG-42-8667373	3,73	86	34	4	
OSG-42-8667375	3,75	86	34	4	
OSG-42-8667380	3,8	86	35	4	
OSG-42-8667390	3,9	86	36	4	
OSG-42-8667400	4	86	36	4	
OSG-42-8682410	4,1	95	37	6	
OSG-42-8682420	4,2	95	38	6	
OSG-42-8682430	4,3	95	39	6	
OSG-42-8682440	4,4	95	40	6	
OSG-42-8682445	4,45	95	41	6	
OSG-42-8682450	4,5	95	41	6	
OSG-42-8682460	4,6	95	42	6	
OSG-42-8682464	4,64	95	42	6	
OSG-42-8682470	4,7	95	43	6	
OSG-42-8682480	4,8	95	44	6	
OSG-42-8682490	4,9	95	45	6	
OSG-42-8682500	5	95	45	6	
OSG-42-8667510	5,1	100	41	6	
OSG-42-8667520	5,2	100	42	6	
OSG-42-8667530	5,3	100	43	6	
OSG-42-8667540	5,4	100	44	6	

EDP	D	L	I	d	Price
OSG-42-8667550	5,5	100	44	6	
OSG-42-8667552	5,52	100	45	6	
OSG-42-8667554	5,54	100	45	6	
OSG-42-8667560	5,6	100	45	6	
OSG-42-8667570	5,7	100	46	6	
OSG-42-8667580	5,8	100	47	6	
OSG-42-8667590	5,9	100	48	6	
OSG-42-8667600	6	100	48	6	
OSG-42-8682610	6,1	109	49	8	
OSG-42-8682620	6,2	109	50	8	
OSG-42-8682630	6,3	109	51	8	
OSG-42-8682640	6,4	109	52	8	
OSG-42-8682650	6,5	109	52	8	
OSG-42-8682660	6,6	109	53	8	
OSG-42-8682670	6,7	109	54	8	
OSG-42-8682680	6,8	109	55	8	
OSG-42-8682690	6,9	109	56	8	
OSG-42-8682700	7	109	56	8	
OSG-42-8667710	7,1	118	57	8	
OSG-42-8667720	7,2	118	58	8	
OSG-42-8667725	7,25	118	58	8	
OSG-42-8667730	7,3	118	59	8	
OSG-42-8667736	7,36	118	59	8	
OSG-42-8667738	7,38	118	60	8	
OSG-42-8667740	7,4	118	60	8	
OSG-42-8682745	7,45	118	60	8	
OSG-42-8667750	7,5	118	60	8	
OSG-42-8667752	7,52	118	61	8	
OSG-42-8667754	7,54	118	61	8	
OSG-42-8667760	7,6	118	61	8	
OSG-42-8667770	7,7	118	62	8	
OSG-42-8667775	7,75	118	62	8	
OSG-42-8667780	7,8	118	63	8	
OSG-42-8667790	7,9	118	64	8	
OSG-42-8667800	8	118	64	8	
OSG-42-8682810	8,1	128	65	10	
OSG-42-8682820	8,2	128	66	10	
OSG-42-8682830	8,3	128	67	10	
OSG-42-8682840	8,4	128	68	10	
OSG-42-8682850	8,5	128	68	10	
OSG-42-8682860	8,6	128	69	10	
OSG-42-8682870	8,7	128	70	10	
OSG-42-8682880	8,8	128	71	10	
OSG-42-8682890	8,9	128	72	10	
OSG-42-8682900	9	128	72	10	
OSG-42-8667910	9,1	136	73	10	
OSG-42-8667920	9,2	136	74	10	
OSG-42-8667924	9,24	136	74	10	
OSG-42-8667925	9,25	136	74	10	
OSG-42-8667926	9,26	136	75	10	
OSG-42-8667930	9,3	136	75	10	
OSG-42-8667936	9,36	136	75	10	
OSG-42-8667938	9,38	136	76	10	
OSG-42-8667940	9,4	136	76	10	
OSG-42-8667950	9,5	136	76	10	
OSG-42-8667952	9,52	136	77	10	
OSG-42-8667954	9,54	136	77	10	
OSG-42-8667960	9,6	136	77	10	
OSG-42-8667970	9,7	136	78	10	
OSG-42-8667975	9,75	136	78	10	
OSG-42-8667980	9,8	136	79	10	
OSG-42-8667990	9,9	136	80	10	
OSG-42-8680000	10	136	80	10	
OSG-42-8683010	10,1	146	81	12	
OSG-42-8683020	10,2	146	82	12	
OSG-42-8683030	10,3	146	83	12	
OSG-42-8683040	10,4	146	84	12	
OSG-42-8683050	10,5	146	84	12	

EDP	D	L	I	d	Price
OSG-42-8683060	10,6	146	85	12	
OSG-42-8683070	10,7	146	86	12	
OSG-42-8683080	10,8	146	87	12	
OSG-42-8683090	10,9	146	88	12	
OSG-42-8683100	11	146	88	12	
OSG-42-8688110	11,1	156	89	12	
OSG-42-8688120	11,2	156	90	12	
OSG-42-8688122	11,22	156	90	12	
OSG-42-8688124	11,24	156	90	12	
OSG-42-8688130	11,3	156	91	12	
OSG-42-8688136	11,36	156	91	12	
OSG-42-8688138	11,38	156	92	12	
OSG-42-8688140	11,4	156	92	12	
OSG-42-8688150	11,5	156	92	12	
OSG-42-8688160	11,6	156	93	12	
OSG-42-8688170	11,7	156	94	12	
OSG-42-8688180	11,8	156	95	12	
OSG-42-8688190	11,9	156	96	12	
OSG-42-8688200	12	156	96	12	
OSG-42-8683210	12,1	167	97	14	
OSG-42-8683220	12,2	167	98	14	
OSG-42-8683230	12,3	167	99	14	
OSG-42-8683240	12,4	167	100	14	
OSG-42-8683250	12,5	167	100	14	
OSG-42-8683260	12,6	167	101	14	
OSG-42-8683270	12,7	167	102	14	
OSG-42-8683280	12,8	167	103	14	
OSG-42-8683290	12,9	167	104	14	
OSG-42-8683300	13	167	104	14	
OSG-42-8688310	13,1	176	105	14	
OSG-42-8688320	13,2	176	106	14	
OSG-42-8688325	13,25	176	106	14	
OSG-42-8688330	13,3	176	107	14	
OSG-42-8688340	13,4	176	108	14	
OSG-42-8683343	13,43	176	108	14	
OSG-42-8688350	13,5	176	108	14	
OSG-42-8683355	13,55	176	109	14	
OSG-42-8688360	13,6	176	109	14	
OSG-42-8688370	13,7	176	110	14	
OSG-42-8688380	13,8	176	111	14	
OSG-42-8688390	13,9	176	112	14	
OSG-42-8688400	14	176	112	14	
OSG-42-8683410	14,1	185	113	16	
OSG-42-8683420	14,2	185	114	16	
OSG-42-8683430	14,3	185	115	16	
OSG-42-8683440	14,4	185	116	16	
OSG-42-8683450	14,5	185	116	16	
OSG-42-8683460	14,6	185	117	16	
OSG-42-8683470	14,7	185	118	16	
OSG-42-8683480	14,8	185	119	16	
OSG-42-8683490	14,9	185	120	16	
OSG-42-8683500	15	185	120	16	
OSG-42-8688510	15,1	193	121	16	
OSG-42-8688520	15,2	193	122	16	
OSG-42-8688525	15,25	193	122	16	
OSG-42-8688530	15,3	193	123	16	
OSG-42-8688540	15,4	193	124	16	
OSG-42-8688550	15,5	193	124	16	
OSG-42-8683555	15,55	193	125	16	
OSG-42-8688560	15,6	193	125	16	
OSG-42-8688570	15,7	193	126	16	
OSG-42-8688580	15,8	193	127	16	
OSG-42-8688590	15,9	193	128	16	
OSG-42-8688600	16	193	128	16	
OSG-42-8683650	16,5	184	113	18	
OSG-42-8683670	16,7	184	117	18	
OSG-42-8683700	17	184	114	18	
OSG-42-8683730	17,3	191	122	18	



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EDP	D	L	I	d	Price
OSG-42-8668750	17,5	191	123	18	
OSG-42-8668755	17,55	191	123	18	
OSG-42-8668800	18	191	126	18	
OSG-42-8668850	18,5	198	130	20	
OSG-42-8668870	18,7	198	131	20	

EDP	D	L	I	d	Price
OSG-42-8683900	19	198	133	20	
OSG-42-8683930	19,3	205	136	20	
OSG-42-8668950	19,5	205	137	20	
OSG-42-8683955	19,55	205	137	20	
OSG-42-8669000	20	205	140	20	

Available on request

ADO-SUS-8D

Drilling | Solid carbide | 8xD



- First choice in quality and performance
- Carbide drill with internal coolant, WXL coating
- Up to 8xD
- Designed for stainless steel and titanium alloys

P	P	P	P	M	K	K	N	S	H	H	H
C: ≤0,2%	C: 0,25-0,4%	C: ≥0,45%	SCM	INOX	GG	GGG	AC, ADC	Ti	25-35 HRC	35-45 HRC	45-52 HRC

A	CARBIDE	WXL	30°	SHRINK	FIT	135°	h8
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EDP	D	L	I	d	Price
OSG-42-8686200	2	75	22	3	
OSG-42-8686210	2,1	75	24	3	
OSG-42-8686220	2,2	75	25	3	
OSG-42-8686230	2,3	75	26	3	
OSG-42-8686240	2,4	75	27	3	
OSG-42-8686250	2,5	75	28	3	
OSG-42-8686260	2,6	80	29	3	
OSG-42-8686270	2,7	80	30	3	
OSG-42-8686280	2,8	80	31	3	
OSG-42-8686290	2,9	80	32	3	
OSG-42-8686300	3	80	33	3	
OSG-42-8684310	3,1	95	34	4	
OSG-42-8684320	3,2	95	35	4	
OSG-42-8684330	3,3	95	36	4	
OSG-42-8684340	3,4	95	37	4	
OSG-42-8684350	3,5	95	39	4	
OSG-42-8684360	3,6	95	40	4	
OSG-42-8684370	3,7	95	41	4	
OSG-42-8684380	3,8	95	42	4	
OSG-42-8684390	3,9	95	43	4	
OSG-42-8684400	4	95	44	4	
OSG-42-8684410	4,1	105	45	6	
OSG-42-8684420	4,2	105	46	6	
OSG-42-8684430	4,3	105	47	6	
OSG-42-8684440	4,4	105	48	6	
OSG-42-8684450	4,5	105	50	6	
OSG-42-8684460	4,6	105	51	6	
OSG-42-8684470	4,7	105	52	6	
OSG-42-8684480	4,8	105	53	6	
OSG-42-8684490	4,9	105	54	6	
OSG-42-8684500	5	105	55	6	
OSG-42-8684510	5,1	115	56	6	
OSG-42-8684520	5,2	115	57	6	
OSG-42-8684530	5,3	115	58	6	
OSG-42-8684540	5,4	115	59	6	
OSG-42-8684550	5,5	115	61	6	
OSG-42-8684560	5,6	115	62	6	
OSG-42-8684570	5,7	115	63	6	
OSG-42-8684580	5,8	115	64	6	
OSG-42-8684590	5,9	115	65	6	
OSG-42-8684600	6	115	66	6	
OSG-42-8684610	6,1	125	67	8	
OSG-42-8684620	6,2	125	68	8	
OSG-42-8684630	6,3	125	69	8	
OSG-42-8684640	6,4	125	70	8	
OSG-42-8684650	6,5	125	72	8	
OSG-42-8684660	6,6	125	73	8	
OSG-42-8684670	6,7	125	74	8	
OSG-42-8684680	6,8	125	75	8	
OSG-42-8684690	6,9	125	76	8	
OSG-42-8684700	7	125	77	8	

EDP	D	L	I	d	Price
OSG-42-8684710	7,1	140	78	8	
OSG-42-8684720	7,2	140	79	8	
OSG-42-8684730	7,3	140	80	8	
OSG-42-8684740	7,4	140	81	8	
OSG-42-8684750	7,5	140	83	8	
OSG-42-8684760	7,6	140	84	8	
OSG-42-8684770	7,7	140	85	8	
OSG-42-8684780	7,8	140	86	8	
OSG-42-8684790	7,9	140	87	8	
OSG-42-8684800	8	140	88	8	
OSG-42-8684810	8,1	150	89	10	
OSG-42-8684820	8,2	150	90	10	
OSG-42-8684830	8,3	150	91	10	
OSG-42-8684840	8,4	150	92	10	
OSG-42-8684850	8,5	150	94	10	
OSG-42-8684860	8,6	150	95	10	
OSG-42-8684870	8,7	150	96	10	
OSG-42-8684880	8,8	150	97	10	
OSG-42-8684890	8,9	150	98	10	
OSG-42-8684900	9	150	99	10	
OSG-42-8684910	9,1	160	100	10	
OSG-42-8684920	9,2	160	101	10	
OSG-42-8684930	9,3	160	102	10	
OSG-42-8684940	9,4	160	103	10	
OSG-42-8684950	9,5	160	105	10	
OSG-42-8684960	9,6	160	106	10	
OSG-42-8684970	9,7	160	107	10	
OSG-42-8684980	9,8	160	108	10	
OSG-42-8684990	9,9	160	109	10	
OSG-42-8685000	10	160	110	10	
OSG-42-8685010	10,1	182	111	12	
OSG-42-8685020	10,2	182	112	12	
OSG-42-8685030	10,3	182	113	12	
OSG-42-8685040	10,4	182	114	12	
OSG-42-8685050	10,5	182	116	12	
OSG-42-8685060	10,6	182	117	12	
OSG-42-8685070	10,7	182	118	12	
OSG-42-8685080	10,8	182	119	12	
OSG-42-8685090	10,9	182	120	12	
OSG-42-8685100	11	182	121	12	
OSG-42-8685110	11,1	194	122	12	
OSG-42-8685120	11,2	194	123	12	
OSG-42-8685130	11,3	194	124	12	
OSG-42-8685140	11,4	194	125	12	
OSG-42-8685150	11,5	194	127	12	
OSG-42-8685160	11,6	194	128	12	
OSG-42-8685170	11,7	194	129	12	
OSG-42-8685180	11,8	194	130	12	
OSG-42-8685190	11,9	194	131	12	
OSG-42-8685200	12	194	132	12	

Available on request

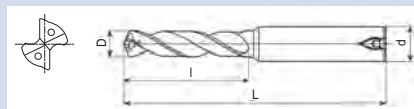
High Performance Drilling | Solid carbide
ADO-SUS-5D/8D

ADO-PLT

Drilling | Solid carbide | Pilot Drill



- First choice in quality and performance
- Carbide pilot drill with internal coolant, EgiAs coating
- For general purpose steels and cast iron



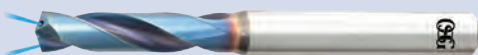
EDP	D	L	I	d	Price
OSG-42-8688903	3,03	65	15	3	
OSG-42-8688923	3,53	70	18	4	
OSG-42-8688904	4,03	70	20	4	
OSG-42-8688924	4,53	75	23	5	
OSG-42-8688905	5,03	75	25	5	
OSG-42-8688925	5,53	80	28	6	
OSG-42-8688906	6,03	80	30	6	
OSG-42-8688926	6,53	85	33	7	

EDP	D	L	I	d	Price
OSG-42-8688907	7,03	85	35	7	
OSG-42-8688908	8,03	90	40	8	
OSG-42-8688928	8,53	95	43	9	
OSG-42-8688909	9,03	95	45	9	
OSG-42-8688910	10,03	100	50	10	
OSG-42-8688911	11,03	115	55	11	
OSG-42-8688912	12,03	120	60	12	

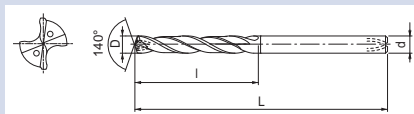
Available on request

ADO-3D

Drilling | Solid carbide | 3xD



- First choice in quality and performance
- Carbide drill with internal coolant, EgiAs coating
- Up to 3xD
- For general purpose steels and cast iron



EDP	D	L	I	d	Price
OSG-42-8690200	2	66	12	3	
OSG-42-8690210	2,1	66	13	3	
OSG-42-8690220	2,2	66	14	3	
OSG-42-8690230	2,3	66	14	3	
OSG-42-8690240	2,4	66	15	3	
OSG-42-8690250	2,5	66	15	3	
OSG-42-8690260	2,6	66	16	3	
OSG-42-8690265	2,65	66	16	3	
OSG-42-8690270	2,7	66	17	3	
OSG-42-8690280	2,8	66	17	3	
OSG-42-8690290	2,9	66	18	3	
OSG-42-8690300	3	66	18	3	
OSG-42-8690310	3,1	74	19	4	
OSG-42-8690315	3,15	74	19	4	
OSG-42-8690320	3,2	74	20	4	
OSG-42-8690330	3,3	74	20	4	
OSG-42-8690340	3,4	74	21	4	
OSG-42-8690350	3,5	74	21	4	
OSG-42-8690360	3,6	74	22	4	
OSG-42-8690370	3,7	74	23	4	
OSG-42-8690375	3,75	74	23	4	
OSG-42-8690380	3,8	74	23	4	
OSG-42-8690390	3,9	74	24	4	

EDP	D	L	I	d	Price
OSG-42-8690400	4	74	24	4	
OSG-42-8690410	4,1	80	25	5	
OSG-42-8700410	4,1	80	25	6	
OSG-42-8690420	4,2	80	26	5	
OSG-42-8700420	4,2	80	26	6	
OSG-42-8690430	4,3	80	26	5	
OSG-42-8700430	4,3	80	26	6	
OSG-42-8690440	4,4	80	27	5	
OSG-42-8700440	4,4	80	27	6	
OSG-42-8690450	4,5	80	27	5	
OSG-42-8700450	4,5	80	27	6	
OSG-42-8690460	4,6	80	28	5	
OSG-42-8700460	4,6	80	28	6	
OSG-42-8690470	4,7	80	29	5	
OSG-42-8700470	4,7	80	29	6	
OSG-42-8690480	4,8	80	29	5	
OSG-42-8700480	4,8	80	29	6	
OSG-42-8690490	4,9	80	30	5	
OSG-42-8700490	4,9	80	30	6	
OSG-42-8690500	5	80	25	5	
OSG-42-8700500	5	80	25	6	
OSG-42-8690510	5,1	82	26	6	
OSG-42-8690520	5,2	82	26	6	



EDP	D	L	I	d	Price
OSG-42-8690525	5,25	82	27	6	
OSG-42-8690530	5,3	82	27	6	
OSG-42-8690540	5,4	82	27	6	
OSG-42-8690550	5,5	82	28	6	
OSG-42-8690560	5,6	82	28	6	
OSG-42-8690570	5,7	82	29	6	
OSG-42-8690580	5,8	82	29	6	
OSG-42-8690590	5,9	82	30	6	
OSG-42-8690600	6	82	30	6	
OSG-42-8700610	6,1	88	31	8	
OSG-42-8700620	6,2	88	31	8	
OSG-42-8700630	6,3	88	32	8	
OSG-42-8700640	6,4	88	32	8	
OSG-42-8700650	6,5	88	33	8	
OSG-42-8700660	6,6	88	33	8	
OSG-42-8700670	6,7	88	34	8	
OSG-42-8700680	6,8	88	34	8	
OSG-42-8700690	6,9	88	35	8	
OSG-42-8700700	7	88	35	8	
OSG-42-8690710	7,1	94	36	8	
OSG-42-8690720	7,2	94	36	8	
OSG-42-8690725	7,25	94	37	8	
OSG-42-8690730	7,3	94	37	8	
OSG-42-8690740	7,4	94	37	8	
OSG-42-8690750	7,5	94	38	8	
OSG-42-8690760	7,6	94	38	8	
OSG-42-8690770	7,7	94	39	8	
OSG-42-8690775	7,75	94	39	8	
OSG-42-8690780	7,8	94	39	8	
OSG-42-8690790	7,9	94	40	8	
OSG-42-8690800	8	94	40	8	
OSG-42-8700810	8,1	101	41	10	
OSG-42-8700820	8,2	101	41	10	
OSG-42-8700830	8,3	101	42	10	
OSG-42-8700840	8,4	101	42	10	
OSG-42-8700850	8,5	101	43	10	
OSG-42-8700860	8,6	101	43	10	
OSG-42-8700870	8,7	101	43	10	
OSG-42-8700880	8,8	101	44	10	
OSG-42-8700890	8,9	101	45	10	
OSG-42-8700900	9	101	45	10	
OSG-42-8690910	9,1	106	46	10	
OSG-42-8690920	9,2	106	46	10	
OSG-42-8690925	9,25	106	47	10	
OSG-42-8690930	9,3	106	47	10	
OSG-42-8690940	9,4	106	47	10	
OSG-42-8690950	9,5	106	48	10	
OSG-42-8690960	9,6	106	48	10	
OSG-42-8690970	9,7	106	49	10	
OSG-42-8690975	9,75	106	49	10	
OSG-42-8690980	9,8	106	49	10	
OSG-42-8690990	9,9	106	50	10	
OSG-42-8691000	10	106	50	10	
OSG-42-8701010	10,1	113	51	12	
OSG-42-8701020	10,2	113	51	12	
OSG-42-8701030	10,3	113	52	12	
OSG-42-8701040	10,4	113	52	12	
OSG-42-8701050	10,5	113	53	12	
OSG-42-8701060	10,6	113	53	12	

EDP	D	L	I	d	Price
OSG-42-8701070	10,7	113	54	12	
OSG-42-8701080	10,8	113	54	12	
OSG-42-8701090	10,9	113	55	12	
OSG-42-8701100	11	113	55	12	
OSG-42-8691110	11,1	120	56	12	
OSG-42-8691120	11,2	120	56	12	
OSG-42-8691130	11,3	120	57	12	
OSG-42-8691140	11,4	120	57	12	
OSG-42-8691150	11,5	120	58	12	
OSG-42-8691160	11,6	120	58	12	
OSG-42-8691170	11,7	120	59	12	
OSG-42-8691180	11,8	120	59	12	
OSG-42-8691190	11,9	120	60	12	
OSG-42-8691200	12	120	60	12	
OSG-42-8701210	12,1	128	61	14	
OSG-42-8701220	12,2	128	61	14	
OSG-42-8701230	12,3	128	62	14	
OSG-42-8701240	12,4	128	62	14	
OSG-42-8701250	12,5	128	63	14	
OSG-42-8701260	12,6	128	63	14	
OSG-42-8701270	12,7	128	64	14	
OSG-42-8701280	12,8	128	64	14	
OSG-42-8701290	12,9	128	65	14	
OSG-42-8701300	13	128	65	14	
OSG-42-8691310	13,1	134	66	14	
OSG-42-8691320	13,2	134	66	14	
OSG-42-8691330	13,3	134	67	14	
OSG-42-8691340	13,4	134	67	14	
OSG-42-8691350	13,5	134	68	14	
OSG-42-8691360	13,6	134	68	14	
OSG-42-8691370	13,7	134	69	14	
OSG-42-8691380	13,8	134	69	14	
OSG-42-8691390	13,9	134	70	14	
OSG-42-8691400	14	134	70	14	
OSG-42-8701410	14,1	140	71	16	
OSG-42-8701420	14,2	140	71	16	
OSG-42-8701430	14,3	140	72	16	
OSG-42-8701440	14,4	140	72	16	
OSG-42-8701450	14,5	140	73	16	
OSG-42-8701460	14,6	140	73	16	
OSG-42-8701470	14,7	140	74	16	
OSG-42-8701480	14,8	140	74	16	
OSG-42-8701490	14,9	140	75	16	
OSG-42-8701500	15	140	75	16	
OSG-42-8691510	15,1	145	76	16	
OSG-42-8691520	15,2	145	76	16	
OSG-42-8691530	15,3	145	77	16	
OSG-42-8691540	15,4	145	77	16	
OSG-42-8691550	15,5	145	78	16	
OSG-42-8691560	15,6	145	78	16	
OSG-42-8691570	15,7	145	79	16	
OSG-42-8691580	15,8	145	79	16	
OSG-42-8691590	15,9	145	80	16	
OSG-42-8691600	16	145	80	16	
OSG-42-8701650	16,5	150	83	18	
OSG-42-8701700	17	150	85	18	
OSG-42-8691750	17,5	155	88	18	
OSG-42-8691800	18	155	90	18	
OSG-42-8701850	18,5	160	93	20	



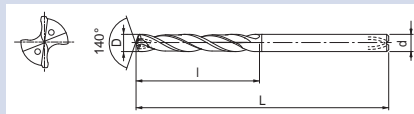
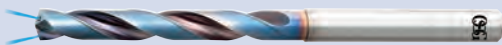
EDP	D	L	I	d	Price
OSG-42-8701900	19	160	95	20	
OSG-42-8691950	19,5	165	98	20	

EDP	D	L	I	d	Price
OSG-42-8692000	20	165	100	20	

Available on request

ADO-5D

Drilling | Solid carbide | 5xD



- First choice in quality and performance
- Carbide drill with internal coolant, EgiAs coating
- Up to 5xD
- For general purpose steels and cast iron

P	P	P	P	M	K	K	N	S	H	H
C ≤ 0,2%	C 0,25-0,4%	C ≥ 0,45%	SCM	INOX	GG	GGG	AC/ADC	Ti	25-35 HRC	35-45 HRC

A	CARBIDE	EgiAs	30°	SHRINK	FIT	140°	h8
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EDP	D	L	I	d	Price
OSG-42-8692200	2	70	18	3	
OSG-42-8692210	2,1	70	19	3	
OSG-42-8692220	2,2	70	20	3	
OSG-42-8692230	2,3	70	21	3	
OSG-42-8692240	2,4	70	22	3	
OSG-42-8692250	2,5	70	23	3	
OSG-42-8692260	2,6	78	24	3	
OSG-42-8692265	2,65	78	24	3	
OSG-42-8692270	2,7	78	25	3	
OSG-42-8692276	2,76	78	25	3	
OSG-42-8692278	2,78	78	26	3	
OSG-42-8692280	2,8	78	26	3	
OSG-42-8692290	2,9	78	27	3	
OSG-42-8692300	3	78	27	3	
OSG-42-8692310	3,1	86	28	4	
OSG-42-8692315	3,15	86	29	4	
OSG-42-8692320	3,2	86	29	4	
OSG-42-8692330	3,3	86	30	4	
OSG-42-8692340	3,4	86	31	4	
OSG-42-8692350	3,5	86	32	4	
OSG-42-8692360	3,6	86	33	4	
OSG-42-8692366	3,66	86	33	4	
OSG-42-8692368	3,68	86	34	4	
OSG-42-8692370	3,7	86	34	4	
OSG-42-8692375	3,75	86	34	4	
OSG-42-8692380	3,8	86	35	4	
OSG-42-8692390	3,9	86	36	4	
OSG-42-8692400	4	86	36	4	
OSG-42-8692410	4,1	95	37	5	
OSG-42-8702410	4,1	95	37	6	
OSG-42-8692420	4,2	95	38	5	
OSG-42-8702420	4,2	95	38	6	
OSG-42-8692430	4,3	95	39	5	
OSG-42-8702430	4,3	95	39	6	
OSG-42-8692440	4,4	95	40	5	
OSG-42-8702440	4,4	95	40	6	
OSG-42-8692450	4,5	95	41	5	
OSG-42-8702450	4,5	95	41	6	
OSG-42-8692460	4,6	95	42	5	
OSG-42-8702460	4,6	95	42	6	
OSG-42-8692462	4,62	95	42	5	
OSG-42-8692464	4,64	95	42	5	
OSG-42-8692470	4,7	95	43	5	
OSG-42-8702470	4,7	95	43	6	
OSG-42-8692480	4,8	95	44	5	
OSG-42-8702480	4,8	95	44	6	
OSG-42-8692490	4,9	95	45	5	
OSG-42-8702490	4,9	95	45	6	
OSG-42-8692500	5	95	45	5	
OSG-42-8702500	5	95	45	6	
OSG-42-8692510	5,1	100	41	6	
OSG-42-8692520	5,2	100	42	6	
OSG-42-8692525	5,25	100	42	6	
OSG-42-8692530	5,3	100	43	6	

EDP	D	L	I	d	Price
OSG-42-8692540	5,4	100	44	6	
OSG-42-8692550	5,5	100	44	6	
OSG-42-8692552	5,52	100	45	6	
OSG-42-8692554	5,54	100	45	6	
OSG-42-8692560	5,6	100	45	6	
OSG-42-8692570	5,7	100	46	6	
OSG-42-8692580	5,8	100	47	6	
OSG-42-8692590	5,9	100	48	6	
OSG-42-8692600	6	100	48	6	
OSG-42-8702610	6,1	109	49	8	
OSG-42-8702620	6,2	109	50	8	
OSG-42-8702630	6,3	109	51	8	
OSG-42-8702640	6,4	109	52	8	
OSG-42-8702650	6,5	109	52	8	
OSG-42-8702660	6,6	109	53	8	
OSG-42-8702670	6,7	109	54	8	
OSG-42-8702680	6,8	109	55	8	
OSG-42-8702690	6,9	109	56	8	
OSG-42-8702700	7	109	56	8	
OSG-42-8692710	7,1	118	57	8	
OSG-42-8692720	7,2	118	58	8	
OSG-42-8692725	7,25	118	58	8	
OSG-42-8692730	7,3	118	59	8	
OSG-42-8692736	7,36	118	59	8	
OSG-42-8692738	7,38	118	60	8	
OSG-42-8692740	7,4	118	60	8	
OSG-42-8692750	7,5	118	60	8	
OSG-42-8692752	7,52	118	61	8	
OSG-42-8692754	7,54	118	61	8	
OSG-42-8692760	7,6	118	61	8	
OSG-42-8692770	7,7	118	62	8	
OSG-42-8692775	7,75	118	62	8	
OSG-42-8692780	7,8	118	63	8	
OSG-42-8692790	7,9	118	64	8	
OSG-42-8692800	8	118	64	8	
OSG-42-8702810	8,1	128	65	10	
OSG-42-8702820	8,2	128	66	10	
OSG-42-8702830	8,3	128	67	10	
OSG-42-8702840	8,4	128	68	10	
OSG-42-8702850	8,5	128	68	10	
OSG-42-8702860	8,6	128	69	10	
OSG-42-8702870	8,7	128	70	10	
OSG-42-8702880	8,8	128	71	10	
OSG-42-8702890	8,9	128	72	10	
OSG-42-8702900	9	128	72	10	
OSG-42-8692910	9,1	136	73	10	
OSG-42-8692920	9,2	136	74	10	
OSG-42-8692924	9,24	136	74	10	
OSG-42-8692925	9,25	136	74	10	
OSG-42-8692926	9,26	136	75	10	
OSG-42-8692930	9,3	136	75	10	
OSG-42-8692936	9,36	136	75	10	
OSG-42-8692938	9,38	136	76	10	
OSG-42-8692940	9,4	136	76	10	



EDP	D	L	I	d	Price
OSG-42-8692950	9,5	136	76	10	
OSG-42-8692952	9,52	136	77	10	
OSG-42-8692954	9,54	136	77	10	
OSG-42-8692960	9,6	136	77	10	
OSG-42-8692970	9,7	136	78	10	
OSG-42-8692975	9,75	136	78	10	
OSG-42-8692980	9,8	136	79	10	
OSG-42-8692990	9,9	136	80	10	
OSG-42-8693000	10	136	80	10	
OSG-42-8703010	10,1	146	81	12	
OSG-42-8703020	10,2	146	82	12	
OSG-42-8703030	10,3	146	83	12	
OSG-42-8703040	10,4	146	84	12	
OSG-42-8703050	10,5	146	84	12	
OSG-42-8703060	10,6	146	85	12	
OSG-42-8703070	10,7	146	86	12	
OSG-42-8703080	10,8	146	87	12	
OSG-42-8703090	10,9	146	88	12	
OSG-42-8703100	11	146	88	12	
OSG-42-8693110	11,1	156	89	12	
OSG-42-8693120	11,2	156	90	12	
OSG-42-8693122	11,22	156	90	12	
OSG-42-8693124	11,24	156	90	12	
OSG-42-8693130	11,3	156	91	12	
OSG-42-8693136	11,36	156	91	12	
OSG-42-8693138	11,38	156	92	12	
OSG-42-8693140	11,4	156	92	12	
OSG-42-8693150	11,5	156	92	12	
OSG-42-8693160	11,6	156	93	12	
OSG-42-8693170	11,7	156	94	12	
OSG-42-8693180	11,8	156	95	12	
OSG-42-8693190	11,9	156	96	12	
OSG-42-8693200	12	156	96	12	
OSG-42-8703210	12,1	167	97	14	
OSG-42-8703220	12,2	167	98	14	
OSG-42-8703230	12,3	167	99	14	
OSG-42-8703240	12,4	167	100	14	
OSG-42-8703250	12,5	167	100	14	
OSG-42-8703260	12,6	167	101	14	
OSG-42-8703270	12,7	167	102	14	
OSG-42-8703280	12,8	167	103	14	
OSG-42-8703290	12,9	167	104	14	

EDP	D	L	I	d	Price
OSG-42-8703300	13	167	104	14	
OSG-42-8693310	13,1	176	105	14	
OSG-42-8693320	13,2	176	106	14	
OSG-42-8693325	13,25	176	106	14	
OSG-42-8693330	13,3	176	107	14	
OSG-42-8693340	13,4	176	108	14	
OSG-42-8693350	13,5	176	108	14	
OSG-42-8693360	13,6	176	109	14	
OSG-42-8693370	13,7	176	110	14	
OSG-42-8693380	13,8	176	111	14	
OSG-42-8693390	13,9	176	112	14	
OSG-42-8693400	14	176	112	14	
OSG-42-8703410	14,1	185	113	16	
OSG-42-8703420	14,2	185	114	16	
OSG-42-8703430	14,3	185	115	16	
OSG-42-8703440	14,4	185	116	16	
OSG-42-8703450	14,5	185	116	16	
OSG-42-8703460	14,6	185	117	16	
OSG-42-8703470	14,7	185	118	16	
OSG-42-8703480	14,8	185	119	16	
OSG-42-8703490	14,9	185	120	16	
OSG-42-8703500	15	185	120	16	
OSG-42-8693510	15,1	193	121	16	
OSG-42-8693520	15,2	193	122	16	
OSG-42-8693525	15,25	193	122	16	
OSG-42-8693530	15,3	193	123	16	
OSG-42-8693540	15,4	193	124	16	
OSG-42-8693550	15,5	193	124	16	
OSG-42-8693560	15,6	193	125	16	
OSG-42-8693570	15,7	193	126	16	
OSG-42-8693580	15,8	193	127	16	
OSG-42-8693590	15,9	193	128	16	
OSG-42-8693600	16	193	128	16	
OSG-42-8703650	16,5	201	132	18	
OSG-42-8703700	17	201	136	18	
OSG-42-8693750	17,5	209	140	18	
OSG-42-8693800	18	209	144	18	
OSG-42-8703850	18,5	217	148	20	
OSG-42-8703900	19	217	152	20	
OSG-42-8693950	19,5	225	156	20	
OSG-42-8694000	20	225	160	20	

Available on request

ADO-10D

Drilling | Solid carbide | 10xD

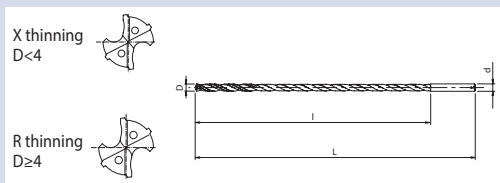


- First choice in quality and performance
- Carbide drill with internal coolant, EgiAs coating
- Double margin, up to 10xD
- For general purpose steels and cast iron

P	P	P	P	M	K	K	H
C: ≤0,2%	C: 0,25-0,4%	C: ≥0,45%	SCM	INOX	GG	GGG	25-35 HRC

A	CARBIDE	EgiAs	30°	SHRINK	FIT	140°	e8
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EDP	D	L	I	d	Price
OSG-42-8696200	2	75	26	3	
OSG-42-8696210	2,1	75	33	3	
OSG-42-8696220	2,2	75	33	3	
OSG-42-8696230	2,3	75	33	3	
OSG-42-8696240	2,4	75	33	3	
OSG-42-8696250	2,5	75	33	3	
OSG-42-8696260	2,6	90	40	3	
OSG-42-8696270	2,7	90	40	3	
OSG-42-8696280	2,8	90	40	3	
OSG-42-8696290	2,9	90	40	3	
OSG-42-8696300	3	90	40	3	
OSG-42-8696310	3,1	100	45	4	
OSG-42-8696320	3,2	100	45	4	
OSG-42-8696330	3,3	100	45	4	
OSG-42-8696340	3,4	100	50	4	



EDP	D	L	I	d	Price
OSG-42-8696350	3,5	100	50	4	
OSG-42-8696360	3,6	100	50	4	
OSG-42-8696370	3,7	100	50	4	
OSG-42-8696380	3,8	100	50	4	
OSG-42-8696390	3,9	100	50	4	
OSG-42-8696400	4	100	50	4	
OSG-42-8710410	4,1	115	55	6	
OSG-42-8710420	4,2	115	55	6	
OSG-42-8710430	4,3	115	60	6	
OSG-42-8710440	4,4	115	60	6	
OSG-42-8710450	4,5	115	60	6	
OSG-42-8710460	4,6	115	60	6	
OSG-42-8710470	4,7	115	65	6	
OSG-42-8710480	4,8	115	65	6	
OSG-42-8710490	4,9	115	65	6	



EDP	D	L	I	d	Price
OSG-42-8710500	5	115	65	6	
OSG-42-8710510	5,1	128	70	6	
OSG-42-8710520	5,2	128	70	6	
OSG-42-8710530	5,3	128	70	6	
OSG-42-8710540	5,4	128	78	6	
OSG-42-8696550	5,5	128	78	6	
OSG-42-8710560	5,6	128	78	6	
OSG-42-8710570	5,7	128	78	6	
OSG-42-8710580	5,8	128	78	6	
OSG-42-8710590	5,9	128	78	6	
OSG-42-8696600	6	128	78	6	
OSG-42-8710610	6,1	140	87	8	
OSG-42-8710620	6,2	140	87	8	
OSG-42-8710630	6,3	140	87	8	
OSG-42-8710640	6,4	140	87	8	
OSG-42-8710650	6,5	140	87	8	
OSG-42-8710660	6,6	140	87	8	
OSG-42-8710670	6,7	140	87	8	
OSG-42-8710680	6,8	140	90	8	
OSG-42-8710690	6,9	140	90	8	
OSG-42-8710700	7	140	90	8	
OSG-42-8710710	7,1	155	100	8	
OSG-42-8710720	7,2	155	100	8	
OSG-42-8710730	7,3	155	100	8	
OSG-42-8710740	7,4	155	100	8	
OSG-42-8696750	7,5	155	100	8	
OSG-42-8710760	7,6	155	105	8	
OSG-42-8710770	7,7	155	105	8	
OSG-42-8710780	7,8	155	105	8	
OSG-42-8710790	7,9	155	105	8	
OSG-42-8696800	8	155	105	8	
OSG-42-8710810	8,1	165	110	10	
OSG-42-8710820	8,2	165	110	10	
OSG-42-8710830	8,3	165	110	10	
OSG-42-8710840	8,4	165	110	10	
OSG-42-8710850	8,5	165	110	10	

EDP	D	L	I	d	Price
OSG-42-8710860	8,6	165	115	10	
OSG-42-8710870	8,7	165	115	10	
OSG-42-8710880	8,8	165	115	10	
OSG-42-8710890	8,9	165	115	10	
OSG-42-8710900	9	165	115	10	
OSG-42-8710910	9,1	190	125	10	
OSG-42-8710920	9,2	190	125	10	
OSG-42-8710930	9,3	190	125	10	
OSG-42-8710940	9,4	190	125	10	
OSG-42-8696950	9,5	190	125	10	
OSG-42-8710960	9,6	190	130	10	
OSG-42-8710970	9,7	190	130	10	
OSG-42-8710980	9,8	190	130	10	
OSG-42-8710990	9,9	190	130	10	
OSG-42-8697000	10	190	130	10	
OSG-42-8711010	10,1	205	140	12	
OSG-42-8711020	10,2	205	140	12	
OSG-42-8711030	10,3	205	140	12	
OSG-42-8711040	10,4	205	140	12	
OSG-42-8711050	10,5	205	140	12	
OSG-42-8711060	10,6	205	140	12	
OSG-42-8711070	10,7	205	140	12	
OSG-42-8711080	10,8	205	145	12	
OSG-42-8711090	10,9	205	145	12	
OSG-42-8711100	11	205	145	12	
OSG-42-8711110	11,1	215	155	12	
OSG-42-8711120	11,2	215	155	12	
OSG-42-8711130	11,3	215	155	12	
OSG-42-8711140	11,4	215	155	12	
OSG-42-8711150	11,5	215	155	12	
OSG-42-8711160	11,6	215	155	12	
OSG-42-8711170	11,7	215	155	12	
OSG-42-8711180	11,8	215	155	12	
OSG-42-8711190	11,9	215	155	12	
OSG-42-8697200	12	215	155	12	
OSG-42-8711250	12,5	215	155	14	

Available on request

ADO-15D

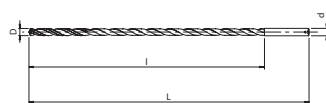
Drilling | Solid carbide | 15xD



- First choice in quality and performance
- Carbide drill with internal coolant, EgiAs coating
- Double margin, up to 15xD
- For general purpose steels and cast iron

P	P	P	P	M	K	K	H
C: ≤0,2%	C: 0,25-0,4%	C: ≥0,45%	SCM	INOX	GG	GGG	25-35 HRC

A	CARBIDE	EgiAs	30°	SHRINK	FIT	140°	e8
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X thinning
D<4R thinning
D≥4

EDP	D	L	I	d	Price
OSG-42-48338125	2,5	96	45	3	
OSG-42-8698300	3	105	55	3	
OSG-42-8698310	3,1	125	60	4	
OSG-42-8698320	3,2	125	60	4	
OSG-42-8698330	3,3	125	60	4	
OSG-42-8698340	3,4	125	65	4	
OSG-42-8698350	3,5	125	65	4	
OSG-42-8698360	3,6	125	65	4	
OSG-42-8698370	3,7	125	65	4	
OSG-42-8698380	3,8	125	75	4	
OSG-42-8698390	3,9	125	75	4	
OSG-42-8698400	4	125	75	4	
OSG-42-8712410	4,1	140	75	6	
OSG-42-8712420	4,2	140	75	6	
OSG-42-8712430	4,3	140	85	6	
OSG-42-8712440	4,4	140	85	6	
OSG-42-8712450	4,5	140	85	6	
OSG-42-8712460	4,6	140	85	6	
OSG-42-8712470	4,7	140	85	6	
OSG-42-8712480	4,8	140	90	6	
OSG-42-8712490	4,9	140	90	6	

EDP	D	L	I	d	Price
OSG-42-8712500	5	140	90	6	
OSG-42-8712510	5,1	160	95	6	
OSG-42-8712520	5,2	160	95	6	
OSG-42-8712530	5,3	160	95	6	
OSG-42-8712540	5,4	160	110	6	
OSG-42-8698550	5,5	160	110	6	
OSG-42-8712560	5,6	160	110	6	
OSG-42-8712570	5,7	160	110	6	
OSG-42-8712580	5,8	160	110	6	
OSG-42-8712590	5,9	160	110	6	
OSG-42-8698600	6	160	110	6	
OSG-42-8712610	6,1	175	120	8	
OSG-42-8712620	6,2	175	120	8	
OSG-42-8712630	6,3	175	120	8	
OSG-42-8712640	6,4	175	120	8	
OSG-42-8712650	6,5	175	120	8	
OSG-42-8712660	6,6	175	120	8	
OSG-42-8712670	6,7	175	120	8	
OSG-42-8712680	6,8	175	125	8	
OSG-42-8712690	6,9	175	125	8	
OSG-42-8712700	7	175	125	8	



EDP	D	L	I	d	Price
OSG-42-8712710	7,1	195	135	8	
OSG-42-8712720	7,2	195	135	8	
OSG-42-8712730	7,3	195	135	8	
OSG-42-8712740	7,4	195	135	8	
OSG-42-8698750	7,5	195	135	8	
OSG-42-8712760	7,6	195	145	8	
OSG-42-8712770	7,7	195	145	8	
OSG-42-8712780	7,8	195	145	8	
OSG-42-8712790	7,9	195	145	8	
OSG-42-8698800	8	195	145	8	
OSG-42-8712810	8,1	210	155	10	
OSG-42-8712820	8,2	210	155	10	
OSG-42-8712830	8,3	210	155	10	
OSG-42-8712840	8,4	210	155	10	
OSG-42-8712850	8,5	210	155	10	
OSG-42-8712860	8,6	210	160	10	
OSG-42-8712870	8,7	210	160	10	
OSG-42-8712880	8,8	210	160	10	
OSG-42-8712890	8,9	210	160	10	
OSG-42-8712900	9	210	160	10	
OSG-42-8712910	9,1	240	170	10	
OSG-42-8712920	9,2	240	170	10	
OSG-42-8712930	9,3	240	170	10	
OSG-42-8712940	9,4	240	170	10	
OSG-42-8698950	9,5	240	170	10	
OSG-42-8712960	9,6	240	180	10	

EDP	D	L	I	d	Price
OSG-42-8712970	9,7	240	180	10	
OSG-42-8712980	9,8	240	180	10	
OSG-42-8712990	9,9	240	180	10	
OSG-42-8699000	10	240	180	10	
OSG-42-8713010	10,1	260	190	12	
OSG-42-8713020	10,2	260	190	12	
OSG-42-8713030	10,3	260	190	12	
OSG-42-8713040	10,4	260	190	12	
OSG-42-8713050	10,5	260	190	12	
OSG-42-8713060	10,6	260	190	12	
OSG-42-8713070	10,7	260	200	12	
OSG-42-8713080	10,8	260	200	12	
OSG-42-8713090	10,9	260	200	12	
OSG-42-8713100	11	260	200	12	
OSG-42-8713110	11,1	280	210	12	
OSG-42-8713120	11,2	280	210	12	
OSG-42-8713130	11,3	280	210	12	
OSG-42-8713140	11,4	280	210	12	
OSG-42-8713150	11,5	280	210	12	
OSG-42-8713160	11,6	280	210	12	
OSG-42-8713170	11,7	280	210	12	
OSG-42-8713180	11,8	280	210	12	
OSG-42-8713190	11,9	280	215	12	
OSG-42-8699200	12	280	215	12	
OSG-42-8713250	12,5	290	252	14	

Available on request

ADO-20D

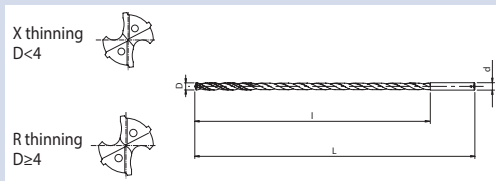
Drilling | Solid carbide | 20xD



- First choice in quality and performance
- Carbide drill with internal coolant, EgiAs coating
- Double margin, up to 20xD
- For general purpose steels and cast iron

P	P	P	P	M	K	K	H
C ≤0,2%	C 0,25-0,4%	C ≥0,45%	SCM	INOX	GG	GGG	25-35 HRC

A	CARBIDE	EgiAs	30°	SHRINK FIT	140°	e8
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EDP	D	L	I	d	Price
OSG-42-48338225	2,5	109	58	3	
OSG-42-8706300	3	120	70	3	
OSG-42-8706310	3,1	140	80	4	
OSG-42-8706320	3,2	140	80	4	
OSG-42-8706330	3,3	140	80	4	
OSG-42-8706340	3,4	140	85	4	
OSG-42-8706350	3,5	140	85	4	
OSG-42-8706360	3,6	140	85	4	
OSG-42-8706370	3,7	140	85	4	
OSG-42-8706380	3,8	140	90	4	
OSG-42-8706390	3,9	140	90	4	
OSG-42-8706400	4	140	90	4	
OSG-42-8714410	4,1	165	100	6	
OSG-42-8714420	4,2	165	100	6	
OSG-42-8714430	4,3	165	110	6	
OSG-42-8714440	4,4	165	110	6	
OSG-42-8714450	4,5	165	110	6	
OSG-42-8714460	4,6	165	110	6	
OSG-42-8714470	4,7	165	110	6	
OSG-42-8714480	4,8	165	115	6	
OSG-42-8714490	4,9	165	115	6	
OSG-42-8714500	5	165	115	6	
OSG-42-8714510	5,1	190	120	6	
OSG-42-8714520	5,2	190	120	6	
OSG-42-8714530	5,3	190	120	6	
OSG-42-8714540	5,4	190	140	6	
OSG-42-8706550	5,5	190	140	6	
OSG-42-8714560	5,6	190	140	6	
OSG-42-8714570	5,7	190	140	6	
OSG-42-8714580	5,8	190	140	6	
OSG-42-8714590	5,9	190	140	6	

EDP	D	L	I	d	Price
OSG-42-8706600	6	190	140	6	
OSG-42-8714610	6,1	210	155	8	
OSG-42-8714620	6,2	210	155	8	
OSG-42-8714630	6,3	210	155	8	
OSG-42-8714640	6,4	210	155	8	
OSG-42-8714650	6,5	210	155	8	
OSG-42-8714660	6,6	210	155	8	
OSG-42-8714670	6,7	210	155	8	
OSG-42-8714680	6,8	210	160	8	
OSG-42-8714690	6,9	210	160	8	
OSG-42-8714700	7	210	160	8	
OSG-42-8714710	7,1	230	170	8	
OSG-42-8714720	7,2	230	170	8	
OSG-42-8714730	7,3	230	170	8	
OSG-42-8714740	7,4	230	170	8	
OSG-42-8706750	7,5	230	170	8	
OSG-42-8714760	7,6	230	180	8	
OSG-42-8714770	7,7	230	180	8	
OSG-42-8714780	7,8	230	180	8	
OSG-42-8714790	7,9	230	180	8	
OSG-42-8706800	8	230	180	8	
OSG-42-8714810	8,1	260	195	10	
OSG-42-8714820	8,2	260	195	10	
OSG-42-8714830	8,3	260	195	10	
OSG-42-8714840	8,4	260	195	10	
OSG-42-8714850	8,5	260	195	10	
OSG-42-8714860	8,6	260	210	10	
OSG-42-8714870	8,7	260	210	10	
OSG-42-8714880	8,8	260	210	10	
OSG-42-8714890	8,9	260	210	10	
OSG-42-8714900	9	260	210	10	

EDP	D	L	I	d	Price
OSG-42-8714910	9,1	290	220	10	
OSG-42-8714920	9,2	290	220	10	
OSG-42-8714930	9,3	290	220	10	
OSG-42-8714940	9,4	290	220	10	
OSG-42-8706950	9,5	290	220	10	
OSG-42-8714960	9,6	290	230	10	
OSG-42-8714970	9,7	290	230	10	
OSG-42-8714980	9,8	290	230	10	
OSG-42-8714990	9,9	290	230	10	
OSG-42-8707000	10	290	230	10	
OSG-42-8715010	10,1	310	250	12	
OSG-42-8715020	10,2	310	250	12	
OSG-42-8715030	10,3	310	250	12	
OSG-42-8715040	10,4	310	250	12	
OSG-42-8715050	10,5	310	250	12	
OSG-42-8715060	10,6	310	250	12	

EDP	D	L	I	d	Price
OSG-42-8715070	10,7	310	250	12	
OSG-42-8715080	10,8	310	250	12	
OSG-42-8715090	10,9	310	250	12	
OSG-42-8715100	11	310	250	12	
OSG-42-8715110	11,1	330	270	12	
OSG-42-8715120	11,2	330	270	12	
OSG-42-8715130	11,3	330	270	12	
OSG-42-8715140	11,4	330	270	12	
OSG-42-8715150	11,5	330	270	12	
OSG-42-8715160	11,6	330	270	12	
OSG-42-8715170	11,7	330	270	12	
OSG-42-8715180	11,8	330	270	12	
OSG-42-8715190	11,9	330	270	12	
OSG-42-8707200	12	330	270	12	
OSG-42-8715250	12,5	330	280	14	

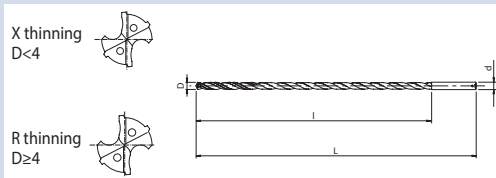
Available on request

ADO-25D

Drilling | Solid carbide | 25xD



- First choice in quality and performance
- Carbide drill with internal coolant, EgiAs coating
- Double margin, up to 25xD
- For general purpose steels and cast iron



EDP	D	L	I	d	Price
OSG-42-48338325	2,5	121	70	3	
OSG-42-8726300	3	135	85	3	
OSG-42-8724310	3,1	165	95	4	
OSG-42-8724320	3,2	165	95	4	
OSG-42-8724330	3,3	165	95	4	
OSG-42-8724340	3,4	165	105	4	
OSG-42-8724350	3,5	165	105	4	
OSG-42-8724360	3,6	165	105	4	
OSG-42-8724370	3,7	165	105	4	
OSG-42-8724380	3,8	165	115	4	
OSG-42-8724390	3,9	165	115	4	
OSG-42-8724400	4	165	115	4	
OSG-42-8724410	4,1	190	120	6	
OSG-42-8724420	4,2	190	120	6	
OSG-42-8724430	4,3	190	135	6	
OSG-42-8724440	4,4	190	135	6	
OSG-42-8724450	4,5	190	135	6	
OSG-42-8724460	4,6	190	135	6	
OSG-42-8724470	4,7	190	135	6	
OSG-42-8724480	4,8	190	140	6	
OSG-42-8724490	4,9	190	140	6	
OSG-42-8724500	5	190	140	6	
OSG-42-8724510	5,1	220	150	6	
OSG-42-8724520	5,2	220	150	6	
OSG-42-8724530	5,3	220	150	6	
OSG-42-8724540	5,4	220	170	6	
OSG-42-8724550	5,5	220	170	6	
OSG-42-8724560	5,6	220	170	6	
OSG-42-8724570	5,7	220	170	6	
OSG-42-8724580	5,8	220	170	6	
OSG-42-8724590	5,9	220	170	6	
OSG-42-8724600	6	220	170	6	
OSG-42-8724610	6,1	250	190	8	
OSG-42-8724620	6,2	250	190	8	
OSG-42-8724630	6,3	250	190	8	
OSG-42-8724640	6,4	250	190	8	
OSG-42-8724650	6,5	250	190	8	
OSG-42-8724660	6,6	250	190	8	
OSG-42-8724670	6,7	250	190	8	
OSG-42-8724680	6,8	250	200	8	
OSG-42-8724690	6,9	250	200	8	

EDP	D	L	I	d	Price
OSG-42-8724700	7	250	200	8	
OSG-42-8724710	7,1	275	210	8	
OSG-42-8724720	7,2	275	210	8	
OSG-42-8724730	7,3	275	210	8	
OSG-42-8724740	7,4	275	210	8	
OSG-42-8724750	7,5	275	210	8	
OSG-42-8724760	7,6	275	225	8	
OSG-42-8724770	7,7	275	225	8	
OSG-42-8724780	7,8	275	225	8	
OSG-42-8724790	7,9	275	225	8	
OSG-42-8724800	8	275	225	8	
OSG-42-8724810	8,1	305	240	10	
OSG-42-8724820	8,2	305	240	10	
OSG-42-8724830	8,3	305	240	10	
OSG-42-8724840	8,4	305	240	10	
OSG-42-8724850	8,5	305	240	10	
OSG-42-8724860	8,6	305	255	10	
OSG-42-8724870	8,7	305	255	10	
OSG-42-8724880	8,8	305	255	10	
OSG-42-8724890	8,9	305	255	10	
OSG-42-8724900	9	305	255	10	
OSG-42-8724910	9,1	340	270	10	
OSG-42-8724920	9,2	340	270	10	
OSG-42-8724930	9,3	340	270	10	
OSG-42-8724940	9,4	340	270	10	
OSG-42-8724950	9,5	340	270	10	
OSG-42-8724960	9,6	340	280	10	
OSG-42-8724970	9,7	340	280	10	
OSG-42-8724980	9,8	340	280	10	
OSG-42-8724990	9,9	340	280	10	
OSG-42-8725000	10	340	280	10	
OSG-42-8725010	10,1	370	310	12	
OSG-42-8725020	10,2	370	310	12	
OSG-42-8725030	10,3	370	310	12	
OSG-42-8725040	10,4	370	310	12	
OSG-42-8725050	10,5	370	310	12	
OSG-42-8725060	10,6	370	310	12	
OSG-42-8725070	10,7	370	310	12	
OSG-42-8725080	10,8	370	310	12	
OSG-42-8725090	10,9	370	310	12	
OSG-42-8725100	11	370	310	12	



EDP	D	L	I	d	Price
OSG-42-8725110	11,1	400	340	12	
OSG-42-8725120	11,2	400	340	12	
OSG-42-8725130	11,3	400	340	12	
OSG-42-8725140	11,4	400	340	12	
OSG-42-8725150	11,5	400	340	12	

EDP	D	L	I	d	Price
OSG-42-8725160	11,6	400	340	12	
OSG-42-8725170	11,7	400	340	12	
OSG-42-8725180	11,8	400	340	12	
OSG-42-8725190	11,9	400	340	12	
OSG-42-8725200	12	400	340	12	

Available on request

ADO-30D

Drilling | Solid carbide | 30xD



- First choice in quality and performance
- Carbide drill with internal coolant, EgiAs coating
- Double margin, up to 30xD
- For general purpose steels and cast iron

P	P	P	P	M	K	K	H
C: ≤0,2%	C: 0,25-0,4%	C: ≥0,45%	SCM	INOX	Gg	Ggg	25-35 HRC

A	CARBIDE	EgiAs	30°	SHRINK	FIT	140°	e8
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EDP	D	L	I	d	Price
OSG-42-48338425	2,5	134	83	3	
OSG-42-8708300	3	150	100	3	
OSG-42-8708310	3,1	185	102	4	
OSG-42-8708320	3,2	185	105	4	
OSG-42-8708330	3,3	185	109	4	
OSG-42-8708340	3,4	185	112	4	
OSG-42-8708350	3,5	185	116	4	
OSG-42-8708360	3,6	185	116	4	
OSG-42-8708370	3,7	185	116	4	
OSG-42-8708380	3,8	185	132	4	
OSG-42-8708390	3,9	185	132	4	
OSG-42-8708400	4	185	132	4	
OSG-42-8716410	4,1	215	140	6	
OSG-42-8716420	4,2	215	140	6	
OSG-42-8716430	4,3	215	150	6	
OSG-42-8716440	4,4	215	150	6	

EDP	D	L	I	d	Price
OSG-42-8716450	4,5	215	150	6	
OSG-42-8716460	4,6	215	150	6	
OSG-42-8716470	4,7	215	150	6	
OSG-42-8716480	4,8	215	165	6	
OSG-42-8716490	4,9	215	165	6	
OSG-42-8716500	5	215	165	6	
OSG-42-8716510	5,1	250	180	6	
OSG-42-8716520	5,2	250	180	6	
OSG-42-8716530	5,3	250	180	6	
OSG-42-8716540	5,4	250	200	6	
OSG-42-8708550	5,5	250	200	6	
OSG-42-8716560	5,6	250	200	6	
OSG-42-8716570	5,7	250	200	6	
OSG-42-8716580	5,8	250	200	6	
OSG-42-8716590	5,9	250	200	6	
OSG-42-8708600	6	250	200	6	



High Performance Drilling | Solid carbide

ADO-25D/30D

EDP	D	L	I	d	Price
OSG-42-8716610	6,1	280	215	8	
OSG-42-8716620	6,2	280	215	8	
OSG-42-8716630	6,3	280	215	8	
OSG-42-8716640	6,4	280	215	8	
OSG-42-8716650	6,5	280	215	8	
OSG-42-8716660	6,6	280	215	8	
OSG-42-8716670	6,7	280	215	8	
OSG-42-8716680	6,8	280	230	8	
OSG-42-8716690	6,9	280	230	8	
OSG-42-8716700	7	280	230	8	
OSG-42-8716710	7,1	315	250	8	
OSG-42-8716720	7,2	315	250	8	
OSG-42-8716730	7,3	315	250	8	
OSG-42-8716740	7,4	315	250	8	
OSG-42-8708750	7,5	315	250	8	
OSG-42-8716760	7,6	315	265	8	
OSG-42-8716770	7,7	315	265	8	
OSG-42-8716780	7,8	315	265	8	
OSG-42-8716790	7,9	315	265	8	
OSG-42-8708800	8	315	265	8	

EDP	D	L	I	d	Price
OSG-42-8716810	8,1	350	280	10	
OSG-42-8716820	8,2	350	280	10	
OSG-42-8716830	8,3	350	280	10	
OSG-42-8716840	8,4	350	280	10	
OSG-42-8716850	8,5	350	280	10	
OSG-42-8716860	8,6	350	300	10	
OSG-42-8716870	8,7	350	300	10	
OSG-42-8716880	8,8	350	300	10	
OSG-42-8716890	8,9	350	300	10	
OSG-42-8716900	9	350	300	10	
OSG-42-8716910	9,1	390	315	10	
OSG-42-8716920	9,2	390	315	10	
OSG-42-8716930	9,3	390	315	10	
OSG-42-8716940	9,4	390	315	10	
OSG-42-8708950	9,5	390	315	10	
OSG-42-8716960	9,6	390	330	10	
OSG-42-8716970	9,7	390	330	10	
OSG-42-8716980	9,8	390	330	10	
OSG-42-8716990	9,9	390	330	10	
OSG-42-8709000	10	390	330	10	

Available on request

ADO-40D

Drilling | Solid carbide | 40xD



- First choice in quality and performance
- 2 flute carbide drill with internal coolant, EgiAs coating
- Up to 40xD

P	P	P	P	M	K	K	H
C: ≤0,2%	C: 0,25-0,4%	C: ≥0,45%	SCM	INOX	GG	GGG	25-35 HRC

A	CARBIDE	EgiAs	±25°	e8	SHRINK FIT	
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EDP	D	L	L1	I	PL	L1	d	Price
OSG-42-8717300	3	179	129	120	0,5	49	3	
OSG-42-8717400	4	222	172	160	0,7	49	4	
OSG-42-8717500	5	265	215	200	0,9	49	5	
OSG-42-8717600	6	308	258	240	1,1	49	6	
OSG-42-8717800	8	394	344	320	1,5	49	8	
OSG-42-8718000	10	490	430	400	1,8	59	10	

Available on request

ADO-50D

Drilling | Solid carbide | 50xD



- First choice in quality and performance
- 2 flute carbide drill with internal coolant, EgiAs coating
- Up to 50xD

P	P	P	P	M	K	K	H
C: ≤0,2%	C: 0,25-0,4%	C: ≥0,45%	SCM	INOX	GG	GGG	25-35 HRC

A	CARBIDE	EgiAs	±25°	e8	SHRINK FIT	
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EDP	D	L	L1	I	PL	L1	d	Price
OSG-42-8718300	3	209	159	150	0,5	49	3	
OSG-42-8718400	4	262	212	200	0,7	49	4	
OSG-42-8718500	5	315	265	250	0,9	49	5	
OSG-42-8718600	6	368	318	300	1,1	49	6	
OSG-42-8718800	8	474	424	400	1,5	49	8	

Available on request

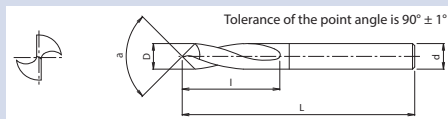


AD-LDS

Drilling | Solid carbide | Centering



- First choice in quality and performance
- Carbide drill with EgiAs coating
- Carbide starter drill



EDP	D	α	L	I	d	Min. Drill Hole Size*	Price
OSG-42-8688951	3	60	48	9	3	1,2	
OSG-42-8688952	4	60	54	12	4	1,5	
OSG-42-8688953	6	60	72	15	6	1,9	
OSG-42-8688954	8	60	81	20	8	2,1	
OSG-42-8688955	10	60	93	24	10	2,5	
OSG-42-8688956	12	60	108	28	12	2,5	
OSG-42-8688930	0,5	90	38	1	3	0,25	
OSG-42-8688931	1	90	38	1,8	3	0,4	
OSG-42-8688932	2	90	38	2,5	3	1	
OSG-42-8688933	3	90	48	9	3	1,2	
OSG-42-8688934	4	90	54	12	4	1,5	
OSG-42-8688935	6	90	72	15	6	1,9	
OSG-42-8688936	8	90	81	20	8	2,1	
OSG-42-8688937	10	90	93	24	10	2,5	
OSG-42-8688938	12	90	108	28	12	2,5	
OSG-42-8688957	3	120	48	9	3	-	
OSG-42-8688958	4	120	54	12	4	-	
OSG-42-8688959	6	120	72	15	6	-	
OSG-42-8688960	8	120	81	20	8	-	
OSG-42-8688961	10	120	93	24	10	-	
OSG-42-8688962	12	120	108	28	12	-	
OSG-42-8688963	0,5	140	38	1	3	-	
OSG-42-8688964	1	140	38	1,8	3	-	
OSG-42-8688965	2	140	38	2,5	3	-	
OSG-42-8688966	3	140	48	9	3	-	
OSG-42-8688967	4	140	54	12	4	-	
OSG-42-8688968	6	140	72	15	6	-	
OSG-42-8688969	8	140	81	20	8	-	
OSG-42-8688970	10	140	93	24	10	-	
OSG-42-8688971	12	140	108	28	12	-	

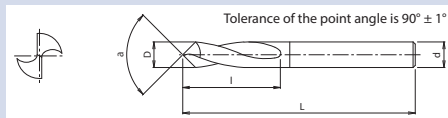
* These minimum drill hole sizes are used for chamfering operations.
Available on request

AD-LS-LDS

Drilling | Solid carbide | Centering



- First choice in quality and performance
- Carbide drill with EgiAs coating
- Carbide long shank starter drill



EDP	D	α	L	I	d	Min. Drill Hole Size*	Price
OSG-42-8688942	3	90	75	9	3	1,2	

High Performance Drilling | Solid carbide

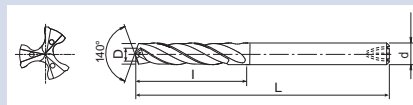
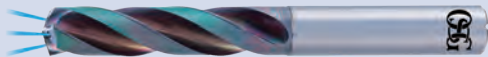
AD-LDS/AD-LS-LDS

EDP	D	α	L	l	d	Min. Drill Hole Size*	Price
OSG-42-8688943	4	90	100	12	4	1,5	
OSG-42-8688944	6	90	150	15	6	1,9	
OSG-42-8688945	8	90	150	20	8	2,1	
OSG-42-8688946	10	90	200	24	10	2,5	
OSG-42-8688947	12	90	200	28	12	2,5	

* These minimum drill hole sizes are used for chamfering operations.
Available on request

ADO-TRS-3D

Drilling | Solid carbide | 3xD



- First choice in quality and performance
- 3 flute carbide drill with internal coolant, EgiAs coating
- Up to 3xD
- Allows high feed 1.000mm/min process in steel and cast iron

P C: ≤0,2%	P C: 0,25-0,4%	P C: ≥0,45%	P SCM	M INOX	K Gg	K GGG	S Ti	H 25-35 HRC	H 35-45 HRC	H 45-52 HRC
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A	CARBIDE	EgiAs	30°	SHRINK	FIT	140°	h8
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EDP	D	L	l	d	Price
OSG-42-8720300	3	66	18	3	
OSG-42-8720330	3,3	74	20	4	
OSG-42-8720350	3,5	74	21	4	
OSG-42-8720366	3,66	74	22	4	
OSG-42-8720400	4	74	24	4	
OSG-42-8720420	4,2	80	26	6	
OSG-42-8720450	4,5	80	27	6	
OSG-42-8720460	4,6	80	28	6	
OSG-42-8720500	5	80	25	6	
OSG-42-8720510	5,1	82	26	6	
OSG-42-8720520	5,2	82	26	6	
OSG-42-8720530	5,3	82	27	6	
OSG-42-8720540	5,4	82	27	6	
OSG-42-8720550	5,5	82	28	6	
OSG-42-48323555	5,55	82	28	6	
OSG-42-8720560	5,6	82	28	6	
OSG-42-8720570	5,7	82	29	6	
OSG-42-8720580	5,8	82	29	6	
OSG-42-8720590	5,9	82	30	6	
OSG-42-8720600	6	82	30	6	
OSG-42-8720610	6,1	88	31	8	
OSG-42-8720620	6,2	88	31	8	
OSG-42-8720630	6,3	88	32	8	
OSG-42-8720640	6,4	88	32	8	
OSG-42-8720650	6,5	88	33	8	
OSG-42-8720660	6,6	88	33	8	
OSG-42-8720670	6,7	88	34	8	
OSG-42-8720680	6,8	88	34	8	
OSG-42-8720690	6,9	88	35	8	
OSG-42-8720700	7	88	35	8	
OSG-42-8720710	7,1	94	36	8	
OSG-42-8720720	7,2	94	36	8	
OSG-42-8720730	7,3	94	37	8	
OSG-42-8720738	7,38	94	37	8	
OSG-42-8720740	7,4	94	37	8	
OSG-42-48323745	7,45	94	38	8	
OSG-42-8720750	7,5	94	38	8	
OSG-42-8720760	7,6	94	38	8	
OSG-42-8720770	7,7	94	39	8	
OSG-42-8720780	7,8	94	39	8	
OSG-42-8720790	7,9	94	40	8	
OSG-42-8720800	8	94	40	8	
OSG-42-8720810	8,1	101	41	10	
OSG-42-8720820	8,2	101	41	10	
OSG-42-8720830	8,3	101	42	10	
OSG-42-8720840	8,4	101	42	10	
OSG-42-8720850	8,5	101	43	10	
OSG-42-8720860	8,6	101	43	10	
OSG-42-8720870	8,7	101	44	10	

EDP	D	L	l	d	Price
OSG-42-8720880	8,8	101	44	10	
OSG-42-8720890	8,9	101	45	10	
OSG-42-8720900	9	101	45	10	
OSG-42-8720910	9,1	106	46	10	
OSG-42-8720920	9,2	106	46	10	
OSG-42-8720925	9,25	106	47	10	
OSG-42-8720930	9,3	106	47	10	
OSG-42-8720938	9,38	106	47	10	
OSG-42-8720940	9,4	106	47	10	
OSG-42-8720950	9,5	106	48	10	
OSG-42-8720960	9,6	106	48	10	
OSG-42-8720970	9,7	106	49	10	
OSG-42-8720980	9,8	106	49	10	
OSG-42-8720990	9,9	106	50	10	
OSG-42-8721000	10	106	50	10	
OSG-42-8721010	10,1	113	51	12	
OSG-42-8721020	10,2	113	51	12	
OSG-42-8721030	10,3	113	52	12	
OSG-42-8721040	10,4	113	52	12	
OSG-42-8721050	10,5	113	53	12	
OSG-42-8721060	10,6	113	53	12	
OSG-42-8721070	10,7	113	54	12	
OSG-42-8721080	10,8	113	54	12	
OSG-42-8721090	10,9	113	55	12	
OSG-42-8721100	11	113	55	12	
OSG-42-8721110	11,1	120	56	12	
OSG-42-8721120	11,2	120	56	12	
OSG-42-8721125	11,25	120	57	12	
OSG-42-8721130	11,3	120	57	12	
OSG-42-8721138	11,38	120	57	12	
OSG-42-8721140	11,4	120	57	12	
OSG-42-8721150	11,5	120	58	12	
OSG-42-8721160	11,6	120	58	12	
OSG-42-8721170	11,7	120	59	12	
OSG-42-8721180	11,8	120	59	12	
OSG-42-8721190	11,9	120	60	12	
OSG-42-8721200	12	120	60	12	
OSG-42-8721250	12,5	128	63	14	
OSG-42-8721300	13	128	65	14	
OSG-42-8721325	13,25	134	67	14	
OSG-42-8721330	13,30	134	67	14	
OSG-42-8721338	13,38	134	67	14	
OSG-42-8721350	13,5	134	68	14	
OSG-42-8721400	14	134	70	14	
OSG-42-8721410	14,1	140	71	16	
OSG-42-8721420	14,2	140	71	16	
OSG-42-8721430	14,3	140	72	16	
OSG-42-8721450	14,5	140	73	16	
OSG-42-8721500	15	140	75	16	



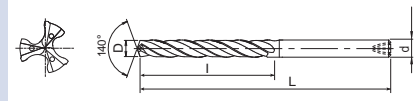
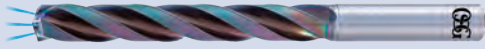
EDP	D	L	I	d	Price
OSG-42-8721520	15,2	145	76	16	
OSG-42-8721530	15,3	145	77	16	
OSG-42-8721550	15,5	145	78	16	
OSG-42-8721600	16	145	80	16	
OSG-42-8721650	16,5	150	83	18	
OSG-42-8721700	17	150	85	18	
OSG-42-8721725	17,25	155	87	18	

EDP	D	L	I	d	Price
OSG-42-8721750	17,5	155	88	18	
OSG-42-8721800	18	155	90	18	
OSG-42-8721850	18,5	160	93	20	
OSG-42-8721900	19	160	95	20	
OSG-42-8721925	19,25	165	97	20	
OSG-42-8721950	19,5	165	98	20	
OSG-42-8722000	20	165	100	20	

Available on request

ADO-TRS-5D

Drilling | Solid carbide | 5xD



- First choice in quality and performance
- 3 flute carbide drill with internal coolant, EgiAs coating
- Up to 5xD
- Allows high feed 1.000mm/min process in steel and cast iron

P	P	P	P	M	K	K	H
C: ≤0,2%	C: 0,25-0,4%	C: ≥0,45%	SCM	INOX	GG	GGG	25-35 HRC



EDP	D	L	I	d	Price
OSG-42-8722300	3	78	27	3	
OSG-42-8722330	3,3	86	30	4	
OSG-42-8722350	3,5	86	32	4	
OSG-42-8722366	3,66	86	33	4	
OSG-42-8722400	4	86	36	4	
OSG-42-8722420	4,2	95	38	6	
OSG-42-8722450	4,5	95	41	6	
OSG-42-8722460	4,6	95	42	6	
OSG-42-8722500	5	95	45	6	
OSG-42-8722510	5,1	100	41	6	
OSG-42-8722520	5,2	100	42	6	
OSG-42-8722530	5,3	100	43	6	
OSG-42-8722540	5,4	100	44	6	
OSG-42-8722550	5,5	100	44	6	
OSG-42-48324555	5,55	100	45	6	
OSG-42-8722560	5,6	100	45	6	
OSG-42-8722570	5,7	100	46	6	
OSG-42-8722580	5,8	100	47	6	
OSG-42-8722590	5,9	100	48	6	
OSG-42-8722600	6	100	48	6	
OSG-42-8722610	6,1	109	49	8	
OSG-42-8722620	6,2	109	50	8	
OSG-42-8722630	6,3	109	51	8	
OSG-42-8722640	6,4	109	52	8	
OSG-42-8722650	6,5	109	52	8	
OSG-42-8722660	6,6	109	53	8	
OSG-42-8722670	6,7	109	54	8	
OSG-42-8722680	6,8	109	55	8	
OSG-42-8722690	6,9	109	56	8	
OSG-42-8722700	7	109	56	8	
OSG-42-8722710	7,1	118	57	8	
OSG-42-8722720	7,2	118	58	8	
OSG-42-8722730	7,3	118	59	8	
OSG-42-8722738	7,38	118	60	8	
OSG-42-8722740	7,4	118	60	8	
OSG-42-48324745	7,45	118	60	8	
OSG-42-8722750	7,5	118	60	8	
OSG-42-8722760	7,6	118	61	8	
OSG-42-8722770	7,7	118	62	8	
OSG-42-8722780	7,8	118	63	8	
OSG-42-8722790	7,9	118	64	8	
OSG-42-8722800	8	118	64	8	
OSG-42-8722810	8,1	128	65	10	
OSG-42-8722820	8,2	128	66	10	
OSG-42-8722830	8,3	128	67	10	
OSG-42-8722840	8,4	128	68	10	
OSG-42-8722850	8,5	128	68	10	
OSG-42-8722860	8,6	128	69	10	
OSG-42-8722870	8,7	128	70	10	

EDP	D	L	I	d	Price
OSG-42-8722880	8,8	128	71	10	
OSG-42-8722890	8,9	128	72	10	
OSG-42-8722900	9	128	72	10	
OSG-42-8722910	9,1	136	73	10	
OSG-42-8722920	9,2	136	74	10	
OSG-42-8722925	9,25	136	74	10	
OSG-42-8722930	9,3	136	75	10	
OSG-42-8722938	9,38	136	76	10	
OSG-42-8722940	9,4	136	76	10	
OSG-42-8722950	9,5	136	76	10	
OSG-42-8722960	9,6	136	77	10	
OSG-42-8722970	9,7	136	78	10	
OSG-42-8722980	9,8	136	79	10	
OSG-42-8722990	9,9	136	80	10	
OSG-42-8723000	10	136	80	10	
OSG-42-8723010	10,1	146	81	12	
OSG-42-8723020	10,2	146	82	12	
OSG-42-8723030	10,3	146	83	12	
OSG-42-8723040	10,4	146	84	12	
OSG-42-8723050	10,5	146	84	12	
OSG-42-8723060	10,6	146	85	12	
OSG-42-8723070	10,7	146	86	12	
OSG-42-8723080	10,8	146	87	12	
OSG-42-8723090	10,9	146	88	12	
OSG-42-8723100	11	146	88	12	
OSG-42-8723110	11,1	156	89	12	
OSG-42-8723120	11,2	156	90	12	
OSG-42-8723125	11,25	156	90	12	
OSG-42-8723130	11,3	156	91	12	
OSG-42-8723138	11,38	156	92	12	
OSG-42-8723140	11,4	156	92	12	
OSG-42-8723150	11,5	156	92	12	
OSG-42-8723160	11,6	156	93	12	
OSG-42-8723170	11,7	156	94	12	
OSG-42-8723180	11,8	156	95	12	
OSG-42-8723190	11,9	156	96	12	
OSG-42-8723200	12	156	96	12	
OSG-42-8723250	12,5	167	100	14	
OSG-42-8723300	13	167	104	14	
OSG-42-8723325	13,25	176	106	14	
OSG-42-8723330	13,30	176	107	14	
OSG-42-8723338	13,38	176	108	14	
OSG-42-8723350	13,5	176	108	14	
OSG-42-8723400	14	176	112	14	
OSG-42-8723410	14,1	185	113	16	
OSG-42-8723420	14,2	185	114	16	
OSG-42-8723430	14,3	185	115	16	
OSG-42-8723450	14,5	185	116	16	
OSG-42-8723500	15	185	120	16	

High Performance Drilling | Solid carbide

ADO-TRS-3D/5D

EDP	D	L	I	d	Price
OSG-42-8723520	15,2	193	122	16	
OSG-42-8723530	15,3	193	123	16	
OSG-42-8723550	15,5	193	124	16	
OSG-42-8723600	16	193	128	16	
OSG-42-8723650	16,5	201	132	18	
OSG-42-8723700	17	201	136	18	
OSG-42-8723725	17,25	209	138	18	

EDP	D	L	I	d	Price
OSG-42-8723750	17,5	209	140	18	
OSG-42-8723800	18	209	144	18	
OSG-42-8723850	18,5	217	148	20	
OSG-42-8723900	19	217	152	20	
OSG-42-8723925	19,25	225	154	20	
OSG-42-8723950	19,5	225	156	20	
OSG-42-8724000	20	225	160	20	

Available on request

TRS-HO-10D

Drilling | Solid carbide | 10xD



- First choice in quality and performance
- 3 flute carbide drill with internal coolant, WDI coating
- Up to 10xD
- Allows high feed 1.000mm/min process in steel and cast iron



EDP	D	L	I	d	Price
OSG-42-48159050	5	115	65	6	
OSG-42-8664055	5,5	128	78	6	
OSG-42-8664060	6	128	78	6	
OSG-42-48159065	6,5	140	87	8	
OSG-42-48159070	7	140	90	8	
OSG-42-8664075	7,5	155	100	8	

EDP	D	L	I	d	Price
OSG-42-8664080	8	155	105	8	
OSG-42-48159085	8,5	165	110	10	
OSG-42-48159090	9	165	115	10	
OSG-42-8664100	10	190	130	10	
OSG-42-8664120	12	215	155	12	

Available on request

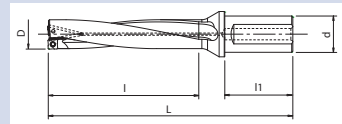


A-TAP SERIES page 273-296



P2D BODY

Drilling | Indexable | Body



- Indexable drill with internal coolant
- Up to 2xD
- 3 different insert grades available



EDP	Designation	D	Applicable inserts type	L	l	l1	d	Price
OSG-43-7803180	P2D1200FS20M03	12	XCMT03...	87	24	50	20	
OSG-43-7803181	P2D1250FS20M03	12,5	XCMT03...	88	25	50	20	
OSG-43-7803182	P2D1300FS20M03	13	XCMT03...	89	26	50	20	
OSG-43-7803183	P2D1350FS20M03	13,5	XCMT03...	90	27	50	20	
OSG-43-7803184	P2D1400FS20M03	14	XCMT03...	91	28	50	20	
OSG-43-7803185	P2D1450FS20M03	14,5	XCMT03...	92	29	50	20	
OSG-43-7803117	P2D1500FS20M04	15	XCMT04...	95	30	50	20	
OSG-43-7803118	P2D1550FS20M04	15,5	XCMT04...	96	31	50	20	
OSG-43-7803119	P2D1600FS20M04	16	XCMT04...	97	32	50	20	
OSG-43-7803120	P2D1650FS20M04	16,5	XCMT04...	98	33	50	20	
OSG-43-7803121	P2D1700FS20M05	17	XCMT05...	102	34	50	20	
OSG-43-7803122	P2D1750FS20M05	17,5	XCMT05...	103	35	50	20	
OSG-43-7803190	P2D1750FS25M05	17,5	XCMT05...	109	35	56	25	
OSG-43-7803123	P2D1800FS25M05	18	XCMT05...	110	36	56	25	
OSG-43-7803124	P2D1850FS25M05	18,5	XCMT05...	111	37	56	25	
OSG-43-7803125	P2D1900FS25M06	19	XCMT06...	112	38	56	25	
OSG-43-7803126	P2D1950FS25M06	19,5	XCMT06...	113	39	56	25	
OSG-43-7803127	P2D2000FS25M06	20	XCMT06...	114	40	56	25	
OSG-43-7803128	P2D2050FS25M06	20,5	XCMT06...	115	41	56	25	
OSG-43-7803129	P2D2100FS25M07	21	XCMT07...	121	42	56	25	
OSG-43-7803130	P2D2150FS25M07	21,5	XCMT07...	122	43	56	25	
OSG-43-7803131	P2D2200FS25M07	22	XCMT07...	123	44	56	25	
OSG-43-7803132	P2D2250FS25M07	22,5	XCMT07...	124	45	56	25	
OSG-43-7803133	P2D2300FS25M07	23	XCMT07...	125	46	56	25	
OSG-43-7803191	P2D2350FS25M07	23,5	XCMT07...	126	47	56	25	
OSG-43-7803134	P2D2350FS32M07	23,5	XCMT07...	130	47	60	32	
OSG-43-7803192	P2D2400FS25M07	24	XCMT07...	127	48	56	25	
OSG-43-7803135	P2D2400FS32M07	24	XCMT07...	131	48	60	32	
OSG-43-7803193	P2D2450FS25M07	24,5	XCMT07...	128	49	56	25	
OSG-43-7803136	P2D2450FS32M07	24,5	XCMT07...	132	49	60	32	
OSG-43-7803194	P2D2500FS25M08	25	XCMT08...	129	50	56	25	
OSG-43-7803137	P2D2500FS32M08	25	XCMT08...	133	50	60	32	
OSG-43-7803195	P2D2550FS25M08	25,5	XCMT08...	130	51	56	25	
OSG-43-7803138	P2D2550FS32M08	25,5	XCMT08...	134	51	60	32	
OSG-43-7803139	P2D2600FS32M08	26	XCMT08...	135	52	60	32	
OSG-43-7803140	P2D2650FS32M08	26,5	XCMT08...	136	53	60	32	
OSG-43-7803141	P2D2700FS32M08	27	XCMT08...	137	54	60	32	
OSG-43-7803142	P2D2800FS32M08	28	XCMT08...	139	56	60	32	
OSG-43-7803143	P2D2850FS32M08	28,5	XCMT08...	140	57	60	32	
OSG-43-7803144	P2D2900FS32M09	29	XCMT09...	141	58	60	32	
OSG-43-7803145	P2D3000FS32M09	30	XCMT09...	143	60	60	32	
OSG-43-7803146	P2D3100FS32M09	31	XCMT09...	145	62	60	32	
OSG-43-7803196	P2D3100FS40M09	31	XCMT09...	155	62	70	40	
OSG-43-7803147	P2D3200FS32M09	32	XCMT09...	147	64	60	32	
OSG-43-7803197	P2D3200FS40M09	32	XCMT09...	157	64	70	40	
OSG-43-7803148	P2D3300FS40M09	33	XCMT09...	159	66	70	40	
OSG-43-7803149	P2D3350FS40M09	33,5	XCMT09...	160	67	70	40	
OSG-43-7803150	P2D3400FS40M10	34	XCMT10...	161	68	70	40	
OSG-43-7803151	P2D3500FS40M10	35	XCMT10...	163	70	70	40	
OSG-43-7803152	P2D3600FS40M10	36	XCMT10...	165	72	70	40	
OSG-43-7803153	P2D3700FS40M10	37	XCMT10...	167	74	70	40	
OSG-43-7803154	P2D3800FS40M10	38	XCMT10...	169	76	70	40	
OSG-43-7803155	P2D3900FS40M12	39	XCMT12...	178	78	70	40	
OSG-43-7803156	P2D4000FS40M12	40	XCMT12...	180	80	70	40	
OSG-43-7803157	P2D4100FS40M12	41	XCMT12...	182	82	70	40	
OSG-43-7803158	P2D4200FS40M12	42	XCMT12...	184	84	70	40	
OSG-43-7803159	P2D4300FS40M12	43	XCMT12...	186	86	70	40	
OSG-43-7803160	P2D4400FS40M12	44	XCMT12...	188	88	70	40	
OSG-43-7803161	P2D4500FS40M13	45	XCMT13...	190	90	70	40	
OSG-43-7803162	P2D4600FS40M13	46	XCMT13...	192	92	70	40	
OSG-43-7803163	P2D4700FS40M13	47	XCMT13...	194	94	70	40	
OSG-43-7803164	P2D4800FS40M13	48	XCMT13...	196	96	70	40	

High Performance Drilling | Indexable

P2D BODY

EDP	Designation	D	Applicable inserts type	L	I	I1	d	Price
OSG-43-7803165	P2D4900F540M13	49	XCMT13...	198	98	70	40	
OSG-43-7803166	P2D5000F540M14	50	XCMT14...	200	100	70	40	
OSG-43-7803167	P2D5100F540M14	51	XCMT14...	202	102	70	40	
OSG-43-7803168	P2D5200F540M14	52	XCMT14...	204	104	70	40	
OSG-43-7803169	P2D5300F540M14	53	XCMT14...	206	106	70	40	
OSG-43-7803170	P2D5400F540M14	54	XCMT14...	208	108	70	40	
OSG-43-7803171	P2D5500F540M14	55	XCMT14...	210	110	70	40	
OSG-43-7803172	P2D5600F540M14	56	XCMT14...	212	112	70	40	
OSG-43-7803173	P2D5700F540M16	57	XCMT16...	214	114	70	40	
OSG-43-7803174	P2D5800F540M16	58	XCMT16...	216	116	70	40	
OSG-43-7803175	P2D5900F540M16	59	XCMT16...	218	118	70	40	
OSG-43-7803176	P2D6000F540M16	60	XCMT16...	220	120	70	40	
OSG-43-7803177	P2D6100F540M16	61	XCMT16...	222	122	70	40	
OSG-43-7803178	P2D6200F540M16	62	XCMT16...	224	124	70	40	
OSG-43-7803179	P2D6300F540M16	63	XCMT16...	226	126	70	40	

See Accessories & spare parts on page 124.

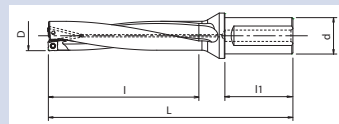
Available on request

P3D BODY

Drilling | Indexable | Body



- Indexable drill with internal coolant
- Up to 3xD
- 3 different insert grades available



EDP	Designation	D	Applicable inserts type	L	I	I1	d	Price
OSG-43-7803210	P3D1200FS20M03	12	XCMT03...	99	36	50	20	
OSG-43-7803211	P3D1250FS20M03	12,5	XCMT03...	100,5	37,5	50	20	
OSG-43-7803212	P3D1270FS20M03	12,7	XCMT03...	101,1	38,1	50	20	
OSG-43-7803213	P3D1300FS20M03	13	XCMT03...	102	39	50	20	
OSG-43-7803214	P3D1350FS20M03	13,5	XCMT03...	103,5	40,5	50	20	
OSG-43-7803215	P3D1400FS20M03	14	XCMT03...	105	42	50	20	
OSG-43-7803216	P3D1450FS20M03	14,5	XCMT03...	106,5	43,5	50	20	
OSG-43-7803217	P3D1500FS20M04	15	XCMT04...	110	45	50	20	
OSG-43-7803218	P3D1550FS20M04	15,5	XCMT04...	112	47	50	20	
OSG-43-7803219	P3D1600FS20M04	16	XCMT04...	113	48	50	20	
OSG-43-7803220	P3D1650FS20M04	16,5	XCMT04...	115	50	50	20	
OSG-43-7803221	P3D1700FS20M05	17	XCMT05...	119	51	50	20	
OSG-43-7803222	P3D1750FS20M05	17,5	XCMT05...	121	53	50	20	
OSG-43-7803290	P3D1750FS25M05	17,5	XCMT05...	127	53	56	25	
OSG-43-7803223	P3D1800FS25M05	18	XCMT05...	128	54	56	25	
OSG-43-7803224	P3D1850FS25M05	18,5	XCMT05...	130	56	56	25	
OSG-43-7803225	P3D1900FS25M06	19	XCMT06...	131	57	56	25	
OSG-43-7803226	P3D1950FS25M06	19,5	XCMT06...	133	59	56	25	
OSG-43-7803227	P3D2000FS25M06	20	XCMT06...	134	60	56	25	
OSG-43-7803228	P3D2050FS25M06	20,5	XCMT06...	136	62	56	25	
OSG-43-7803229	P3D2100FS25M07	21	XCMT07...	142	63	56	25	
OSG-43-7803230	P3D2150FS25M07	21,5	XCMT07...	144	65	56	25	
OSG-43-7803231	P3D2200FS25M07	22	XCMT07...	145	66	56	25	
OSG-43-7803232	P3D2250FS25M07	22,5	XCMT07...	147	68	56	25	
OSG-43-7803233	P3D2300FS25M07	23	XCMT07...	148	69	56	25	
OSG-43-7803291	P3D2350FS25M07	23,5	XCMT07...	150	71	56	25	
OSG-43-7803234	P3D2350FS32M07	23,5	XCMT07...	154	71	60	32	
OSG-43-7803292	P3D2400FS25M07	24	XCMT07...	151	72	56	25	
OSG-43-7803235	P3D2400FS32M07	24	XCMT07...	155	72	60	32	
OSG-43-7803293	P3D2450FS25M07	24,5	XCMT07...	153	74	56	25	
OSG-43-7803236	P3D2450FS32M07	24,5	XCMT07...	157	74	60	32	
OSG-43-7803294	P3D2500FS25M08	25	XCMT08...	154	75	56	25	
OSG-43-7803237	P3D2500FS32M08	25	XCMT08...	158	75	60	32	
OSG-43-7803295	P3D2550FS25M08	25,5	XCMT08...	156	77	56	25	
OSG-43-7803238	P3D2550FS32M08	25,5	XCMT08...	160	77	60	32	
OSG-43-7803239	P3D2600FS32M08	26	XCMT08...	161	78	60	32	
OSG-43-7803240	P3D2650FS32M08	26,5	XCMT08...	163	80	60	32	
OSG-43-7803241	P3D2700FS32M08	27	XCMT08...	164	81	60	32	
OSG-43-7803300	P3D2750FS32M08	27,5	XCMT08...	166	83	60	32	
OSG-43-7803242	P3D2800FS32M08	28	XCMT08...	167	84	60	32	
OSG-43-7803243	P3D2850FS32M08	28,5	XCMT08...	169	86	60	32	
OSG-43-7803244	P3D2900FS32M09	29	XCMT09...	170	87	60	32	
OSG-43-7803301	P3D2950FS32M09	29,5	XCMT09...	172	89	60	32	



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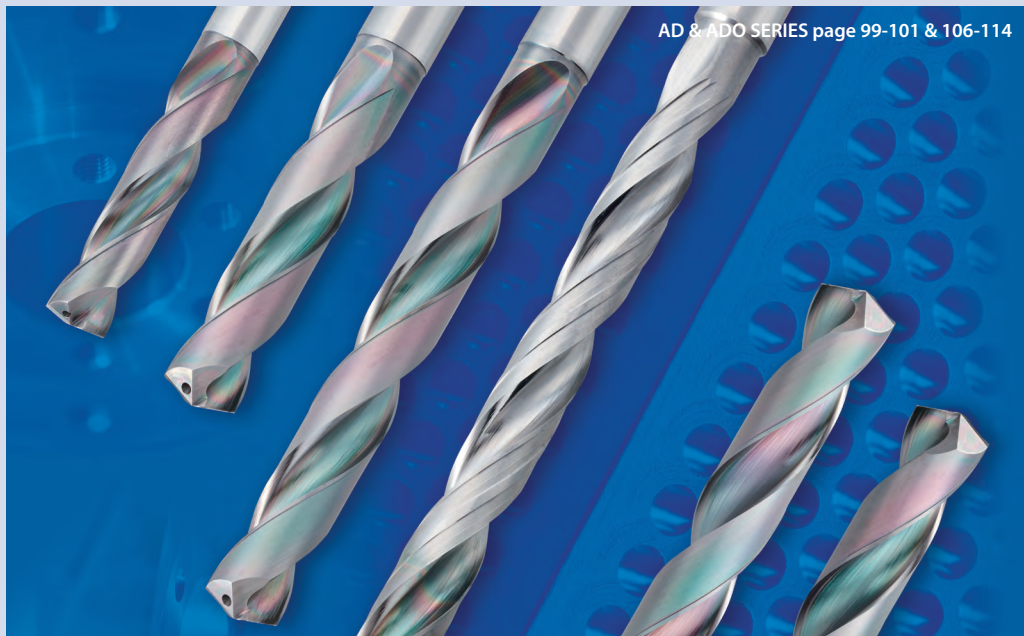
JUNE 2023 V3 SOMTA CATALOGUE

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EDP	Designation	D	Applicable inserts type	L	I	l1	d	Price
OSG-43-7803245	P3D3000F532M09	30	XCMT09...	173	90	60	32	
OSG-43-7803302	P3D3050F532M09	30,5	XCMT09...	175	92	60	32	
OSG-43-7803246	P3D3100F532M09	31	XCMT09...	176	93	60	32	
OSG-43-7803296	P3D3100F540M09	31	XCMT09...	186	93	70	40	
OSG-43-7803303	P3D3150F532M09	31,5	XCMT09...	178	95	60	32	
OSG-43-7803247	P3D3200F532M09	32	XCMT09...	179	96	60	32	
OSG-43-7803297	P3D3200F540M09	32	XCMT09...	189	96	70	40	
OSG-43-7803304	P3D3250F540M09	32,5	XCMT09...	191	98	70	40	
OSG-43-7803248	P3D3300F540M09	33	XCMT09...	192	99	70	40	
OSG-43-7803249	P3D3350F540M09	33,5	XCMT09...	194	101	70	40	
OSG-43-7803250	P3D3400F540M10	34	XCMT10...	195	102	70	40	
OSG-43-7803305	P3D3450F540M10	34,5	XCMT10...	197	104	70	40	
OSG-43-7803251	P3D3500F540M10	35	XCMT10...	198	105	70	40	
OSG-43-7803306	P3D3550F540M10	35,5	XCMT10...	200	107	70	40	
OSG-43-7803252	P3D3600F540M10	36	XCMT10...	201	108	70	40	
OSG-43-7803253	P3D3700F540M10	37	XCMT10...	204	111	70	40	
OSG-43-7803307	P3D3750F540M10	37,5	XCMT10...	206	113	70	40	
OSG-43-7803254	P3D3800F540M10	38	XCMT10...	207	114	70	40	
OSG-43-7803255	P3D3900F540M12	39	XCMT12...	217	117	70	40	
OSG-43-7803256	P3D4000F540M12	40	XCMT12...	220	120	70	40	
OSG-43-7803308	P3D4050F540M12	40,5	XCMT12...	222	122	70	40	
OSG-43-7803257	P3D4100F540M12	41	XCMT12...	223	123	70	40	
OSG-43-7803258	P3D4200F540M12	42	XCMT12...	226	126	70	40	
OSG-43-7803259	P3D4300F540M12	43	XCMT12...	229	129	70	40	
OSG-43-7803260	P3D4400F540M12	44	XCMT12...	232	132	70	40	
OSG-43-7803261	P3D4500F540M13	45	XCMT13...	235	135	70	40	
OSG-43-7803262	P3D4600F540M13	46	XCMT13...	238	138	70	40	
OSG-43-7803263	P3D4700F540M13	47	XCMT13...	241	141	70	40	
OSG-43-7803264	P3D4800F540M13	48	XCMT13...	244	144	70	40	
OSG-43-7803265	P3D4900F540M13	49	XCMT13...	247	147	70	40	
OSG-43-7803266	P3D5000F540M14	50	XCMT14...	250	150	70	40	
OSG-43-7803309	P3D5050F540M14	50,5	XCMT14...	252	152	70	40	
OSG-43-7803267	P3D5100F540M14	51	XCMT14...	253	153	70	40	
OSG-43-7803268	P3D5200F540M14	52	XCMT14...	256	156	70	40	
OSG-43-7803269	P3D5300F540M14	53	XCMT14...	259	159	70	40	
OSG-43-7803270	P3D5400F540M14	54	XCMT14...	262	162	70	40	
OSG-43-7803271	P3D5500F540M14	55	XCMT14...	265	165	70	40	
OSG-43-7803272	P3D5600F540M14	56	XCMT14...	268	168	70	40	
OSG-43-7803273	P3D5700F540M16	57	XCMT16...	271	171	70	40	
OSG-43-7803274	P3D5800F540M16	58	XCMT16...	274	174	70	40	
OSG-43-7803275	P3D5900F540M16	59	XCMT16...	277	177	70	40	
OSG-43-7803276	P3D6000F540M16	60	XCMT16...	280	180	70	40	
OSG-43-7803277	P3D6100F540M16	61	XCMT16...	283	183	70	40	
OSG-43-7803278	P3D6200F540M16	62	XCMT16...	286	186	70	40	
OSG-43-7803279	P3D6300F540M16	63	XCMT16...	289	189	70	40	

See Accessories & spare parts on page 124.

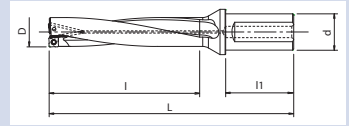
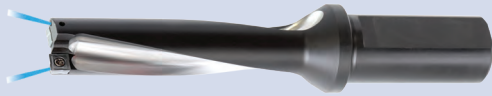
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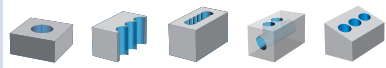
AD & ADO SERIES page 99-101 & 106-114

P4D BODY

Drilling | Indexable | Body



- Indexable drill with internal coolant
- Up to 4xD
- 3 different insert grades available



EDP	Designation	D	Applicable inserts type	L	I	I1	d	Price
OSG-43-7803311	P4D1200FS20M03	12	XCMT03...	111	48	50	20	
OSG-43-7803312	P4D1250FS20M03	12.5	XCMT03...	113	50	50	20	
OSG-43-7803313	P4D1300FS20M03	13	XCMT03...	115	52	50	20	
OSG-43-7803314	P4D1350FS20M03	13.5	XCMT03...	117	54	50	20	
OSG-43-7803315	P4D1400FS20M03	14	XCMT03...	119	56	50	20	
OSG-43-7803316	P4D1450FS20M03	14.5	XCMT03...	121	58	50	20	
OSG-43-7803317	P4D1500FS20M04	15	XCMT04...	125	60	50	20	
OSG-43-7803318	P4D1550FS20M04	15.5	XCMT04...	127	62	50	20	
OSG-43-7803319	P4D1600FS20M04	16	XCMT04...	129	64	50	20	
OSG-43-7803320	P4D1650FS20M04	16.5	XCMT04...	131	66	50	20	
OSG-43-7803321	P4D1700FS20M05	17	XCMT05...	136	68	50	20	
OSG-43-7803322	P4D1750FS20M05	17.5	XCMT05...	138	70	50	20	
OSG-43-7803390	P4D1750FS25M05	17.5	XCMT05...	144	70	56	25	
OSG-43-7803323	P4D1800FS25M05	18	XCMT05...	146	72	56	25	
OSG-43-7803324	P4D1850FS25M05	18.5	XCMT05...	148	74	56	25	
OSG-43-7803325	P4D1900FS25M06	19	XCMT06...	150	76	56	25	
OSG-43-7803326	P4D1950FS25M06	19.5	XCMT06...	152	78	56	25	
OSG-43-7803327	P4D2000FS25M06	20	XCMT06...	154	80	56	25	
OSG-43-7803328	P4D2050FS25M06	20.5	XCMT06...	156	82	56	25	
OSG-43-7803329	P4D2100FS25M07	21	XCMT07...	163	84	56	25	
OSG-43-7803330	P4D2150FS25M07	21.5	XCMT07...	165	86	56	25	
OSG-43-7803331	P4D2200FS25M07	22	XCMT07...	167	88	56	25	
OSG-43-7803332	P4D2250FS25M07	22.5	XCMT07...	169	90	56	25	
OSG-43-7803333	P4D2300FS25M07	23	XCMT07...	171	92	56	25	
OSG-43-7803391	P4D2350FS25M07	23.5	XCMT07...	173	94	56	25	
OSG-43-7803334	P4D2350FS32M07	23.5	XCMT07...	177	94	60	32	
OSG-43-7803392	P4D2400FS25M07	24	XCMT07...	175	96	56	25	
OSG-43-7803335	P4D2400FS32M07	24	XCMT07...	179	96	60	32	
OSG-43-7803393	P4D2450FS25M07	24.5	XCMT07...	177	98	56	25	
OSG-43-7803336	P4D2450FS32M07	24.5	XCMT07...	181	98	60	32	
OSG-43-7803394	P4D2500FS25M08	25	XCMT08...	179	100	56	25	
OSG-43-7803337	P4D2500FS32M08	25	XCMT08...	183	100	60	32	
OSG-43-7803395	P4D2550FS25M08	25.5	XCMT08...	181	102	56	25	
OSG-43-7803338	P4D2550FS32M08	25.5	XCMT08...	185	102	60	32	
OSG-43-7803339	P4D2600FS32M08	26	XCMT08...	187	104	60	32	
OSG-43-7803340	P4D2650FS32M08	26.5	XCMT08...	189	106	60	32	
OSG-43-7803341	P4D2700FS32M08	27	XCMT08...	191	108	60	32	
OSG-43-7803342	P4D2800FS32M08	28	XCMT08...	195	112	60	32	
OSG-43-7803343	P4D2850FS32M08	28.5	XCMT08...	197	114	60	32	
OSG-43-7803344	P4D2900FS32M09	29	XCMT09...	199	116	60	32	
OSG-43-7803345	P4D3000FS32M09	30	XCMT09...	203	120	60	32	
OSG-43-7803346	P4D3100FS32M09	31	XCMT09...	207	124	60	32	
OSG-43-7803396	P4D3100FS40M09	31	XCMT09...	217	124	70	40	
OSG-43-7803347	P4D3200FS32M09	32	XCMT09...	211	128	60	32	
OSG-43-7803397	P4D3200FS40M09	32	XCMT09...	221	128	70	40	
OSG-43-7803348	P4D3300FS40M09	33	XCMT09...	225	132	70	40	
OSG-43-7803349	P4D3350FS40M09	33.5	XCMT09...	227	134	70	40	
OSG-43-7803350	P4D3400FS40M10	34	XCMT10...	229	136	70	40	
OSG-43-7803351	P4D3500FS40M10	35	XCMT10...	233	140	70	40	
OSG-43-7803352	P4D3600FS40M10	36	XCMT10...	237	144	70	40	
OSG-43-7803353	P4D3700FS40M10	37	XCMT10...	241	148	70	40	
OSG-43-7803354	P4D3800FS40M10	38	XCMT10...	245	152	70	40	
OSG-43-7803355	P4D3900FS40M12	39	XCMT12...	256	156	70	40	
OSG-43-7803356	P4D4000FS40M12	40	XCMT12...	260	160	70	40	
OSG-43-7803357	P4D4100FS40M12	41	XCMT12...	264	164	70	40	
OSG-43-7803358	P4D4200FS40M12	42	XCMT12...	268	168	70	40	
OSG-43-7803359	P4D4300FS40M12	43	XCMT12...	272	172	70	40	
OSG-43-7803360	P4D4400FS40M12	44	XCMT12...	276	176	70	40	
OSG-43-7803361	P4D4500FS40M13	45	XCMT13...	280	180	70	40	
OSG-43-7803362	P4D4600FS40M13	46	XCMT13...	284	184	70	40	
OSG-43-7803363	P4D4700FS40M13	47	XCMT13...	288	188	70	40	
OSG-43-7803364	P4D4800FS40M13	48	XCMT13...	292	192	70	40	
OSG-43-7803365	P4D4900FS40M13	49	XCMT13...	296	196	70	40	



EDP	Designation	D	Applicable inserts type	L	I	l1	d	Price
OSG-43-7803366	P4D5000F540M14	50	XCMT14...	300	200	70	40	
OSG-43-7803367	P4D5100F540M14	51	XCMT14...	304	204	70	40	
OSG-43-7803368	P4D5200F540M14	52	XCMT14...	308	208	70	40	
OSG-43-7803369	P4D5300F540M14	53	XCMT14...	312	212	70	40	
OSG-43-7803370	P4D5400F540M14	54	XCMT14...	316	216	70	40	
OSG-43-7803371	P4D5500F540M14	55	XCMT14...	320	220	70	40	
OSG-43-7803372	P4D5600F540M14	56	XCMT14...	324	224	70	40	
OSG-43-7803373	P4D5700F540M16	57	XCMT16...	328	228	70	40	
OSG-43-7803374	P4D5800F540M16	58	XCMT16...	332	232	70	40	
OSG-43-7803375	P4D5900F540M16	59	XCMT16...	336	236	70	40	
OSG-43-7803376	P4D6000F540M16	60	XCMT16...	340	240	70	40	
OSG-43-7803377	P4D6100F540M16	61	XCMT16...	344	244	70	40	
OSG-43-7803378	P4D6200F540M16	62	XCMT16...	348	248	70	40	
OSG-43-7803379	P4D6300F540M16	63	XCMT16...	352	252	70	40	

See Accessories & spare parts on page 124.

Available on request

P5D BODY

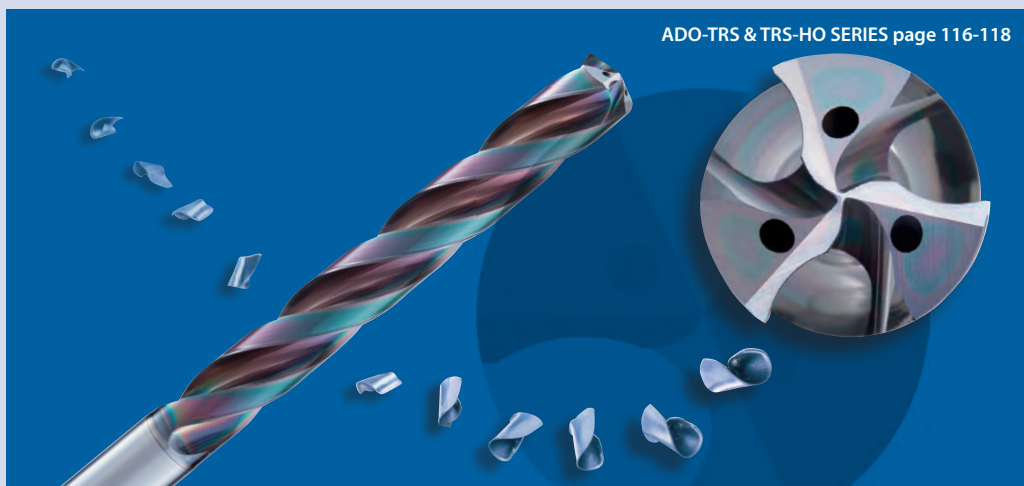
Drilling | Indexable | Body



- Indexable drill with internal coolant
- Up to 5xD
- 3 different insert grades available



EDP	Designation	D	Applicable inserts type	L	I	l1	d	Price
OSG-43-7802780	P5D1200F520M03	12	XCMT03...	123	60	50	20	
OSG-43-7802781	P5D1250F520M03	12.5	XCMT03...	125.5	62.5	50	20	
OSG-43-7802782	P5D1300F520M03	13	XCMT03...	128	65	50	20	
OSG-43-7802783	P5D1350F520M03	13.5	XCMT03...	130.5	67.5	50	20	
OSG-43-7802784	P5D1400F520M03	14	XCMT03...	133	70	50	20	
OSG-43-7802785	P5D1450F520M03	14.5	XCMT03...	135.5	72.5	50	20	
OSG-43-7802717	P5D1500F520M04	15	XCMT04...	140	75	50	20	
OSG-43-7802718	P5D1550F520M04	15.5	XCMT04...	143	78	50	20	
OSG-43-7802719	P5D1600F520M04	16	XCMT04...	145	80	50	20	
OSG-43-7802720	P5D1650F520M04	16.5	XCMT04...	148	83	50	20	
OSG-43-7802721	P5D1700F520M05	17	XCMT05...	153	85	50	20	
OSG-43-7802722	P5D1750F520M05	17.5	XCMT05...	156	88	50	20	
OSG-43-7802790	P5D1750F525M05	17.5	XCMT05...	162	88	56	25	



High Performance Drilling | Indexable



P4D/P5D BODY

EDP	Designation	D	Applicable inserts type	L	I	l1	d	Price
OSG-43-7802723	PSD1800F525M05	18	XCMT05...	164	90	56	25	
OSG-43-7802724	PSD1850F525M05	18,5	XCMT05...	167	93	56	25	
OSG-43-7802725	PSD1900F525M06	19	XCMT06...	169	95	56	25	
OSG-43-7802726	PSD1950F525M06	19,5	XCMT06...	172	98	56	25	
OSG-43-7802727	PSD2000F525M06	20	XCMT06...	174	100	56	25	
OSG-43-7802728	PSD2050F525M06	20,5	XCMT06...	177	103	56	25	
OSG-43-7802729	PSD2100F525M07	21	XCMT07...	184	105	56	25	
OSG-43-7802730	PSD2150F525M07	21,5	XCMT07...	187	108	56	25	
OSG-43-7802731	PSD2200F525M07	22	XCMT07...	189	110	56	25	
OSG-43-7802732	PSD2250F525M07	22,5	XCMT07...	192	113	56	25	
OSG-43-7802733	PSD2300F525M07	23	XCMT07...	194	115	56	25	
OSG-43-7802791	PSD2350F525M07	23,5	XCMT07...	197	118	56	25	
OSG-43-7802734	PSD2350F532M07	23,5	XCMT07...	201	118	60	32	
OSG-43-7802792	PSD2400F525M07	24	XCMT07...	199	120	56	25	
OSG-43-7802735	PSD2400F532M07	24	XCMT07...	203	120	60	32	
OSG-43-7802793	PSD2450F525M07	24,5	XCMT07...	202	123	56	25	
OSG-43-7802736	PSD2450F532M07	24,5	XCMT07...	206	123	60	32	
OSG-43-7802794	PSD2500F525M08	25	XCMT08...	204	125	56	25	
OSG-43-7802737	PSD2500F532M08	25	XCMT08...	208	125	60	32	
OSG-43-7802795	PSD2550F525M08	25,5	XCMT08...	207	128	56	25	
OSG-43-7802738	PSD2550F532M08	25,5	XCMT08...	211	128	60	32	
OSG-43-7802739	PSD2600F532M08	26	XCMT08...	213	130	60	32	
OSG-43-7802740	PSD2650F532M08	26,5	XCMT08...	216	133	60	32	
OSG-43-7802741	PSD2700F532M08	27	XCMT08...	218	135	60	32	
OSG-43-7802742	PSD2800F532M08	28	XCMT08...	223	140	60	32	
OSG-43-7802743	PSD2850F532M08	28,5	XCMT08...	226	143	60	32	
OSG-43-7802744	PSD2900F532M09	29	XCMT09...	228	145	60	32	
OSG-43-7802745	PSD3000F532M09	30	XCMT09...	233	150	60	32	
OSG-43-7802746	PSD3100F532M09	31	XCMT09...	238	155	60	32	
OSG-43-7802796	PSD3100F540M09	31	XCMT09...	248	155	70	40	
OSG-43-7802747	PSD3200F532M09	32	XCMT09...	243	160	60	32	
OSG-43-7802797	PSD3200F540M09	32	XCMT09...	253	160	70	40	
OSG-43-7802748	PSD3300F540M09	33	XCMT09...	258	165	70	40	
OSG-43-7802749	PSD3350F540M09	33,5	XCMT09...	261	168	70	40	
OSG-43-7802750	PSD3400F540M10	34	XCMT10...	263	170	70	40	
OSG-43-7802751	PSD3500F540M10	35	XCMT10...	268	175	70	40	
OSG-43-7802752	PSD3600F540M10	36	XCMT10...	273	180	70	40	
OSG-43-7802753	PSD3700F540M10	37	XCMT10...	278	185	70	40	
OSG-43-7802754	PSD3800F540M10	38	XCMT10...	283	190	70	40	
OSG-43-7802755	PSD3900F540M12	39	XCMT12...	295	195	70	40	
OSG-43-7802756	PSD4000F540M12	40	XCMT12...	300	200	70	40	
OSG-43-7802757	PSD4100F540M12	41	XCMT12...	305	205	70	40	
OSG-43-7802758	PSD4200F540M12	42	XCMT12...	310	210	70	40	
OSG-43-7802759	PSD4300F540M12	43	XCMT12...	315	215	70	40	
OSG-43-7802760	PSD4400F540M12	44	XCMT12...	320	220	70	40	
OSG-43-7802761	PSD4500F540M13	45	XCMT13...	325	225	70	40	
OSG-43-7802762	PSD4600F540M13	46	XCMT13...	330	230	70	40	
OSG-43-7802763	PSD4700F540M13	47	XCMT13...	335	235	70	40	
OSG-43-7802764	PSD4800F540M13	48	XCMT13...	340	240	70	40	
OSG-43-7802765	PSD4900F540M13	49	XCMT13...	345	245	70	40	
OSG-43-7802766	PSD5000F540M14	50	XCMT14...	350	250	70	40	
OSG-43-7802767	PSD5100F540M14	51	XCMT14...	355	255	70	40	
OSG-43-7802768	PSD5200F540M14	52	XCMT14...	360	260	70	40	
OSG-43-7802769	PSD5300F540M14	53	XCMT14...	365	265	70	40	
OSG-43-7802770	PSD5400F540M14	54	XCMT14...	370	270	70	40	
OSG-43-7802771	PSD5500F540M14	55	XCMT14...	375	275	70	40	
OSG-43-7802772	PSD5600F540M14	56	XCMT14...	380	280	70	40	
OSG-43-7802773	PSD5700F540M16	57	XCMT16...	385	285	70	40	
OSG-43-7802774	PSD5800F540M16	58	XCMT16...	390	290	70	40	
OSG-43-7802775	PSD5900F540M16	59	XCMT16...	395	295	70	40	
OSG-43-7802776	PSD6000F540M16	60	XCMT16...	400	300	70	40	
OSG-43-7802777	PSD6100F540M16	61	XCMT16...	405	305	70	40	
OSG-43-7802778	PSD6200F540M16	62	XCMT16...	410	310	70	40	
OSG-43-7802779	PSD6300F540M16	63	XCMT16...	415	315	70	40	

See Accessories & spare parts below.

Available on request

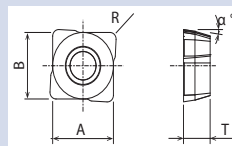
Accessories & spare parts

Applicable drill Ø	 Clamping screw		 Wrench	
Ø 12 - 14,5	OSG-31-7808096	FS18536P	OSG-31-7808223	6IP-D (Torx 6IP)
Ø 15 - 18,5	OSG-31-7808139	FS20543P	OSG-31-7808223	6IP-D (Torx 6IP)
Ø 19 - 20,5	OSG-31-7808138	FS22550P	OSG-31-7808224	7IP-D (Torx 7IP)
Ø 21 - 24,5	OSG-31-7808136	FS25560P	OSG-31-7808225	8IP-D (Torx 8IP)
Ø 25 - 33,5	OSG-31-7808135	FS30570P	OSG-31-7808226	9IP-D (Torx 9IP)
Ø 34 - 44	OSG-31-7808137	FS35586P	OSG-31-7808228	15IP-D (Torx 15IP)
Ø 45 - 63	OSG-31-7808114	FS45510P	OSG-31-7808229	20IP-D (Torx 20IP)



P2D • P3D • P4D • P5D INSERTS

Drilling | Indexable | Inserts & Heads



- Applicable inserts for PD drill



EDP	Designation	z	A x B	T	α	R	Grade	P	M	K	N	S	H	Applicable body Ø	Price
OSG-44-7823098	XCMT031904ER-DM	2	6,1x4,5	1,9	8	0,4	XP9020	●	●	○	○	○	○	Ø12 - 14,5	
OSG-44-7823064	XCMT042204ER-DM	4	5	2,2	8	0,4	XP9020	●	●	○	○	○	○	Ø15 - 16,5	
OSG-44-7823065	XCMT052404ER-DM	4	5,83	2,4	8	0,4	XP9020	●	●	○	○	○	○	Ø17 - 18,5	
OSG-44-7823066	XCMT062706ER-DM	4	6,46	2,7	8	0,6	XP9020	●	●	○	○	○	○	Ø19 - 20,5	
OSG-44-7823067	XCMT073106ER-DM	4	7,11	3,1	8	0,6	XP9020	●	●	○	○	○	○	Ø21 - 24,5	
OSG-44-7823068	XCMT083508ER-DM	4	8,36	3,5	8	0,8	XP9020	●	●	○	○	○	○	Ø25 - 28,5	
OSG-44-7823069	XCMT094008ER-DM	4	9,62	4	8	0,8	XP9020	●	●	○	○	○	○	Ø29 - 33,5	
OSG-44-7823097	XCMT104608ER-DM	4	10,89	4,6	8	0,8	XP9020	●	●	○	○	○	○	Ø34 - 38	
OSG-44-7823071	XCMT125010ER-DM	4	12,57	5	8	1	XP9020	●	●	○	○	○	○	Ø39 - 44	
OSG-44-7823072	XCMT135212ER-DM	4	14,05	5,2	8	1,2	XP9020	●	●	○	○	○	○	Ø45 - 49	
OSG-44-7823073	XCMT145612ER-DM	4	15,58	5,6	8	1,2	XP9020	●	●	○	○	○	○	Ø50 - 56	
OSG-44-7823075	XCMT165912ER-DM	4	17,28	5,9	8	1,2	XP9020	●	●	○	○	○	○	Ø57 - 63	
OSG-44-7823163	XCMT031904ER-DR	2	6,1x4,5	1,9	8	0,4	XP1010	○	●	●				Ø12 - 14,5	
OSG-44-7823164	XCMT042204ER-DR	4	5	2,2	8	0,4	XP1010	○	●	●				Ø15 - 16,5	
OSG-44-7823165	XCMT052404ER-DR	4	5,83	2,4	8	0,4	XP1010	○	●	●				Ø17 - 18,5	
OSG-44-7823166	XCMT062706ER-DR	4	6,46	2,7	8	0,6	XP1010	○	●	●				Ø19 - 20,5	
OSG-44-7823167	XCMT073106ER-DR	4	7,11	3,1	8	0,6	XP1010	○	●	●				Ø21 - 24,5	
OSG-44-7823168	XCMT083508ER-DR	4	8,36	3,5	8	0,8	XP1010	○	●	●				Ø25 - 28,5	
OSG-44-7823169	XCMT094008ER-DR	4	9,62	4	8	0,8	XP1010	○	●	●				Ø29 - 33,5	
OSG-44-7823197	XCMT104608ER-DR	4	10,89	4,6	8	0,8	XP1010	○	●	●				Ø34 - 38	
OSG-44-7823171	XCMT125010ER-DR	4	12,57	5	8	1	XP1010	○	●	●				Ø39 - 44	
OSG-44-7823172	XCMT135212ER-DR	4	14,05	5,2	8	1,2	XP1010	○	●	●				Ø45 - 49	
OSG-44-7823173	XCMT145612ER-DR	4	15,58	5,6	8	1,2	XP1010	○	●	●				Ø50 - 56	
OSG-44-7823175	XCMT165912ER-DR	4	17,28	5,9	8	1,2	XP1010	○	●	●				Ø57 - 63	
OSG-44-7823263	XCMT031904ER-DN	2	6,1x4,5	1,9	8	0,4	CK110				●			Ø12 - 14,5	
OSG-44-7823264	XCMT042204ER-DN	4	5	2,2	8	0,4	CK110				●			Ø15 - 16,5	
OSG-44-7823265	XCMT052404ER-DN	4	5,83	2,4	8	0,4	CK110				●			Ø17 - 18,5	
OSG-44-7823266	XCMT062706ER-DN	4	6,46	2,7	8	0,6	CK110				●			Ø19 - 20,5	
OSG-44-7823267	XCMT073106ER-DN	4	7,11	3,1	8	0,6	CK110				●			Ø21 - 24,5	
OSG-44-7823268	XCMT083508ER-DN	4	8,36	3,5	8	0,8	CK110				●			Ø25 - 28,5	
OSG-44-7823269	XCMT094008ER-DN	4	9,62	4	8	0,8	CK110				●			Ø29 - 33,5	
OSG-44-7823297	XCMT104608ER-DN	4	10,89	4,6	8	0,8	CK110				●			Ø34 - 38	
OSG-44-7823271	XCMT125010ER-DN	4	12,57	5	8	1	CK110				●			Ø39 - 44	
OSG-44-7823272	XCMT135212ER-DN	4	14,05	5,2	8	1,2	CK110				●			Ø45 - 49	
OSG-44-7823273	XCMT145612ER-DN	4	15,58	5,6	8	1,2	CK110				●			Ø50 - 56	
OSG-44-7823275	XCMT165912ER-DN	4	17,28	5,9	8	1,2	CK110				●			Ø57 - 63	


Available on request


High Performance Drilling | Indexable

P2D/P3D/P4D/P5D INSERTS

HYP-HP-SC-3D/ HYP-HPO-SC-3D/HYP-HPO-3D


Standard drilling


	Steel			Cu	A5052 /A7075	Al < 13% Si < 130 HB
	< 700 N/mm ²	< 850 N/mm ²	< 1000 N/mm ²			
Vc	100 ~ 150 m/min	80 ~ 120 m/min	70 ~ 110 m/min	50 ~ 90 m/min	60 ~ 110 m/min	120 ~ 220 m/min
Ø	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
3	0,09-0,12	0,09-0,12	0,09-0,12	0,02-0,03	0,09-0,20	0,09-0,28
4	0,10-0,15	0,10-0,15	0,10-0,15	0,02-0,04	0,10-0,24	0,10-0,38
5	0,12-0,18	0,12-0,18	0,12-0,18	0,03-0,05	0,12-0,28	0,12-0,40
6	0,14-0,20	0,14-0,20	0,14-0,20	0,03-0,06	0,14-0,34	0,14-0,48
8	0,16-0,24	0,16-0,24	0,16-0,24	0,04-0,08	0,16-0,38	0,16-0,53
10	0,18-0,27	0,18-0,27	0,18-0,27	0,05-0,10	0,18-0,45	0,18-0,63
12	0,20-0,30	0,20-0,30	0,20-0,30	0,06-0,12	0,20-0,53	0,20-0,75
14	0,22-0,35	0,22-0,35	0,22-0,35	0,08-0,16	0,22-0,57	0,22-0,81
16	0,25-0,36	0,25-0,36	0,25-0,36	0,10-0,18	0,25-0,61	0,25-0,85
18	0,28-0,38	0,28-0,38	0,28-0,38	0,12-0,20	0,28-0,63	0,28-0,90
20	0,30-0,40	0,30-0,40	0,30-0,40	0,20-0,28	0,28-0,68	0,30-0,98

	GG (G)		SUS	High-Alloy Steel	Special Alloys	Hardened Steel
	< 180 HB	< 300 HB	< 820 HB	< 1200 N/mm ²	< 30 HRC	< 60 HRC
Vc	150 ~ 200 m/min	100 ~ 150 m/min	40 ~ 50 m/min	50 ~ 60 m/min	15 ~ 25 m/min	15 ~ 25 m/min
Ø	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
3	0,12-0,15	0,12-0,15	0,09-0,12	0,07-0,11	0,05-0,09	0,03-0,05
4	0,13-0,18	0,13-0,18	0,10-0,15	0,08-0,13	0,06-0,10	0,04-0,06
5	0,15-0,22	0,15-0,22	0,12-0,18	0,10-0,15	0,08-0,12	0,05-0,07
6	0,18-0,25	0,18-0,25	0,14-0,20	0,12-0,18	0,09-0,15	0,05-0,07
8	0,20-0,30	0,20-0,30	0,16-0,24	0,14-0,22	0,12-0,20	0,06-0,08
10	0,23-0,33	0,23-0,33	0,18-0,27	0,15-0,25	0,13-0,23	0,07-0,10
12	0,25-0,38	0,25-0,38	0,20-0,30	0,17-0,26	0,14-0,24	0,09-0,12
14	0,30-0,43	0,30-0,43	0,22-0,35	0,18-0,30	0,15-0,26	0,10-0,13
16	0,35-0,50	0,35-0,50	0,25-0,36	0,20-0,32	0,16-0,26	0,10-0,13
18	0,38-0,55	0,38-0,55	0,28-0,38	0,23-0,33	0,18-0,28	0,12-0,16
20	0,40-0,63	0,40-0,63	0,30-0,40	0,25-0,35	0,20-0,30	0,14-0,18

HYP-HPO-5D/HYP-HPO-8D

Standard drilling

	Steel			Cu	A5052 /A7075	Al < 13% Si < 130 HB
	< 700 N/mm ²	< 850 N/mm ²	< 1000 N/mm ²			
Vc < Ø3	40 ~ 60 m/min	40 ~ 60 m/min	40 ~ 60 m/min	20 ~ 50 m/min	40 ~ 60 m/min	50 ~ 70 m/min
Vc	100 ~ 150 m/min	80 ~ 120 m/min	70 ~ 110 m/min	50 ~ 90 m/min	60 ~ 110 m/min	120 ~ 220 m/min
Ø	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
3	0,09-0,12	0,09-0,12	0,09-0,12	0,02-0,03	0,09-0,20	0,09-0,28
4	0,10-0,15	0,10-0,15	0,10-0,15	0,02-0,04	0,10-0,24	0,10-0,38
5	0,12-0,18	0,12-0,18	0,12-0,18	0,03-0,05	0,12-0,28	0,12-0,40
6	0,14-0,20	0,14-0,20	0,14-0,20	0,03-0,06	0,14-0,34	0,14-0,48
8	0,16-0,24	0,16-0,24	0,16-0,24	0,04-0,08	0,16-0,38	0,16-0,53
10	0,18-0,27	0,18-0,27	0,18-0,27	0,05-0,10	0,18-0,45	0,18-0,63
12	0,20-0,30	0,20-0,30	0,20-0,30	0,06-0,12	0,20-0,53	0,20-0,75
14	0,22-0,35	0,22-0,35	0,22-0,35	0,08-0,16	0,22-0,57	0,22-0,81
16	0,25-0,36	0,25-0,36	0,25-0,36	0,10-0,18	0,25-0,61	0,25-0,85
18	0,28-0,38	0,28-0,38	0,28-0,38	0,12-0,20	0,28-0,63	0,28-0,90
20	0,30-0,40	0,30-0,40	0,30-0,40	0,20-0,28	0,28-0,68	0,30-0,98

	GG (G)		SUS	High-Alloy Steel	Special Alloys	Hardened Steel
	< 180 HB	< 300 HB	< 820 HB	< 1200 N/mm ²	< 30 HRC	< 60 HRC
Vc < Ø3	50 ~ 60 m/min	50 ~ 60 m/min	30 ~ 50 m/min	40 ~ 60 m/min	15 ~ 20 m/min	15 ~ 20 m/min
Vc	150 ~ 200 m/min	100 ~ 150 m/min	40 ~ 50 m/min	50 ~ 60 m/min	15 ~ 25 m/min	15 ~ 25 m/min
Ø	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
3	0,12-0,15	0,12-0,15	0,09-0,12	0,07-0,11	0,05-0,09	0,03-0,05
4	0,13-0,18	0,13-0,18	0,10-0,15	0,08-0,13	0,06-0,10	0,04-0,06
5	0,15-0,22	0,15-0,22	0,12-0,18	0,10-0,15	0,08-0,12	0,05-0,07
6	0,18-0,25	0,18-0,25	0,14-0,20	0,12-0,18	0,09-0,15	0,05-0,07
8	0,20-0,30	0,20-0,30	0,16-0,24	0,14-0,22	0,12-0,20	0,06-0,08
10	0,23-0,33	0,23-0,33	0,18-0,27	0,15-0,25	0,13-0,23	0,07-0,10
12	0,25-0,38	0,25-0,38	0,20-0,30	0,17-0,26	0,14-0,24	0,09-0,12
14	0,30-0,43	0,30-0,43	0,22-0,35	0,18-0,30	0,15-0,26	0,10-0,13
16	0,35-0,50	0,35-0,50	0,25-0,36	0,20-0,32	0,16-0,26	0,10-0,13
18	0,38-0,55	0,38-0,55	0,28-0,38	0,23-0,33	0,18-0,28	0,12-0,16
20	0,40-0,63	0,40-0,63	0,30-0,40	0,25-0,35	0,20-0,30	0,14-0,18

High Performance Drilling | Solid carbide

Cutting conditions



ADO-MICRO 2D/5D

	Mild Steel - Low Carbon Steel S5400 - S10C ~150HB ~500 N/mm ²		Carbon Steel S35C - S50C ~210HB ~710 N/mm ²		Alloy Steel SCM - SCr - SNCM 710 ~900 N/mm ²		Alloy Steel SCM - SCr - SNCM 710 ~900 N/mm ²		Austenitic Stainless Steel SUS303 - SUS304 SUS316 - SUS316L		Special Alloy Steel SUJ2 - SUS440	
	Vc	20~40~60m/min	20~40~60m/min	20~40~60m/min	20~40~60m/min	20~30~40m/min	20~30~40m/min	20~30~70m/min	20~30~70m/min	25~35~45m/min	25~35~45m/min	25~35~45m/min
Ø	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)
0.7	18.200	0.007 ~ 0.021	18.200	0.007 ~ 0.021	18.200	0.014 ~ 0.028	13.600	0.014 ~ 0.028	13.600	0.007 ~ 0.021	15.900	0.007 ~ 0.021
1	12.700	0.01 ~ 0.03	12.700	0.01 ~ 0.03	12.700	0.02 ~ 0.04	9.500	0.02 ~ 0.04	9.500	0.01 ~ 0.03	11.100	0.01 ~ 0.03
1.5	8.500	0.015 ~ 0.045	8.500	0.015 ~ 0.045	8.500	0.03 ~ 0.06	6.400	0.03 ~ 0.06	6.400	0.015 ~ 0.045	7.400	0.015 ~ 0.045
2	6.400	0.02 ~ 0.06	6.400	0.02 ~ 0.06	6.400	0.04 ~ 0.08	4.800	0.04 ~ 0.08	4.800	0.02 ~ 0.06	5.600	0.02 ~ 0.06

	Cast Iron FC250 ~350N/mm ²		Ductile Cast Iron FCD450 - FCD600 400 ~600 N/mm ²		Aluminium Alloy AC4C - ADC		Aluminium A5052 - A7075		Titanium Alloy		Heat Resistant Alloy Inconel 718	
	Vc	20~50~60m/min	30~40~50m/min	30~40~50m/min	30~50~70m/min	30~50~70m/min	20~40~60m/min	20~40~60m/min	40~50~60m/min	40~50~60m/min	5~10~15m/min	5~10~15m/min
Ø	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)
0.7	22.700	0.014 ~ 0.028	18.200	0.014 ~ 0.028	22.700	0.014 ~ 0.042	18.200	0.007 ~ 0.021	22.700	0.011 ~ 0.018	4.500	0.004 ~ 0.014
1	15.900	0.02 ~ 0.04	12.700	0.02 ~ 0.04	15.900	0.02 ~ 0.06	12.700	0.01 ~ 0.03	15.900	0.015 ~ 0.025	3.200	0.005 ~ 0.02
1.5	10.600	0.03 ~ 0.06	8.500	0.03 ~ 0.06	10.600	0.03 ~ 0.09	8.500	0.015 ~ 0.045	10.600	0.023 ~ 0.038	2.100	0.008 ~ 0.03
2	8.000	0.04 ~ 0.08	6.400	0.04 ~ 0.08	8.000	0.04 ~ 0.12	6.400	0.02 ~ 0.06	8.000	0.03 ~ 0.05	1.600	0.01 ~ 0.04

See Annexure A on page 134.

ADO-MICRO 12D/15D/20D/25D/30D

	Mild Steel - Low Carbon Steel S5400 - S10C ~150HB ~500 N/mm ²		Carbon Steel S35C - S50C ~210HB ~710 N/mm ²		Alloy Steel SCM - SCr - SNCM 710 ~900 N/mm ²		Alloy Steel SCM - SCr - SNCM 710 ~900 N/mm ²		Austenitic Stainless Steel SUS303 - SUS304 SUS316 - SUS316L		Special Alloy Steel SUJ2 - SUS440	
	Vc	20~40~60m/min	20~40~60m/min	20~40~60m/min	20~40~60m/min	20~30~40m/min	20~30~40m/min	20~30~70m/min	20~30~70m/min	25~35~45m/min	25~35~45m/min	25~35~45m/min
Ø	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)
1	12.700	0.01 ~ 0.03	12.700	0.01 ~ 0.03	12.700	0.02 ~ 0.04	9.500	0.02 ~ 0.04	9.500	0.01 ~ 0.03	11.100	0.01 ~ 0.03
1.5	8.500	0.015 ~ 0.045	8.500	0.015 ~ 0.045	8.500	0.03 ~ 0.06	6.400	0.03 ~ 0.06	6.400	0.015 ~ 0.045	7.400	0.015 ~ 0.045
2	6.400	0.02 ~ 0.06	6.400	0.02 ~ 0.06	6.400	0.04 ~ 0.08	4.800	0.04 ~ 0.08	4.800	0.02 ~ 0.06	5.600	0.02 ~ 0.06

	Cast Iron FC250 ~350N/mm ²		Ductile Cast Iron FCD450 - FCD600 400 ~600 N/mm ²		Aluminium Alloy AC4C - ADC		Aluminium A5052 - A7075		Titanium Alloy		Heat Resistant Alloy Inconel 718	
	Vc	20~50~60m/min	30~40~50m/min	30~40~50m/min	30~50~70m/min	30~50~70m/min	20~40~60m/min	20~40~60m/min	40~50~60m/min	40~50~60m/min	5~10~15m/min	5~10~15m/min
Ø	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)
1	15.900	0.02 ~ 0.04	12.700	0.02 ~ 0.04	15.900	0.02 ~ 0.06	12.700	0.01 ~ 0.03	15.900	0.015 ~ 0.025	3.200	0.005 ~ 0.02
1.5	10.600	0.03 ~ 0.06	8.500	0.03 ~ 0.06	10.600	0.03 ~ 0.09	8.500	0.015 ~ 0.045	10.600	0.023 ~ 0.038	2.100	0.008 ~ 0.03
2	8.000	0.04 ~ 0.08	6.400	0.04 ~ 0.08	8.000	0.04 ~ 0.12	6.400	0.02 ~ 0.06	8.000	0.03 ~ 0.05	1.600	0.01 ~ 0.04

See Annexure A on page 134.

AD-2D/AD-4D

Standard drilling

	C<0.35% (C<0.35%) S140 - SCM ~710 N/mm ²		C<0.35% (C<0.35%) CK50 ~1060 N/mm ²		Special Alloy SUJ2		SUS Serie SUS300 Serie SUS400		Hardened Steel SKD61 43 HRC		GG GG25 ~ 350 N/mm ²		GGG GGG40 ~ 500 N/mm ²	
	Vc	63 ~ 100 m/min	63 ~ 100 m/min	63 ~ 100 m/min	50 ~ 71 m/min	25 ~ 40 m/min	25 ~ 40 m/min	40 ~ 63 m/min	32 ~ 45 m/min	63 ~ 100 m/min	50 ~ 80 m/min	63 ~ 100 m/min	50 ~ 80 m/min	50 ~ 80 m/min
Ø	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)
2	11.000	0.06~0.08	11.000	0.06~0.08	9.000	0.06~0.08	4.700	0.06~0.08	7.600	0.06~0.08	6.000	0.06~0.08	12.000	0.06~0.08
3	8.000	0.09~0.12	8.000	0.09~0.12	6.000	0.09~0.12	3.200	0.09~0.12	5.000	0.09~0.12	4.000	0.09~0.12	6.900	0.09~0.12
4	6.300	0.10~0.15	6.300	0.10~0.15	4.750	0.10~0.15	2.400	0.10~0.15	3.800	0.10~0.15	3.000	0.10~0.15	5.200	0.10~0.15
5	5.000	0.12~0.18	5.000	0.12~0.18	3.800	0.12~0.18	1.900	0.12~0.18	3.000	0.12~0.18	2.450	0.12~0.18	4.100	0.12~0.18
6	4.200	0.14~0.20	4.200	0.14~0.20	3.200	0.14~0.20	1.600	0.14~0.20	2.550	0.14~0.20	2.050	0.14~0.20	3.450	0.14~0.20
8	3.200	0.16~0.24	3.200	0.16~0.24	2.400	0.16~0.24	1.200	0.16~0.24	1.900	0.16~0.24	1.550	0.16~0.24	2.600	0.16~0.24
10	2.550	0.18~0.27	2.550	0.18~0.27	1.900	0.18~0.27	950	0.18~0.27	1.550	0.18~0.27	1.250	0.18~0.27	2.100	0.18~0.27
12	2.100	0.20~0.30	2.100	0.20~0.30	1.600	0.20~0.30	800	0.20~0.30	1.300	0.20~0.30	1.050	0.20~0.30	1.750	0.20~0.30
14	1.800	0.22~0.35	1.800	0.22~0.35	1.350	0.22~0.35	700	0.22~0.35	1.100	0.22~0.35	880	0.22~0.35	1.500	0.22~0.35
16	1.600	0.25~0.36	1.600	0.25~0.36	1.200	0.25~0.36	600	0.25~0.36	950	0.25~0.36	770	0.25~0.36	1.300	0.25~0.36
18	1.400	0.28~0.38	1.400	0.28~0.38	1.050	0.28~0.38	530	0.28~0.38	850	0.28~0.38	680	0.28~0.38	1.200	0.28~0.38
20	1.300	0.30~0.40	1.300	0.30~0.40	960	0.30~0.40	480	0.30~0.40	760	0.30~0.40	610	0.30~0.40	1.100	0.30~0.40

High Performance Drilling | Solid carbide

Cutting conditions

ADO-SUS-3D/5D/8D

	Carbon Steel S50C		Alloy Steel SCM440		Alloy Steel SCM440 + 30HRC		Stainless Steel SUS304 - SUS316		Super Duplex SUS630 + 17-4PH + 15-5PH		Ti Alloy		Nickel Alloy Inconel 718	
Vc	80 ~ 120 m/min		80 ~ 120 m/min		60 ~ 90 m/min		60 ~ 100 m/min		30 ~ 60 m/min		20 ~ 50 m/min		10 ~ 30 m/min	
Ø	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)
3	10.600	0,06-0,12	10.600	0,06-0,12	7.400	0,06-0,12	8.500	0,06-0,12	4.800	0,06-0,09	3.700	0,05-0,09	2.100	0,05-0,08
4	8.000	0,08-0,16	8.000	0,08-0,16	5.600	0,08-0,16	6.400	0,08-0,16	3.600	0,08-0,12	2.800	0,06-0,12	1.600	0,06-0,01
5	6.400	0,10-0,20	6.400	0,10-0,20	4.500	0,10-0,20	5.100	0,10-0,20	2.900	0,10-0,15	2.200	0,08-0,15	1.300	0,08-0,13
6	5.300	0,12-0,24	5.300	0,12-0,24	3.700	0,12-0,24	4.200	0,12-0,24	2.400	0,12-0,18	1.900	0,09-0,18	1.100	0,09-0,15
7	4.500	0,14-0,26	4.500	0,14-0,26	3.200	0,14-0,26	3.600	0,14-0,26	2.000	0,14-0,21	1.600	0,11-0,21	900	0,11-0,18
8	4.000	0,16-0,28	4.000	0,16-0,28	2.800	0,16-0,28	3.200	0,16-0,28	1.800	0,16-0,24	1.400	0,12-0,24	800	0,12-0,2
9	3.500	0,18-0,30	3.500	0,18-0,30	2.500	0,18-0,30	2.800	0,18-0,30	1.600	0,18-0,27	1.200	0,14-0,27	700	0,14-0,2
10	3.200	0,20-0,30	3.200	0,20-0,30	2.200	0,20-0,30	2.500	0,20-0,30	1.400	0,20-0,30	1.100	0,15-0,30	640	0,15-0,2
11	2.900	0,20-0,30	2.900	0,20-0,30	2.000	0,20-0,30	2.300	0,20-0,30	1.300	0,20-0,30	1.000	0,15-0,30	580	0,15-0,2
12	2.700	0,21-0,30	2.700	0,21-0,30	1.900	0,21-0,30	2.100	0,21-0,30	1.200	0,21-0,30	900	0,16-0,30	530	0,15-0,2
13	2.400	0,21-0,33	2.400	0,21-0,33	1.700	0,21-0,33	2.000	0,21-0,33	1.100	0,21-0,33	900	0,18-0,33	-	-
14	2.300	0,22-0,35	2.300	0,22-0,35	1.600	0,22-0,35	1.800	0,22-0,35	1.000	0,22-0,35	800	0,19-0,35	-	-
16	2.000	0,25-0,36	2.000	0,25-0,36	1.400	0,25-0,36	1.600	0,25-0,36	900	0,25-0,36	700	0,22-0,36	-	-
18	1.800	0,28-0,38	1.800	0,28-0,38	1.200	0,28-0,38	1.400	0,28-0,38	800	0,28-0,38	600	0,24-0,38	-	-
20	1.600	0,30-0,40	1.600	0,30-0,40	1.100	0,30-0,40	1.300	0,30-0,40	700	0,30-0,40	600	0,27-0,40	-	-

ADO-3D/5D/ADO-PLT

	Carbon Steel S50C		Alloy Steel SCM440		Alloy Steel SCM440 + 30HRC		Cast Iron FC250		Ductile Cast IRON FCD700		Stainless Steel SUS304	
Vc	80 ~ 120 m/min		80 ~ 120 m/min		60 ~ 90 m/min		80 ~ 120 m/min		60 ~ 100 m/min		40 ~ 70 m/min	
Ø	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)
2	12.700	0,04-0,08	12.700	0,04-0,08	11.100	0,04-0,08	12.700	0,04-0,08	12.700	0,04-0,08	9.500	0,04-0,08
3	10.600	0,06-0,12	10.600	0,06-0,12	7.400	0,06-0,12	10.600	0,06-0,12	8.500	0,06-0,12	6.400	0,06-0,12
4	8.000	0,08-0,16	8.000	0,08-0,16	5.600	0,08-0,16	8.000	0,08-0,16	6.400	0,08-0,16	4.800	0,08-0,16
5	6.400	0,10-0,20	6.400	0,10-0,20	4.500	0,10-0,20	6.400	0,10-0,20	5.100	0,10-0,20	3.800	0,10-0,20
6	5.300	0,12-0,24	5.300	0,12-0,24	3.700	0,12-0,24	5.300	0,12-0,24	4.200	0,12-0,24	3.200	0,12-0,24
7	4.500	0,14-0,26	4.500	0,14-0,26	3.200	0,14-0,26	4.500	0,14-0,26	3.600	0,14-0,26	2.700	0,14-0,26
8	4.000	0,16-0,28	4.000	0,16-0,28	2.800	0,16-0,28	4.000	0,16-0,28	3.200	0,16-0,28	2.400	0,16-0,28
9	3.500	0,18-0,30	3.500	0,18-0,30	2.500	0,18-0,30	3.500	0,18-0,30	2.800	0,18-0,30	2.100	0,18-0,30
10	3.200	0,20-0,30	3.200	0,20-0,30	2.200	0,20-0,30	3.200	0,20-0,30	2.500	0,20-0,30	1.900	0,20-0,30
11	2.900	0,20-0,30	2.900	0,20-0,30	2.000	0,20-0,30	2.900	0,20-0,30	2.300	0,20-0,30	1.700	0,20-0,30
12	2.700	0,21-0,30	2.700	0,21-0,30	1.900	0,21-0,30	2.700	0,21-0,30	2.100	0,21-0,30	1.600	0,21-0,30
13	2.400	0,21-0,33	2.400	0,21-0,33	1.700	0,21-0,33	2.400	0,21-0,33	2.000	0,21-0,33	1.500	0,21-0,33
14	2.300	0,22-0,35	2.300	0,22-0,35	1.600	0,22-0,35	2.300	0,22-0,35	1.800	0,22-0,35	1.400	0,22-0,35
16	2.000	0,25-0,36	2.000	0,25-0,36	1.400	0,25-0,36	2.000	0,25-0,36	1.600	0,25-0,36	1.200	0,25-0,36
18	1.800	0,28-0,38	1.800	0,28-0,38	1.200	0,28-0,38	1.800	0,28-0,38	1.400	0,28-0,38	1.100	0,28-0,38
20	1.600	0,30-0,40	1.600	0,30-0,40	1.100	0,30-0,40	1.600	0,30-0,40	1.300	0,30-0,40	1.000	0,30-0,40

ADO-10D/20D/25D/30D

	Mild Steel - Low Carbon Steel S5400 - S10C ~150HB ~500 N/mm ²		Carbon Steel S35C - S50C ~210HB ~710 N/mm ²		Alloys Steel SCM + SCr + SNCM 16-28HRC 710-900 N/mm ²		Cast Iron FC250 ~350 N/mm ²		Ductile Cast Iron FCD450 - FCD600 400-600 N/mm ²		Stainless Steel SUS400 400 ~ 800 N/mm ²	
Vc	60 ~ 125 m/min		60 ~ 125 m/min		60 ~ 125 m/min		60 ~ 125 m/min		50 ~ 80 m/min		40 ~ 80 m/min	
Ø	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)
3	7.500	0,06-0,12	7.500	0,06-0,12	7.500	0,06-0,12	7.500	0,06-0,12	7.500	0,06-0,12	5.300	0,06-0,12
4	6.400	0,08-0,16	6.400	0,08-0,16	6.400	0,08-0,16	6.400	0,08-0,16	5.600	0,08-0,16	5.000	0,08-0,16
5	5.800	0,10-0,20	5.800	0,10-0,20	5.800	0,10-0,20	5.800	0,10-0,20	4.500	0,10-0,20	4.500	0,10-0,20
6	4.800	0,12-0,24	4.800	0,12-0,24	4.800	0,12-0,24	4.800	0,12-0,24	3.800	0,12-0,24	3.800	0,12-0,24
8	3.600	0,16-0,28	3.600	0,16-0,28	3.600	0,16-0,28	3.600	0,16-0,28	2.800	0,16-0,28	2.800	0,16-0,28
10	2.900	0,20-0,35	2.900	0,20-0,35	2.900	0,20-0,35	2.900	0,20-0,35	2.300	0,20-0,35	2.300	0,20-0,35
12	2.400	0,24-0,42	2.400	0,24-0,42	2.400	0,24-0,42	2.400	0,24-0,42	1.900	0,24-0,42	1.900	0,24-0,42



ADO-40D/50D

	Mild Steel - Low Carbon Steel S5400 - S10C ~150HB ~500 N/mm ²		Carbon Steel S35C - S50C ~210HB ~710 N/mm ²		Alloy Steel SCM - SCr - SNCM 16~28HRC 710 ~900 N/mm ²		Alloy Steel (C≥0.3%) SCM440 28~35HRC 900~1,060N/mm ²	
Vc	60~90m/min		60~90m/min		50~80m/min		40~70m/min	
Ø	S (min ⁻¹)	f (mm/rev.)	S (min ⁻¹)	f (mm/rev.)	S (min ⁻¹)	f (mm/rev.)	S (min ⁻¹)	f (mm/rev.)
3	7.500	0,06 ~ 0,12	7.500	0,06 ~ 0,12	6.400	0,06 ~ 0,12	5.300	0,06 ~ 0,11
4	5.600	0,08 ~ 0,16	5.600	0,08 ~ 0,16	4.800	0,08 ~ 0,16	4.000	0,08 ~ 0,14
5	4.500	0,1 ~ 0,2	4.500	0,1 ~ 0,2	3.800	0,1 ~ 0,2	3.200	0,1 ~ 0,17
6	3.700	0,12 ~ 0,24	3.700	0,12 ~ 0,24	3.200	0,12 ~ 0,24	2.700	0,12 ~ 0,21
8	2.800	0,16 ~ 0,28	2.800	0,16 ~ 0,28	2.400	0,16 ~ 0,28	2.000	0,16 ~ 0,24
10	2.300	0,2 ~ 0,35	2.300	0,2 ~ 0,35	1.900	0,2 ~ 0,35	1.600	0,2 ~ 0,3

	Cast Iron FC250 ~350N/mm ²		Ductile Cast Iron FCD450 - FCD600 400 ~600 N/mm ²		Stainless Steel SUS300/400 480 ~800 N/mm ²	
Vc	60~90m/min		50~80m/min		40~60m/min	
Ø	S (min ⁻¹)	f (mm/rev.)	S (min ⁻¹)	f (mm/rev.)	S (min ⁻¹)	f (mm/rev.)
3	7.500	0,06 ~ 0,12	6.400	0,06 ~ 0,12	5.300	0,06 ~ 0,12
4	5.600	0,08 ~ 0,16	4.800	0,08 ~ 0,16	4.000	0,08 ~ 0,16
5	4.500	0,1 ~ 0,2	3.800	0,1 ~ 0,2	3.200	0,1 ~ 0,2
6	3.700	0,12 ~ 0,24	3.200	0,12 ~ 0,24	2.700	0,12 ~ 0,24
8	2.800	0,16 ~ 0,28	2.400	0,16 ~ 0,28	2.000	0,16 ~ 0,28
10	2.300	0,2 ~ 0,35	1.900	0,2 ~ 0,35	1.600	0,2 ~ 0,35

1. The indicated speeds and feeds are for drilling with water-soluble coolant or MQL (mist drilling in stainless steels is not recommended).
2. Water-soluble high density coolant (20-30 times dilution) is recommended.
3. When using non-water-soluble coolant, set the cutting speed between 70~100% of the lowest limit.
4. Make a pilot hole before using in accordance with the recommended operation.
5. A clogged oil hole can lead to breakage. Make sure that a filter is attached to the oil feeder.
6. Peck drilling of 1D - 2D is strongly recommended.


*If it is difficult to process or if the straightness of the hole needed to be improved, use the coolant-through carbide drill ADO-20/30D after drilling a pilot hole, then process with the ADO-40/50D. When processing with 3 tools, the ADO-40/50D may be used at a more aggressive cutting condition than those listed above.


ADF-2D

	Low Carbon Steel - Alloy Steel (C<0.3%) S5400 - SCM ~710N/mm ²		Carbon Steel S35C - S50C ~210HB ~710N/mm ²		Alloy Steel SCM - SCr - SNCM 28~35HRC 900~1,100N/mm ²		Plastic Mold Steel NAK80 ~40HRC		Stainless Steel SUS304 480 ~ 800N/mm ²	
Vc	30~100m/min		30~100m/min		30~90m/min		20~40m/min		10~30m/min	
Ø	Speed (min ⁻¹)	Feed Rate (mm/rev.)	Speed (min ⁻¹)	Feed Rate (mm/rev.)	Speed (min ⁻¹)	Feed Rate (mm/rev.)	Speed (min ⁻¹)	Feed Rate (mm/rev.)	Speed (min ⁻¹)	Feed Rate (mm/rev.)
0.2	40.000	0,001 ~ 0,006	40.000	0,001 ~ 0,006	40.000	0,001 ~ 0,006	40.000	0,001 ~ 0,004	40.000	0,001 ~ 0,004
0.5	28.700	0,003 ~ 0,015	28.700	0,003 ~ 0,015	25.500	0,003 ~ 0,015	19.000	0,003 ~ 0,01	15.900	0,003 ~ 0,01
1	17.500	0,005 ~ 0,03	17.500	0,005 ~ 0,03	15.900	0,005 ~ 0,03	9.550	0,005 ~ 0,02	8.000	0,005 ~ 0,02
1.5	13.800	0,008 ~ 0,045	13.800	0,008 ~ 0,045	12.700	0,008 ~ 0,045	6.350	0,008 ~ 0,03	5.300	0,008 ~ 0,03
2	12.700	0,01 ~ 0,06	12.700	0,01 ~ 0,06	9.550	0,01 ~ 0,06	4.750	0,01 ~ 0,04	-	-
3	8.500	0,015 ~ 0,09	8.500	0,015 ~ 0,09	6.350	0,015 ~ 0,09	3.200	0,015 ~ 0,06	-	-
4	6.350	0,02 ~ 0,12	6.350	0,02 ~ 0,12	4.750	0,02 ~ 0,12	2.400	0,02 ~ 0,08	-	-
6	4.250	0,03 ~ 0,18	4.250	0,03 ~ 0,18	3.200	0,03 ~ 0,18	1.600	0,03 ~ 0,12	-	-
8	3.200	0,04 ~ 0,24	3.200	0,04 ~ 0,24	2.400	0,04 ~ 0,24	1.200	0,04 ~ 0,16	-	-
10	2.550	0,05 ~ 0,3	2.550	0,05 ~ 0,3	1.900	0,05 ~ 0,3	950	0,05 ~ 0,2	-	-
12	2.100	0,06 ~ 0,3	2.100	0,06 ~ 0,3	1.600	0,06 ~ 0,3	800	0,06 ~ 0,24	-	-
14	1.800	0,07 ~ 0,35	1.800	0,07 ~ 0,35	1.350	0,07 ~ 0,35	700	0,07 ~ 0,28	-	-
16	1.600	0,08 ~ 0,36	1.600	0,08 ~ 0,36	1.200	0,08 ~ 0,36	600	0,08 ~ 0,32	-	-
18	1.400	0,09 ~ 0,38	1.400	0,09 ~ 0,38	1.050	0,09 ~ 0,38	550	0,09 ~ 0,36	-	-
20	1.250	0,1 ~ 0,4	1.250	0,1 ~ 0,4	950	0,1 ~ 0,4	500	0,1 ~ 0,4	-	-

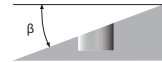
	Special Alloy Steel - Hardened Steel - Prehardened Steel FC250 ~45HRC		Cast Iron FC250 ~350N/mm ²		Ductile Cast Iron FCD600 400 ~600N/mm ²		Aluminium A5052 - A7075 ~350N/mm ²		Aluminium Alloy AC4C - ADC 400~600N/mm ²	
Vc	20~30m/min		30~120m/min		30~80m/min		30~200m/min		30~200m/min	
Ø	Speed (min ⁻¹)	Feed Rate (mm/rev.)	Speed (min ⁻¹)	Feed Rate (mm/rev.)	Speed (min ⁻¹)	Feed Rate (mm/rev.)	Speed (min ⁻¹)	Feed Rate (mm/rev.)	Speed (min ⁻¹)	Feed Rate (mm/rev.)
0.2	40.000	0,001 ~ 0,004	40.000	0,001 ~ 0,006	40.000	0,001 ~ 0,006	40.000	0,001 ~ 0,006	40.000	0,001 ~ 0,006
0.5	15.900	0,003 ~ 0,01	32.000	0,003 ~ 0,015	25.000	0,003 ~ 0,015	35.000	0,003 ~ 0,015	35.000	0,003 ~ 0,015
1	7.950	0,005 ~ 0,02	22.500	0,005 ~ 0,03	15.900	0,005 ~ 0,03	30.000	0,005 ~ 0,03	30.000	0,005 ~ 0,03
1.5	5.300	0,008 ~ 0,03	17.000	0,008 ~ 0,045	11.500	0,008 ~ 0,045	25.000	0,008 ~ 0,045	25.000	0,008 ~ 0,045
2	4.000	0,01 ~ 0,03	14.300	0,01 ~ 0,06	10.350	0,01 ~ 0,06	22.300	0,01 ~ 0,06	22.300	0,01 ~ 0,06
3	2.650	0,015 ~ 0,045	9.550	0,015 ~ 0,09	6.900	0,015 ~ 0,09	14.850	0,015 ~ 0,09	14.850	0,015 ~ 0,09
4	2.000	0,02 ~ 0,06	7.150	0,02 ~ 0,12	5.150	0,02 ~ 0,12	11.150	0,02 ~ 0,12	11.150	0,02 ~ 0,12
6	1.350	0,03 ~ 0,09	4.750	0,03 ~ 0,18	3.450	0,03 ~ 0,18	7.450	0,03 ~ 0,18	7.450	0,03 ~ 0,18
8	1.000	0,04 ~ 0,12	3.600	0,04 ~ 0,24	2.600	0,04 ~ 0,24	5.550	0,04 ~ 0,24	5.550	0,04 ~ 0,24
10	800	0,05 ~ 0,15	2.850	0,05 ~ 0,3	2.050	0,05 ~ 0,3	4.450	0,05 ~ 0,3	4.450	0,05 ~ 0,3
12	650	0,06 ~ 0,18	2.400	0,06 ~ 0,3	1.700	0,06 ~ 0,3	3.700	0,06 ~ 0,36	3.700	0,06 ~ 0,36
14	550	0,07 ~ 0,21	2.050	0,07 ~ 0,35	1.500	0,07 ~ 0,35	3.200	0,07 ~ 0,42	3.200	0,07 ~ 0,42
16	500	0,08 ~ 0,24	1.800	0,08 ~ 0,36	1.300	0,08 ~ 0,36	2.800	0,08 ~ 0,48	2.800	0,08 ~ 0,48
18	450	0,09 ~ 0,27	1.600	0,09 ~ 0,38	1.150	0,09 ~ 0,38	2.500	0,09 ~ 0,54	2.500	0,09 ~ 0,54
20	400	0,1 ~ 0,3	1.450	0,1 ~ 0,4	1.050	0,1 ~ 0,4	2.250	0,1 ~ 0,6	2.250	0,1 ~ 0,6

ADFLS-2D


	Low Carbon Steel - Alloy Steel (C<0.3%)		Carbon Steel		Alloy Steel		Plastic Mold Steel		Special Alloy Steel-Hardened Steel-Pre-hardened steel	
	S5400・SCM ~710N/mm ²		S35C・S50C ~210HB ~710N/mm ²		SCM・SCr・SNCM 28-35HRC 900~1,100N/mm ²		NAK80 ~40HRC		SKD61 ~50HRC	
Vc	60~100m/min		60~100m/min		30~90m/min		20~40m/min		20~30m/min	
Ø	Speed (min ⁻¹)	Feed Rate (mm/rev.)	Speed (min ⁻¹)	Feed Rate (mm/rev.)	Speed (min ⁻¹)	Feed Rate (mm/rev.)	Speed (min ⁻¹)	Feed Rate (mm/rev.)	Speed (min ⁻¹)	Feed Rate (mm/rev.)
3	8.500	0.045 ~ 0.075	8.500	0.045 ~ 0.075	6.350	0.045 ~ 0.075	3.200	0.045 ~ 0.06	2.650	0.03 ~ 0.06
4	6.350	0.06 ~ 0.1	6.350	0.06 ~ 0.1	4.750	0.06 ~ 0.1	2.400	0.06 ~ 0.08	2.000	0.04 ~ 0.08
6	4.250	0.09 ~ 0.15	4.250	0.09 ~ 0.15	3.200	0.09 ~ 0.15	1.600	0.09 ~ 0.12	1.350	0.06 ~ 0.12
8	3.200	0.12 ~ 0.2	3.200	0.12 ~ 0.2	2.400	0.12 ~ 0.2	1.200	0.12 ~ 0.16	1.000	0.08 ~ 0.16
10	2.550	0.15 ~ 0.25	2.550	0.15 ~ 0.25	1.900	0.15 ~ 0.25	950	0.15 ~ 0.2	800	0.1 ~ 0.2
12	2.100	0.18 ~ 0.3	2.100	0.18 ~ 0.3	1.600	0.18 ~ 0.3	800	0.18 ~ 0.24	650	0.12 ~ 0.24
14	1.800	0.21 ~ 0.35	1.800	0.21 ~ 0.35	900	0.21 ~ 0.35	700	0.21 ~ 0.28	550	0.14 ~ 0.28
16	1.600	0.24 ~ 0.4	1.600	0.24 ~ 0.4	800	0.24 ~ 0.4	600	0.24 ~ 0.32	500	0.16 ~ 0.32
18	1.400	0.27 ~ 0.45	1.400	0.27 ~ 0.45	700	0.27 ~ 0.45	550	0.27 ~ 0.36	450	0.18 ~ 0.36
20	1.250	0.3 ~ 0.5	1.250	0.3 ~ 0.5	650	0.3 ~ 0.5	500	0.3 ~ 0.4	400	0.2 ~ 0.4


	Cast Iron		Ductile Cast Iron		Aluminium		Aluminium Alloy	
	FC250 ~350N/mm²		FCD600 400 – 600N/mm²		A5052 • A7075 ~350N/mm²		AC4C • ADC 400 – 600N/mm²	
Vc	60~120m/min		50~80m/min		80~200m/min		80~200m/min	
Ø	Speed (min⁻¹)	Feed Rate (mm/rev.)	Speed (min⁻¹)	Feed Rate (mm/rev.)	Speed (min⁻¹)	Feed Rate (mm/rev.)	Speed (min⁻¹)	Feed Rate (mm/rev.)
3	9.550	0,06 – 0,09	6.900	0,06 – 0,09	14.850	0,015 – 0,09	14.850	0,015 – 0,09
4	7.150	0,08 – 0,12	5.150	0,08 – 0,12	11.150	0,02 – 0,12	11.150	0,02 – 0,12
6	4.750	0,12 – 0,18	3.450	0,12 – 0,18	7.450	0,03 – 0,18	7.450	0,03 – 0,18
8	3.600	0,16 – 0,24	2.600	0,16 – 0,24	5.550	0,04 – 0,24	5.550	0,04 – 0,24
10	2.850	0,2 – 0,3	2.050	0,2 – 0,3	4.450	0,05 – 0,3	4.450	0,05 – 0,3
12	2.400	0,24 – 0,36	1.700	0,24 – 0,36	3.700	0,06 – 0,36	3.700	0,06 – 0,36
14	2.050	0,28 – 0,42	1.500	0,28 – 0,42	3.200	0,07 – 0,42	3.200	0,07 – 0,42
16	1.800	0,32 – 0,48	1.300	0,32 – 0,48	2.800	0,08 – 0,48	2.800	0,08 – 0,48
18	1.600	0,36 – 0,54	1.150	0,36 – 0,54	2.500	0,09 – 0,54	2.500	0,09 – 0,54
20	1.450	0,4 – 0,6	1.050	0,4 – 0,6	2.250	0,1 – 0,6	2.250	0,1 – 0,6

- To process flat surfaces, prior Centre-drilling with a larger diameter is required.
- Water-soluble coolant may be applied as noted in the above table only under the premise that the work surface has been flattened by milling.
- When using non-water soluble oil or water-emulsifiable (over 20 times dilution), reduce cutting speed by 30%.
- Use a rigid and precise machine and holder.
- Please minimize tool hang over as much as possible during machining.
- Adjust the rotational speed and the feed rate in accordance with conditions such as the machining shape, machine rigidity, or work holding.
- Please set up the drill so that the runout of the cutting edge is under 0.01 mm.
- When machining an inclined plane, adjust the rotational speed and the feed rate in accordance with the angle of the incline (β).
- When the machining incline angle(β) is less than 30°, please reduce the feed to 40~60%.
- When the machining incline angle(β) is over 30°, please reduce the speed to 60~80%, the feed to 20~40%.
- Please use step drilling in pilot holes to improve cutting chip separation.
- If it is necessary to ensure the locating precision of the hole to be machined, adjust the rotational speed and the feed rate as indicated above (in accordance with the machining precision requirement).



ADFO-3D

	Low Carbon Steel - Alloy Steel (C<0.3%)		Carbon Steel		Alloy Steel		Plastic Mold Steel		Stainless Steel	
	S5400・SCM ~710N/mm²		S35C・S50C ~210HB ~710N/mm²		SCM・SCr・SNCM 28~35HRC 900~1,100N/mm²		NAK80 ~40HRC		SUS304 480~800N/mm²	
Vc	80~120m/min		80~120m/min		50~90m/min		20~40m/min		40~60m/min	
Ø	Speed (min ⁻¹)	Feed Rate (mm/rev.)	Speed (min ⁻¹)	Feed Rate (mm/rev.)	Speed (min ⁻¹)	Feed Rate (mm/rev.)	Speed (min ⁻¹)	Feed Rate (mm/rev.)	Speed (min ⁻¹)	Feed Rate (mm/rev.)
3	10.600	0.045~0.09	10.600	0.045~0.09	7.450	0.045~0.09	3.200	0.045~0.09	5.300	0.045~0.09
4	8.000	0.045~0.12	8.000	0.045~0.12	5.550	0.045~0.12	2.400	0.045~0.12	4.000	0.045~0.12
6	5.300	0.06~0.18	5.300	0.06~0.18	3.700	0.06~0.18	1.600	0.06~0.18	2.650	0.06~0.18
8	4.000	0.08~0.24	4.000	0.08~0.24	2.800	0.08~0.24	1.200	0.08~0.24	2.000	0.08~0.24
10	3.200	0.10~0.30	3.200	0.10~0.30	2.250	0.10~0.30	950	0.10~0.30	1.600	0.10~0.30
12	2.650	0.12~0.36	2.650	0.12~0.36	1.850	0.12~0.36	800	0.12~0.36	1.350	0.12~0.36
14	2.250	0.14~0.42	2.250	0.14~0.42	1.600	0.14~0.42	700	0.14~0.42	1.150	0.14~0.42
16	2.000	0.16~0.48	2.000	0.16~0.48	1.400	0.16~0.48	600	0.16~0.48	1.000	0.16~0.48
18	1.750	0.18~0.54	1.750	0.18~0.54	1.250	0.18~0.54	550	0.18~0.54	900	0.18~0.54
20	1.600	0.20~0.60	1.600	0.20~0.60	1.100	0.20~0.60	500	0.20~0.60	800	0.20~0.60

	Cast Iron FC250 ~350N/mm ²		Ductile Cast Iron FCD600 400 ~600N/mm ²		Aluminium A5052・A7075 ~350N/mm ²		Aluminium Alloy AC4C・ADC 400~600N/mm ²	
Vc	80~120m/min		60~100m/min		120~200m/min		120~200m/min	
Ø	Speed (min ⁻¹)	Feed Rate (mm/rev.)	Speed (min ⁻¹)	Feed Rate (mm/rev.)	Speed (min ⁻¹)	Feed Rate (mm/rev.)	Speed (min ⁻¹)	Feed Rate (mm/rev.)
3	10.600	0.045 ~ 0.09	8.500	0.045 ~ 0.09	17.000	0.045 ~ 0.09	17.000	0.045 ~ 0.09
4	8.000	0.045 ~ 0.12	6.350	0.045 ~ 0.12	12.750	0.045 ~ 0.12	12.750	0.045 ~ 0.12
6	5.300	0.06 ~ 0.18	4.250	0.06 ~ 0.18	8.500	0.06 ~ 0.18	8.500	0.06 ~ 0.18
8	4.000	0.08 ~ 0.24	3.200	0.08 ~ 0.24	6.350	0.08 ~ 0.24	6.350	0.08 ~ 0.24
10	3.200	0.10 ~ 0.30	2.550	0.10 ~ 0.30	5.100	0.10 ~ 0.30	5.100	0.10 ~ 0.30
12	2.650	0.12 ~ 0.36	2.100	0.12 ~ 0.36	4.250	0.12 ~ 0.36	4.250	0.12 ~ 0.36
14	2.250	0.14 ~ 0.42	1.800	0.14 ~ 0.42	3.650	0.14 ~ 0.42	3.650	0.14 ~ 0.42
16	2.000	0.16 ~ 0.48	1.600	0.16 ~ 0.48	3.200	0.16 ~ 0.48	3.200	0.16 ~ 0.48
18	1.750	0.18 ~ 0.54	1.400	0.18 ~ 0.54	2.850	0.18 ~ 0.54	2.850	0.18 ~ 0.54
20	1.600	0.20 ~ 0.60	1.250	0.20 ~ 0.60	2.550	0.20 ~ 0.60	2.550	0.20 ~ 0.60

See Annexure B on page 134.



AD-LDS / AD-LS-LDS

Centering

	Low Carbon Steel - Mild Steel SS400 ~500N/mm ²		Carbon Steel S50C 500 ~ 710N/mm ²		Alloy Steel SCM 710 ~ 900N/mm ²		Special Alloy Steel-Hardened SKD61 ~28HRC ~900N/mm ²	
Vc	63~80m/min		40~63m/min		32~50m/min		20~30m/min	
Ø	Speed (min ⁻¹)	Feed Rate (mm/rev.)	Speed (min ⁻¹)	Feed Rate (mm/rev.)	Speed (min ⁻¹)	Feed Rate (mm/rev.)	Speed (min ⁻¹)	Feed Rate (mm/rev.)
0.5	20,000	0.005 ~ 0.02	25,000	0.005 ~ 0.02	20,000	0.005 ~ 0.02	16,000	0.005 ~ 0.02
1	10,000	0.01 ~ 0.03	16,000	0.01 ~ 0.03	10,000	0.01 ~ 0.03	8,000	0.01 ~ 0.03
2	5,000	0.03 ~ 0.06	8,000	0.03 ~ 0.06	5,000	0.03 ~ 0.06	4,000	0.03 ~ 0.06
3	7,500	0.04 ~ 0.08	5,500	0.04 ~ 0.08	4,500	0.04 ~ 0.08	2,700	0.04 ~ 0.08
4	5,700	0.05 ~ 0.1	4,100	0.05 ~ 0.1	3,300	0.05 ~ 0.1	2,000	0.05 ~ 0.1
6	3,800	0.06 ~ 0.12	2,700	0.06 ~ 0.12	2,300	0.06 ~ 0.12	1,300	0.06 ~ 0.12
8	2,800	0.08 ~ 0.15	2,000	0.08 ~ 0.15	1,700	0.08 ~ 0.15	1,000	0.08 ~ 0.15
10	2,300	0.1 ~ 0.18	1,700	0.1 ~ 0.18	1,400	0.1 ~ 0.18	800	0.1 ~ 0.18
12	1,900	0.12 ~ 0.21	1,400	0.12 ~ 0.21	1,200	0.12 ~ 0.21	650	0.12 ~ 0.21

	Special Alloy Steel-Hardened SKD11 ~34HRC ~1060N/mm ²		Tool Steel		Cast Iron - Ductile cast iron FCD250-FC400 ~ 500N/mm ²		Aluminium - Alloy Casting ADC - AC4D	
Vc	16~22m/min		16~22m/min		63~100m/min		80~160m/min	
Ø	Speed (min ⁻¹)	Feed Rate (mm/rev.)	Speed (min ⁻¹)	Feed Rate (mm/rev.)	Speed (min ⁻¹)	Feed Rate (mm/rev.)	Speed (min ⁻¹)	Feed Rate (mm/rev.)
0.5	12,000	0.005 ~ 0.02	12,000	0.005 ~ 0.02	Note 2.	0.005 ~ 0.015	Note 2.	0.02 ~ 0.04
1	6,000	0.01 ~ 0.03	6,000	0.01 ~ 0.03	20,000	0.01 ~ 0.03	Note 2.	0.04 ~ 0.07
2	3,000	0.03 ~ 0.06	3,000	0.03 ~ 0.06	12,000	0.03 ~ 0.06	15,000	0.06 ~ 0.14
3	2,000	0.04 ~ 0.08	2,000	0.04 ~ 0.08	8,000	0.05 ~ 0.09	12,000	0.1 ~ 0.22
4	1,500	0.05 ~ 0.1	1,500	0.05 ~ 0.1	6,500	0.07 ~ 0.12	9,500	0.12 ~ 0.25
6	1,000	0.06 ~ 0.12	1,000	0.06 ~ 0.12	4,300	0.12 ~ 0.18	6,400	0.14 ~ 0.28
8	750	0.08 ~ 0.15	750	0.08 ~ 0.15	3,200	0.13 ~ 0.2	4,800	0.18 ~ 0.32
10	600	0.1 ~ 0.18	600	0.1 ~ 0.18	2,600	0.17 ~ 0.25	3,800	0.22 ~ 0.36
12	500	0.12 ~ 0.21	500	0.12 ~ 0.21	2,200	0.21 ~ 0.3	3,200	0.25 ~ 0.4

Note1. When using AD-LS-LDS, reduce the feed rate accordingly.

Note2. For machines that cannot achieve the speeds indicated in the table please set rotation as high as possible.

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

2. When using non-water-soluble coolant, reduce the drilling speed by 20%.

3. When centering on a curved or inclined surface, reduce the feed rate accordingly.

4. Centering on Austenitic Stainless Steels is not recommended. For these procedures, use the TIN-NC-LDS or the NC-LDS.

AD-LDS / AD-LS-LDS

Counter Sinking

	Low Carbon Steel - Mild Steel SS400 ~500N/mm ²		Carbon Steel S50C 500 ~ 710N/mm ²		Alloy Steel SCM 710 ~ 900N/mm ²		Special Alloy Steel-Hardened SKD61 ~28HRC ~900N/mm ²	
Vc	63~80m/min		40~63m/min		32~50m/min		20~30m/min	
Ø	Speed (min ⁻¹)	Feed Rate (mm/rev.)	Speed (min ⁻¹)	Feed Rate (mm/rev.)	Speed (min ⁻¹)	Feed Rate (mm/rev.)	Speed (min ⁻¹)	Feed Rate (mm/rev.)
0.5	20,000	0.005 ~ 0.05	25,000	0.005 ~ 0.05	20,000	0.005 ~ 0.05	16,000	0.005 ~ 0.05
1	10,000	0.01 ~ 0.1	16,000	0.01 ~ 0.1	10,000	0.01 ~ 0.1	8,000	0.01 ~ 0.01
2	5,000	0.02 ~ 0.18	8,000	0.02 ~ 0.18	5,000	0.02 ~ 0.18	4,000	0.02 ~ 0.18
3	7,500	0.04 ~ 0.24	5,500	0.04 ~ 0.24	4,500	0.04 ~ 0.24	2,700	0.04 ~ 0.24
4	5,700	0.04 ~ 0.24	4,100	0.04 ~ 0.24	3,300	0.04 ~ 0.24	2,000	0.04 ~ 0.24
6	3,800	0.06 ~ 0.36	2,700	0.06 ~ 0.36	2,300	0.06 ~ 0.36	1,300	0.06 ~ 0.36
8	2,800	0.08 ~ 0.38	2,000	0.08 ~ 0.38	1,700	0.08 ~ 0.38	1,000	0.08 ~ 0.38
10	2,300	0.1 ~ 0.4	1,700	0.1 ~ 0.4	1,400	0.1 ~ 0.4	800	0.1 ~ 0.4
12	1,900	0.12 ~ 0.42	1,400	0.12 ~ 0.42	1,200	0.12 ~ 0.42	650	0.12 ~ 0.42

	Special Alloy Steel-Hardened SKD11 ~34HRC ~1060N/mm ²		Quenched and Tempered Steel 45~50HRC		Cast Iron - Ductile cast iron FCD250-FC400 ~ 500N/mm ²		Aluminium - Alloy Casting ADC - AC4D	
Vc	20~30m/min		20~30m/min		63~100m/min		80~160m/min	
Ø	Speed (min ⁻¹)	Feed Rate (mm/rev.)	Speed (min ⁻¹)	Feed Rate (mm/rev.)	Speed (min ⁻¹)	Feed Rate (mm/rev.)	Speed (min ⁻¹)	Feed Rate (mm/rev.)
0.5	16,000	0.005 ~ 0.05	16,000	0.005 ~ 0.02	Note 2.	0.005 ~ 0.05	Note 2.	0.005 ~ 0.05
1	8,000	0.01 ~ 0.1	8,000	0.01 ~ 0.03	20,000	0.01 ~ 0.1	Note 2.	0.01 ~ 0.1
2	4,000	0.02 ~ 0.18	4,000	0.03 ~ 0.06	12,000	0.02 ~ 0.18	15,000	0.02 ~ 0.18
3	2,700	0.04 ~ 0.24	2,700	0.04 ~ 0.08	8,000	0.04 ~ 0.24	12,000	0.04 ~ 0.24
4	2,000	0.04 ~ 0.24	2,000	0.05 ~ 0.1	6,500	0.04 ~ 0.24	9,500	0.04 ~ 0.24
6	1,300	0.06 ~ 0.36	1,300	0.06 ~ 0.12	4,300	0.06 ~ 0.36	6,400	0.06 ~ 0.36
8	1,000	0.08 ~ 0.38	1,000	0.08 ~ 0.15	3,200	0.08 ~ 0.38	4,800	0.08 ~ 0.38
10	800	0.1 ~ 0.4	800	0.1 ~ 0.18	2,600	0.1 ~ 0.4	3,800	0.1 ~ 0.4
12	650	0.12 ~ 0.42	650	0.12 ~ 0.21	2,200	0.12 ~ 0.42	3,200	0.12 ~ 0.42

Note1) When using AD-LS-LDS, reduce the feed rate accordingly.

Note2) For machines that cannot achieve the speeds indicated in the table please set rotation as high as possible.

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

2. When using non-water-soluble coolant, reduce the drilling speed by 20%.

3. When counter sinking on a curved or inclined surface, reduce the feed rate accordingly.

4. For high-speed machining, double the median value of the above cutting condition to use as upper limit.

ADO-TRS-3D/5D

Vc	Mild Steel - Low Carbon Steel S5400 - S10C ~150HB ~500 N/mm ²		Carbon Steel S35C - S50C ~210HB ~710 N/mm ²		Alloy Steel SCM - SCr - SNCM 710 ~900 N/mm ²	
	80 ~ 120 m/min		80 ~ 120 m/min		60 ~ 100 m/min	
Ø	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)
3	10.000	0,11 ~ 0,15	10.000	0,11 ~ 0,15	8.500	0,11 ~ 0,15
4	8.000	0,14 ~ 0,2	8.000	0,14 ~ 0,2	6.400	0,14 ~ 0,2
5	6.400	0,18 ~ 0,25	6.400	0,18 ~ 0,25	5.100	0,18 ~ 0,25
6	5.300	0,21 ~ 0,3	5.300	0,21 ~ 0,3	4.200	0,21 ~ 0,3
7	4.500	0,25 ~ 0,35	4.500	0,25 ~ 0,35	3.600	0,25 ~ 0,35
8	4.000	0,28 ~ 0,4	4.000	0,28 ~ 0,4	3.200	0,28 ~ 0,4
9	3.500	0,32 ~ 0,45	3.500	0,32 ~ 0,45	2.800	0,32 ~ 0,45
10	3.200	0,35 ~ 0,5	3.200	0,35 ~ 0,5	2.500	0,35 ~ 0,5
11	2.900	0,39 ~ 0,55	2.900	0,39 ~ 0,55	2.300	0,39 ~ 0,55
12	2.700	0,42 ~ 0,6	2.700	0,42 ~ 0,6	2.100	0,42 ~ 0,6
13	2.400	0,46 ~ 0,65	2.400	0,46 ~ 0,65	2.000	0,46 ~ 0,65
14	2.300	0,49 ~ 0,7	2.300	0,49 ~ 0,7	1.800	0,49 ~ 0,7
15	2.100	0,53 ~ 0,75	2.100	0,53 ~ 0,7	1.700	0,53 ~ 0,7
16	2.000	0,56 ~ 0,8	2.000	0,56 ~ 0,72	1.600	0,56 ~ 0,72
17	1.900	0,6 ~ 0,85	1.900	0,6 ~ 0,77	1.500	0,6 ~ 0,77
18	1.800	0,63 ~ 0,9	1.800	0,63 ~ 0,81	1.400	0,63 ~ 0,81
19	1.700	0,67 ~ 0,9	1.700	0,67 ~ 0,86	1.300	0,67 ~ 0,86
20	1.600	0,7 ~ 0,9	1.600	0,7 ~ 0,9	1.300	0,7 ~ 0,9

Vc	Alloy Steel SCM - SCr - SNCM 900 ~1.100 N/mm ²		Cast Iron FC250 ~350N/mm ²		Ductile Cast Iron FCD450 - FCD600 400 ~600 N/mm ²	
	60 ~ 90 m/min		80 ~ 120 m/min		60 ~ 100 m/min	
Ø	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)
3	8.000	0,11 ~ 0,15	10.000	0,11 ~ 0,18	8.500	0,11 ~ 0,15
4	6.000	0,14 ~ 0,2	8.000	0,14 ~ 0,24	6.400	0,14 ~ 0,2
5	4.800	0,18 ~ 0,25	6.400	0,18 ~ 0,3	5.100	0,18 ~ 0,25
6	4.000	0,21 ~ 0,3	5.300	0,21 ~ 0,36	4.200	0,21 ~ 0,3
7	3.400	0,25 ~ 0,35	4.500	0,25 ~ 0,42	3.600	0,25 ~ 0,35
8	3.000	0,28 ~ 0,4	4.000	0,28 ~ 0,48	3.200	0,28 ~ 0,4
9	2.700	0,32 ~ 0,45	3.500	0,32 ~ 0,54	2.800	0,32 ~ 0,45
10	2.400	0,35 ~ 0,5	3.200	0,35 ~ 0,6	2.500	0,35 ~ 0,5
11	2.200	0,39 ~ 0,55	2.900	0,39 ~ 0,66	2.300	0,39 ~ 0,55
12	2.000	0,42 ~ 0,6	2.700	0,42 ~ 0,72	2.100	0,42 ~ 0,6
13	1.800	0,46 ~ 0,65	2.400	0,46 ~ 0,78	2.000	0,46 ~ 0,65
14	1.700	0,49 ~ 0,7	2.300	0,49 ~ 0,84	1.800	0,49 ~ 0,7
15	1.600	0,53 ~ 0,70	2.100	0,53 ~ 0,75	1.700	0,53 ~ 0,7
16	1.500	0,56 ~ 0,72	2.000	0,56 ~ 0,8	1.600	0,56 ~ 0,72
17	1.400	0,6 ~ 0,77	1.900	0,6 ~ 0,85	1.500	0,6 ~ 0,77
18	1.300	0,63 ~ 0,81	1.800	0,63 ~ 0,9	1.400	0,63 ~ 0,81
19	1.300	0,67 ~ 0,86	1.700	0,67 ~ 0,95	1.300	0,67 ~ 0,86
20	1.200	0,7 ~ 0,9	1.600	0,7 ~ 1	1.300	0,7 ~ 0,9

See Annexure C on page 134.

TRS-HO-10D

Vc	Mild Steel - Low Carbon Steel St-52 ~150HB ~500 N/mm ²		Carbon Steel C45 ~210HB ~710 N/mm ²		Alloys Steel 42CrMo4 16-28HRC 710~900 N/mm ²		Alloys Steel 42CrMo4 16-28HRC 900~110 N/mm ²		Cast Iron GG-25 ~350 N/mm ²		Ductile Cast Iron GGG-60 400~600 N/mm ²	
	80 ~ 120 m/min		80 ~ 120 m/min		60 ~ 100 m/min		60 ~ 90 m/min		80 ~ 150 m/min		60 ~ 120 m/min	
	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)	S (min ⁻¹)	F (mm/rev.)
Ø	10D	10D	10D	10D	10D	10D	10D	10D	10D	10D	10D	10D
5	6.400	0,18 ~ 0,25	6.400	0,18 ~ 0,25	4.800	0,18 ~ 0,25	5.700	0,18 ~ 0,25	6.400	0,18 ~ 0,30	6.400	0,18 ~ 0,25
6	5.300	0,21 ~ 0,30	5.300	0,21 ~ 0,30	4.000	0,21 ~ 0,30	4.800	0,21 ~ 0,30	5.300	0,21 ~ 0,36	5.300	0,21 ~ 0,30
7	4.500	0,25 ~ 0,35	4.500	0,25 ~ 0,35	3.400	0,25 ~ 0,35	4.100	0,25 ~ 0,35	4.500	0,25 ~ 0,42	4.500	0,25 ~ 0,35
8	4.000	0,28 ~ 0,40	4.000	0,28 ~ 0,40	3.000	0,28 ~ 0,40	3.600	0,28 ~ 0,40	4.000	0,28 ~ 0,48	4.000	0,28 ~ 0,40
9	3.500	0,32 ~ 0,45	3.500	0,32 ~ 0,45	2.700	0,32 ~ 0,45	3.200	0,32 ~ 0,45	3.500	0,32 ~ 0,54	3.500	0,32 ~ 0,45
10	3.200	0,35 ~ 0,50	3.200	0,35 ~ 0,50	2.400	0,35 ~ 0,50	2.900	0,35 ~ 0,50	3.200	0,35 ~ 0,60	3.200	0,35 ~ 0,50
11	2.900	0,39 ~ 0,55	2.900	0,39 ~ 0,55	2.200	0,39 ~ 0,50	2.600	0,39 ~ 0,50	2.900	0,39 ~ 0,66	2.900	0,39 ~ 0,55
12	2.700	0,42 ~ 0,60	2.700	0,42 ~ 0,60	2.000	0,42 ~ 0,54	2.400	0,42 ~ 0,54	2.700	0,42 ~ 0,72	2.700	0,42 ~ 0,60
13	-	0,46 ~ 0,65	-	0,46 ~ 0,65	1.800	0,46 ~ 0,59	-	0,46 ~ 0,59	-	0,46 ~ 0,78	-	0,46 ~ 0,65
14	-	0,49 ~ 0,70	-	0,49 ~ 0,70	1.700	0,49 ~ 0,63	-	0,49 ~ 0,63	-	0,49 ~ 0,84	-	0,49 ~ 0,70
16	-	0,48 ~ 0,72	-	0,48 ~ 0,72	1.500	0,48 ~ 0,64	-	0,48 ~ 0,64	-	0,56 ~ 0,80	-	0,48 ~ 0,72
18	-	0,54 ~ 0,81	-	0,54 ~ 0,81	1.300	0,54 ~ 0,72	-	0,54 ~ 0,72	-	0,63 ~ 0,90	-	0,54 ~ 0,81



P2D & P3D

	Work Material	Tensile Strength/ Hardness	Vc (m/min)	Feed Rate (mm/rev)							
				ø12~ø14.5	ø15~ø16.5	ø17~ø18.5	ø19~ø20.5	ø21~ø24.5	ø25~ø28.5	ø29~ø33.5	ø34~ø63
P	Mild Steel-Carbon Steel (S5400-S10C)	~180HB	200 (150~250)	0.06 (0.04~0.08)	0.06 (0.04~0.1)	0.06 (0.04~0.1)	0.07 (0.04~0.1)	0.08 (0.04~0.12)	0.08 (0.04~0.12)	0.1 (0.05~0.15)	0.1 (0.05~0.18)
	Carbon Steel-Alloy Steel (S50C-SCM440)	~280HB	150 (100~220)	0.08 (0.04~0.12)	0.08 (0.04~0.14)	0.09 (0.04~0.16)	0.1 (0.04~0.18)	0.14 (0.04~0.2)	0.18 (0.06~0.25)	0.2 (0.08~0.3)	0.2 (0.08~0.35)
M	Die Steel (SKD11-SKD61)	~280HB	120 (80~180)	0.06 (0.04~0.1)	0.06 (0.04~0.1)	0.07 (0.04~0.1)	0.08 (0.04~0.12)	0.12 (0.04~0.15)	0.14 (0.06~0.2)	0.18 (0.08~0.25)	0.18 (0.08~0.25)
	Stainless Steel (SUS304-SUS420)	~250HB	130 (80~180)	0.07 (0.04~0.1)	0.07 (0.04~0.1)	0.08 (0.04~0.1)	0.09 (0.04~0.12)	0.1 (0.04~0.15)	0.13 (0.06~0.2)	0.15 (0.08~0.25)	0.15 (0.08~0.25)
K	Cast Iron (FC250)	~350N/mm ²	200 (150~280)	0.08 (0.04~0.14)	0.08 (0.04~0.14)	0.1 (0.04~0.16)	0.12 (0.04~0.2)	0.16 (0.08~0.25)	0.2 (0.06~0.3)	0.2 (0.08~0.3)	0.2 (0.08~0.35)
	Ductile Cast Iron (FCD400)	~800N/mm ²	160 (100~220)	0.08 (0.04~0.1)	0.08 (0.04~0.12)	0.09 (0.04~0.14)	0.1 (0.04~0.18)	0.14 (0.04~0.2)	0.18 (0.06~0.25)	0.18 (0.08~0.25)	0.18 (0.08~0.25)
N	Aluminium Alloy	~13%Si	200 (100~800)	0.08 (0.04~0.12)	0.08 (0.04~0.12)	0.1 (0.04~0.16)	0.12 (0.04~0.2)	0.16 (0.04~0.25)	0.2 (0.06~0.3)	0.2 (0.08~0.3)	0.2 (0.08~0.3)
	Heat Resistant Alloy (Wet) (Inconel 718)	—	30 (15~50)	0.04 (0.02~0.06)	0.04 (0.02~0.06)	0.05 (0.03~0.06)	0.05 (0.03~0.06)	0.06 (0.04~0.08)	0.08 (0.06~0.1)	0.1 (0.06~0.12)	0.1 (0.06~0.12)
S	Titanium Alloy (Wet) (Ti-6Al-4V)	—	60 (30~100)	0.05 (0.04~0.08)	0.05 (0.04~0.08)	0.06 (0.04~0.08)	0.06 (0.04~0.08)	0.08 (0.04~0.15)	0.1 (0.06~0.2)	0.14 (0.08~0.2)	0.14 (0.08~0.2)
	Pre-hardened Steel NAK80	40~43HRC	100 (60~120)	0.06 (0.04~0.1)	0.06 (0.04~0.1)	0.06 (0.04~0.12)	0.07 (0.04~0.12)	0.08 (0.04~0.12)	0.1 (0.06~0.15)	0.1 (0.06~0.15)	0.1 (0.06~0.15)
H	Hardened Steel SKD11	50~55HRC	60 (40~80)	0.05 (0.04~0.08)	0.05 (0.04~0.08)	0.05 (0.04~0.08)	0.06 (0.04~0.08)	0.06 (0.04~0.08)	0.06 (0.04~0.1)	0.08 (0.04~0.1)	0.08 (0.04~0.1)

P4D

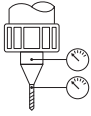
	Work Material	Tensile Strength/ Hardness	Vc (m/min)	Feed Rate (mm/rev)							
				ø12~ø14.5	ø15~ø16.5	ø17~ø18.5	ø19~ø20.5	ø21~ø24.5	ø25~ø28.5	ø29~ø33.5	ø34~ø63
P	Mild Steel-Carbon Steel (S5400-S10C)	~180HB	200 (150~250)	0.06 (0.04~0.08)	0.06 (0.04~0.08)	0.06 (0.04~0.08)	0.07 (0.04~0.1)	0.08 (0.04~0.12)	0.08 (0.04~0.12)	0.1 (0.05~0.15)	0.1 (0.05~0.18)
	Carbon Steel-Alloy Steel (S50C-SCM440)	~280HB	150 (100~220)	0.07 (0.04~0.1)	0.08 (0.04~0.14)	0.08 (0.04~0.16)	0.09 (0.04~0.18)	0.12 (0.04~0.15)	0.18 (0.06~0.25)	0.2 (0.08~0.25)	0.2 (0.08~0.3)
M	Die Steel (SKD11-SKD61)	~280HB	120 (80~180)	0.06 (0.04~0.08)	0.06 (0.04~0.1)	0.07 (0.04~0.1)	0.08 (0.04~0.12)	0.1 (0.04~0.13)	0.14 (0.06~0.2)	0.18 (0.08~0.25)	0.18 (0.08~0.25)
	Stainless Steel (SUS304-SUS420)	~250HB	130 (80~180)	0.06 (0.04~0.08)	0.06 (0.04~0.08)	0.07 (0.04~0.1)	0.08 (0.04~0.1)	0.08 (0.04~0.1)	0.13 (0.06~0.2)	0.15 (0.08~0.2)	0.15 (0.08~0.2)
K	Cast Iron (FC250)	~350N/mm ²	200 (150~280)	0.08 (0.04~0.12)	0.08 (0.04~0.14)	0.09 (0.04~0.16)	0.1 (0.04~0.2)	0.12 (0.04~0.15)	0.2 (0.06~0.3)	0.2 (0.08~0.3)	0.2 (0.08~0.3)
	Ductile Cast Iron (FCD400)	~800N/mm ²	160 (100~220)	0.08 (0.04~0.1)	0.08 (0.04~0.1)	0.08 (0.04~0.12)	0.09 (0.04~0.15)	0.12 (0.04~0.15)	0.15 (0.06~0.25)	0.18 (0.08~0.25)	0.18 (0.08~0.25)
N	Aluminium Alloy	~13%Si	200 (100~800)	0.07 (0.04~0.12)	0.07 (0.04~0.12)	0.09 (0.04~0.12)	0.12 (0.04~0.2)	0.14 (0.04~0.2)	0.2 (0.06~0.3)	0.2 (0.08~0.3)	0.2 (0.08~0.3)
	Heat Resistant Alloy (Wet) (Inconel 718)	—	30 (15~50)	0.04 (0.02~0.06)	0.04 (0.02~0.06)	0.04 (0.02~0.06)	0.05 (0.02~0.06)	0.05 (0.04~0.08)	0.07 (0.06~0.1)	0.08 (0.06~0.12)	0.08 (0.06~0.12)
S	Titanium Alloy (Wet) (Ti-6Al-4V)	—	60 (30~100)	0.05 (0.04~0.08)	0.05 (0.04~0.08)	0.06 (0.04~0.08)	0.06 (0.04~0.08)	0.08 (0.04~0.1)	0.1 (0.06~0.2)	0.14 (0.08~0.2)	0.14 (0.08~0.2)
	Pre-hardened Steel NAK80	40~43HRC	100 (60~120)	0.06 (0.04~0.1)	0.06 (0.04~0.1)	0.06 (0.04~0.1)	0.06 (0.04~0.1)	0.08 (0.04~0.12)	0.08 (0.06~0.12)	0.1 (0.06~0.13)	0.1 (0.06~0.13)
H	Hardened Steel SKD11	50~55HRC	60 (40~80)	0.05 (0.04~0.08)	0.05 (0.04~0.08)	0.05 (0.04~0.08)	0.06 (0.04~0.08)	0.06 (0.04~0.08)	0.08 (0.04~0.1)	0.08 (0.04~0.1)	0.08 (0.04~0.1)

PHP instructions also valid for P2D

P5D

	Work Material	Tensile Strength/ Hardness	Vc (m/min)	Feed Rate (mm/rev)							
				ø12~ø14.5	ø15~ø16.5	ø17~ø18.5	ø19~ø20.5	ø21~ø24.5	ø25~ø28.5	ø29~ø33.5	ø34~ø63
P	Mild Steel-Carbon Steel (S5400-S10C)	~180HB	200 (150~250)	0.05 (0.04~0.08)	0.05 (0.04~0.08)	0.06 (0.04~0.08)	0.07 (0.04~0.1)	0.08 (0.04~0.12)	0.08 (0.04~0.12)	0.1 (0.05~0.15)	0.1 (0.05~0.18)
	Carbon Steel-Alloy Steel (S50C-SCM440)	~280HB	150 (100~220)	0.06 (0.04~0.09)	0.06 (0.04~0.09)	0.06 (0.04~0.12)	0.08 (0.04~0.14)	0.08 (0.04~0.15)	0.12 (0.06~0.2)	0.18 (0.08~0.2)	0.18 (0.08~0.25)
M	Die Steel (SKD11-SKD61)	~280HB	120 (80~180)	0.06 (0.04~0.08)	0.06 (0.04~0.08)	0.06 (0.04~0.08)	0.07 (0.04~0.1)	0.1 (0.04~0.13)	0.12 (0.06~0.15)	0.15 (0.08~0.18)	0.16 (0.08~0.22)
	Stainless Steel (SUS304-SUS420)	~250HB	130 (80~180)	0.06 (0.04~0.08)	0.06 (0.04~0.08)	0.06 (0.04~0.08)	0.07 (0.04~0.09)	0.08 (0.04~0.1)	0.1 (0.06~0.15)	0.12 (0.06~0.18)	0.12 (0.06~0.2)
K	Cast Iron (FC250)	~350N/mm ²	200 (150~280)	0.06 (0.04~0.1)	0.06 (0.04~0.1)	0.08 (0.04~0.12)	0.08 (0.04~0.13)	0.08 (0.04~0.15)	0.12 (0.06~0.2)	0.18 (0.08~0.2)	0.18 (0.08~0.25)
	Ductile Cast Iron (FCD400)	~800N/mm ²	160 (100~220)	0.06 (0.04~0.09)	0.06 (0.04~0.09)	0.08 (0.04~0.12)	0.08 (0.04~0.12)	0.1 (0.04~0.13)	0.12 (0.06~0.15)	0.15 (0.08~0.18)	0.18 (0.08~0.25)
N	Aluminium Alloy	~13%Si	200 (100~800)	0.06 (0.04~0.1)	0.06 (0.04~0.1)	0.09 (0.04~0.12)	0.12 (0.04~0.15)	0.15 (0.04~0.15)	0.2 (0.06~0.25)	0.2 (0.08~0.3)	0.2 (0.08~0.3)
	Heat Resistant Alloy (Wet) (Inconel 718)	—	30 (15~50)	0.04 (0.02~0.06)	0.04 (0.02~0.06)	0.04 (0.02~0.06)	0.04 (0.02~0.06)	0.04 (0.02~0.06)	0.06 (0.06~0.08)	0.07 (0.06~0.08)	0.07 (0.06~0.08)
S	Titanium Alloy (Wet) (Ti-6Al-4V)	—	60 (30~100)	0.05 (0.04~0.08)	0.05 (0.04~0.08)	0.06 (0.04~0.08)	0.06 (0.04~0.08)	0.06 (0.04~0.1)	0.08 (0.06~0.15)	0.1 (0.08~0.15)	0.1 (0.08~0.15)
	Pre-hardened Steel NAK80	40~43HRC	100 (60~120)	0.06 (0.04~0.08)	0.06 (0.04~0.08)	0.06 (0.04~0.08)	0.06 (0.04~0.08)	0.08 (0.04~0.1)	0.08 (0.06~0.12)	0.1 (0.06~0.12)	0.1 (0.06~0.12)
H	Hardened Steel SKD11	50~55HRC	60 (40~80)	0.05 (0.04~0.07)	0.05 (0.04~0.07)	0.05 (0.04~0.07)	0.06 (0.04~0.07)	0.06 (0.04~0.08)	0.06 (0.04~0.1)	0.08 (0.04~0.1)	0.08 (0.04~0.1)

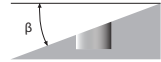
ANNEXURE A



1. This cutting condition chart is based on the usage of **water-soluble coolant and internal oil supply**.
2. Please use quality water-soluble coolant with a dilution factor of approximately 20 times.
3. Please use a precision filter (approximation of 3µm to 5µm) to prevent the oil holes from clogging.
4. Although the recommended coolant pressure is 3 MPa or more, please adjust accordingly if the level of flow volume is unsatisfactory due to the type and concentration of cutting oil used.
5. For accurate mounting, acceptable deflection of the body cylindrical part at the shank end should be **less than 0.002µm**, as shown in the illustrated figure.
6. For work material with poor chip evacuation characteristic, please perform step drilling as required.
7. For holes deeper than 12D, please use a 2D type drill to prepare a pilot hole prior to processing.
8. Please always use the appropriate cutting fluid recommended by the cutting fluid manufacturer in the machining of magnesium alloys. Be cautious with the cutting chips as they are highly flammable and may pose a serious fire risk if not properly handled.

ANNEXURE B

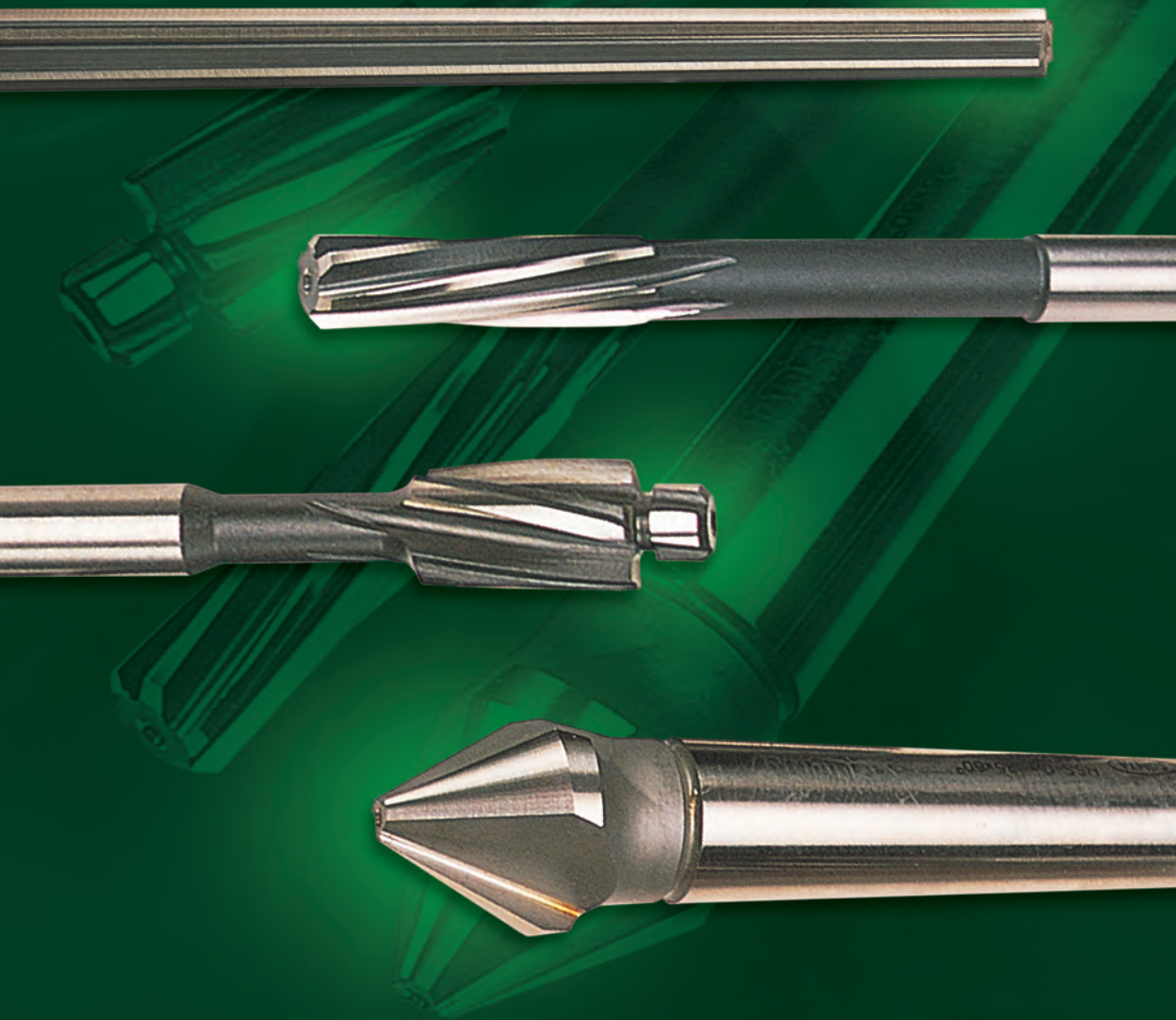
1. Water-soluble coolant may be applied as noted in the above table only under the premise that the work surface has been flattened by milling.
2. Use a rigid and precise machine and holder.
3. Please minimize overhang length as much as possible during machining.
4. Adjust the rotational speed and the feed in accordance with conditions such as the machining shape, machine rigidity, or work holding.
5. Please set up the drill so that the runout of the cutting edge is under 0.02 mm.
6. Please select a cutting fluid that is most suitable for the work material with minimal smoke formation.
7. In the case of dry machining, please use air blow to remove chips to prevent clogging.
Please do not machine stainless steel dry.
8. When machining an inclined plane, adjust the rotational speed and the feed in accordance with the angle of the incline (β).
When the machining incline angle (β) is less than 30°, please reduce the feed to 40-60%.
When the machining incline angle (β) is over 30°, please reduce the speed to 60-80%, the feed to 20-40%.
9. Please use step drilling in pilot holes to improve cutting chip separation.
10. If it is necessary to ensure the locating precision of the hole to be machined, adjust the rotational speed and the feed as indicated above (in accordance with the machining precision requirement).
11. Please always use the appropriate cutting fluid recommended by the cutting fluid manufacturer in the machining of magnesium alloys. Be cautious with the cutting chips as they are highly flammable and may pose a serious fire risk if not properly handled.



ANNEXURE C

1. The indicated speeds and feeds are for drilling with **water-soluble coolant**.
2. Water-soluble high density coolant (less than 20 times dilution) is recommended.
3. When using non-water-soluble or water-soluble coolant (over 20 times dilution), reduce cutting speed by 30%.
4. Equip the drill with a scratch- and dust-free collet and **minimize drill deflection to less than 0.02mm**.
5. Fasten the work material to reduce the possibility of work deformation, deflection of machined surface, or vibration.
6. A clogged oil hole can lead to breakage. Make sure that a filter is attached to the oil feeder.





shaping your dreams



OSG GROUP COMPANY

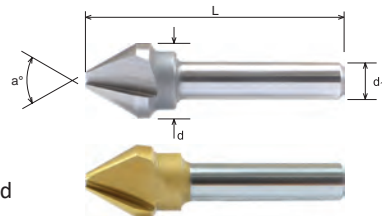
REAMERS, COUNTERSINKS & COUNTERBORES

Codes

761, 763

Properties

mm	DIN 334C 761	DIN 335C 763
HSS Co5	60° & 90°	UNCOATED TiN
pg 147		



Parallel Shank Countersinks

To produce a countersink suitable for countersunk head screws, also used as a deburring tool.

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	○	○	○	○	●	●	●	●							●	●	●	●	●	●	●	●	●	●					

d	d ₁	L	Uncoated		TiN Coated	
			Code	Price	Code	Price
a° = 60°						
6.3	5	45	7610630		7610630T	
8	6	50	7610800		7610800T	
10	6	50	7611000		7611000T	
12.5	8	56	7611250		7611250T	
16	10	63	7611600		7611600T	
20	10	67	7612000		7612000T	
25	10	71	7612500		7612500T	

a° = 90°						
6.3	5	45	7630630		7630630T	
8	6	50	7630800		7630800T	
10	6	50	7631000		7631000T	
12.5	8	56	7631250		7631250T	
16	10	60	7631600		7631600T	
20	10	63	7632000		7632000T	
25	10	67	7632500		7632500T	

Description	Code	Price
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Parallel Shank Countersink Set - TiN Coated

7630000T

THIS SET CONTAINS:

6.3mm - 7630630T, 10.0mm - 7631000T,

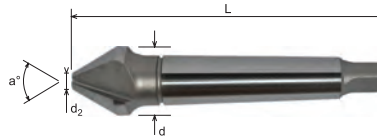
12.5mm - 7631250T, 16.0mm - 7631600T,

20.0mm - 7632000T



MTS Countersinks

To produce a countersink suitable for countersunk head screws, also used as a deburring tool.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

d	a° = 60°				a° = 90°			
	d ₂	L	Code	Price	d ₂	L	Code	Price
No. 1 Morse Taper Shank								
16	4	90	7711600		3.2	85	7731600	
No. 2 Morse Taper Shank								
20	5	106	7712000		3.5	100	7732000	
25	6.3	112	7712500		3.8	106	7732500	
31.5	10	118	7713150		4.2	112	7733150	
No. 3 Morse Taper Shank								
40	12.5	150	7714000		10	140	7734000	
50	16	160	7715000		14	150	7735000	
No. 4 Morse Taper Shank								
63	20	190	7716300		16	180	7736300	
80	25	200	7718000		22	190	7738000	



Codes

771, 773

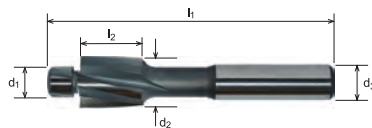
Properties

mm	DIN 334D 771	DIN 335D 773
HSS Co5	60° & 90°	MTS 1 - 4
pg 148		



Parallel Shank Counterbores

For counterboring holes to suit capscrew heads.



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	○	○	○	●	○			●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	●	●	○	○	●	○				

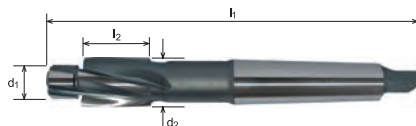
To suit Capscrew	d ₂	d ₃	l ₂	l ₁	Medium			Fine		
					d ₁	Code	Price	d ₁	Code	Price
M3	6	5	14	71	3.4	7740300		3.2	7740301	
M3.5	6.5	5	14	71	3.9	7740350		3.7	7740351	
M4	8	5	14	71	4.5	7740400		4.3	7740401	
M5	10	8	18	80	5.5	7740500		5.3	7740501	
M6	11	8	18	80	6.6	7740600		6.4	7740601	
M8	15	12.5	22	100	9	7740800		8.4	7740801	
M10	18	12.5	22	100	11	7741000		10.5	7741001	
M12	20	12.5	22	100	14	7741200		13	7741201	

Description	Code	Price
Parallel Shank Counterbore Set	7740000	
THIS SET CONTAINS:		
M5 - 7740500, M6 - 7740600,		
M8 - 7740800, M10 - 7741000,		
M12 - 7741200		



MTS Counterbores

For counterboring holes to suit capscrew heads.



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	○	○	○	●	○			●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	●	●	○	○	●	○				

To suit Capscrew	d ₂	l ₂	l ₁	Medium		
				d ₁	Code	Price
No. 3 Morse Taper Shank						
M22	36	40	214	24	7752200	

Not available once current stock is depleted



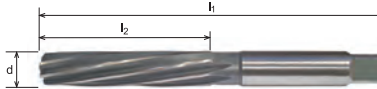
Code
775

Properties		
mm	ISO 4207 DIN 375	HSS
pg 149		



Parallel Hand Reamers

General hand reaming.



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	○	●	○	○	○	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

Codes

701 - 702

Properties

mm inch	BS 328 ISO 236/1 DIN 206	HSS
H7	10°	
RH		

d		l ₂	l ₁	Code	Price
mm	inch				
1.5		20	41	7010150	
1.587	1/16	21	44	7020159	
2		25	50	7010200	
2.5		29	58	7010250	
2.778	7/64	31	62	7020278	
3		31	62	7010300	
3.175	1/8	33	66	7020318	
3.5		35	71	7010350	
3.572	9/64	35	71	7020357	
3.969	5/32	38	76	7020397	
4		38	76	7010400	
4.366	11/64	41	81	7020437	
4.5		41	81	7010450	
4.762	3/16	44	87	7020476	
5		44	87	7010500	
5.159	13/64	44	87	7020516	
5.5		47	93	7010550	
5.556	7/32	47	93	7020556	
5.953	15/64	47	93	7020595	
6		47	93	7010600	
6.350	1/4	50	100	7020635	
6.5		50	100	7010650	
7		54	107	7010700	
7.144	9/32	54	107	7020714	
7.5		54	107	7010750	
7.937	5/16	58	115	7020794	
8		58	115	7010800	
8.5		58	115	7010850	
8.731	11/32	62	124	7020873	
9		62	124	7010900	
9.5		62	124	7010950	
9.525	3/8	66	133	7020953	
10		66	133	7011000	
10.319	13/32	66	133	7021032	
10.5		66	133	7011050	
11		71	142	7011100	
11.112	7/16	71	142	7021111	
11.5		71	142	7011150	
11.906	15/32	76	152	7021191	
12		76	152	7011200	
12.5		76	152	7011250	
12.700	1/2	76	152	7021270	

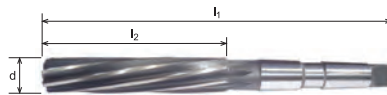
d		l ₂	l ₁	Code	Price
mm	inch				
13		76	152	7011300	
13.5		81	163	7011350	
14		81	163	7011400	
14.287	9/16	81	163	7021429	
14.5		81	163	7011450	
15		81	163	7011500	
15.5		87	175	7011550	
15.875	5/8	87	175	7021588	
16		87	175	7011600	
17		87	175	7011700	
17.462	11/16	93	188	7021746	
18		93	188	7011800	
19		93	188	7011900	
19.050	3/4	100	201	7021905	
20		100	201	7012000	
20.637	13/16	100	201	7022064	
21		100	201	7012100	
22		107	215	7012200	
22.225	7/8	107	215	7022223	
23		107	215	7012300	
23.812	15/16	115	231	7022381	
24		115	231	7012400	
25		115	231	7012500	
25.400	1"	115	231	7022540	
26		115	231	7012600	
27		124	247	7012700	
28		124	247	7012800	
28.575	1.1/8	124	247	7022858	
29		124	247	7012900	
30		124	247	7013000	
31		133	265	7013100	
31.750	1.1/4	133	265	7023175	
32		133	265	7013200	
33		133	265	7013300	
34		142	284	7013400	
34.925	1.3/8	142	284	7023493	
35		142	284	7013500	
36		142	284	7013600	
37		142	284	7013700	
38		152	305	7013800	
38.100	1.1/2	152	305	7023810	

Not available once current stock is depleted





MTS Parallel Machine Reamers

General machine reaming.



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	●				●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

Codes
711 - 712

Properties		
mm inch	BS 328 ISO 236/11	HSS
 MTS 1 - 4	H7	10°
 RH	pg 149	



d		l2	l1	Code	Price	d		l2	l1	Code	Price
mm	inch					mm	inch				

No. 1 Morse Taper Shank

6		45	127	7110600		11.5		71	151	7111150	
8		58	138	7110800		11.906	15/32	76	156	7121191	
8.5		58	138	7110850		12		76	156	7111200	
9		62	142	7110900		12.5		76	156	7111250	
9.5		62	142	7110950		12.700	1/2	76	156	7121270	
9.525	3/8	66	146	7120953		13		76	156	7111300	
10		66	146	7111000		13.494	17/32	81	161	7121349	
10.5		66	146	7111050		13.5		81	161	7111350	
11		71	151	7111100		14		81	161	7111400	
11.112	7/16	71	151	7121111							

No. 2 Morse Taper Shank

14.287	9/16	81	181	7121429		19		93	193	7111900	
14.5		81	181	7111450		19.050	3/4	100	200	7121905	
15		81	181	7111500		19.5		100	200	7111950	
15.5		87	187	7111550		19.844	25/32	100	200	7121984	
15.875	5/8	87	187	7121588		20		100	200	7112000	
16		87	187	7111600		20.5		100	200	7112050	
16.5		87	187	7111650		20.637	13/16	100	200	7122064	
16.669	21/32	87	187	7121667		21		100	200	7112100	
17		87	187	7111700		21.5		107	207	7112150	
17.462	11/16	93	193	7121746		22		107	207	7112200	
17.5		93	193	7111750		22.225	7/8	107	207	7122223	
18		93	193	7111800		22.5		107	207	7112250	
18.256	23/32	93	193	7121826		23		107	207	7112300	
18.5		93	193	7111850							

No. 3 Morse Taper Shank

23.812	15/16	115	242	7122381		28		124	251	7112800	
24		115	242	7112400		28.5		124	251	7112850	
25		115	242	7112500		28.575	1 1/8	124	251	7122858	
25.400	1"	115	242	7122540		29		124	251	7112900	
25.5		115	242	7112550		29.5		124	251	7112950	
26		115	242	7112600		30		124	251	7113000	
26.5		115	242	7112650		30.162	1 3/16	133	260	7123016	
26.987	1 1/16	124	251	7122699		31		133	260	7113100	
27		124	251	7112700		31.750	1 1/4	133	260	7123175	

No. 4 Morse Taper Shank

32		133	293	7113200		41.275	1 5/8	152	312	7124128	
33		133	293	7113300		42		152	312	7114200	
33.337	1 5/16	133	293	7123334		43		163	323	7114300	
34		142	302	7113400		44		163	323	7114400	
34.925	1 3/8	142	302	7123493		44.450	1 3/4	163	323	7124445	
35		142	302	7113500		45		163	323	7114500	
36		142	302	7113600		46		163	323	7114600	
37		142	302	7113700		47		163	323	7114700	
38		152	312	7113800		47.625	1 7/8	174	334	7124763	
38.100	1 1/2	152	312	7123810		48		174	334	7114800	
39		152	312	7113900		49		174	334	7114900	
40		152	312	7114000		50		174	334	7115000	
41		152	312	7114100							

Not available once current stock is depleted

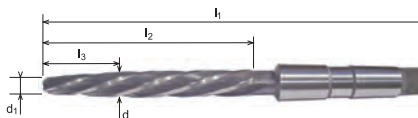


shaping your dreams

**BEST
SELLER**

MTS Taper Bridge Machine Reamers

For opening out existing holes
for alignment on structural steel work.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	○	○	●				●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○		○					

d	d ₁	l ₂	l ₁	l ₃	Code	Price
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No. 2 Morse Taper Shank

13	8.8	105	199	42	7211300	
14	9.4	115	209	46	7211400	
16	10.6	135	229	54	7211600	

No. 3 Morse Taper Shank

17	11.6	135	251	54	7211700	
18	12.2	145	261	58	7211800	
20	13.8	155	271	62	7212000	
21	14.8	155	271	62	7212100	
22	15.4	165	281	66	7212200	
23	16.4	165	281	66	7212300	
24	16.8	180	296	72	7212400	
25	17.8	180	296	72	7212500	
26	18.8	180	296	72	7212600	
28	20.2	195	311	78	7212800	
30	22.2	195	311	78	7213000	

No. 4 Morse Taper Shank

32	23.6	210	354	84	7213200	
34	25.2	220	364	88	7213400	
38	28.8	230	374	92	7213800	



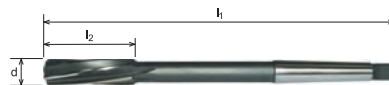
Code
721

Properties		
mm	BS 328 ISO 2238 DIN 311	HSS
MTS 2 - 4	20°	1:10
RH	pg 149	







MTS Machine Chucking Reamers

General machine reaming.



Codes
741

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4

Properties		
mm	DIN 208	HSS Co5
 MTS 1 - 4	H7	 10°
 RH	 pg 150	

d	l ₂	l ₁	Code	Price	d	l ₂	l ₁	Code	Price
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No. 1 Morse Taper Shank

6	26	138	7410600		12	44	182	7411200	
8	33	156	7410800		14	47	189	7411400	
10	38	168	7411000						

No. 2 Morse Taper Shank

15	50	204	7411500		20	60	228	7412000	
16	52	210	7411600		21	62	232	7412100	
18	56	219	7411800		22	64	237	7412200	

No. 3 Morse Taper Shank

24	68	268	7412400		28	71	277	7412800	
25	68	268	7412500		30	73	281	7413000	
26	70	273	7412600						

No. 4 Morse Taper Shank

32	77	317	7413200						
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Not available once current stock is depleted



Parallel Shank Machine Chucking Reamers

General machine reaming.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	●	○	○	○	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

Codes

751 - 752

d		d1	l2	l1	Code	Price
mm	inch					
2		2	11	49	7510200	
2.4		2.4	14	57	7510240	
2.5		2.5	14	57	7510250	
2.6		2.6	14	57	7510260	
2.7		2.7	15	61	7510270	
2.8		2.8	15	61	7510280	
3		3	15	61	7510300	
3.1		3.1	16	65	7510310	
3.175	1/8	3.2	16	65	7520318	
3.2		3.2	16	65	7510320	
3.4		3.4	18	70	7510340	
3.5		3.5	18	70	7510350	
3.6		3.6	18	70	7510360	
3.8		4	19	75	7510380	
4		4	19	75	7510400	
4.1		4	19	75	7510410	
4.2		4	19	75	7510420	
4.3		4.5	21	80	7510430	
4.4		4.5	21	80	7510440	
4.5		4.5	21	80	7510450	
4.762	3/16	5	23	86	7520476	
4.8		5	23	86	7510480	
4.9		5	23	86	7510490	
5		5	23	86	7510500	
5.1		5	23	86	7510510	
5.2		5	23	86	7510520	
5.3		5	23	86	7510530	
5.4		5.6	26	93	7510540	
5.5		5.6	26	93	7510550	
5.6		5.6	26	93	7510560	
5.7		5.6	26	93	7510570	
5.8		5.6	26	93	7510580	
6		5.6	26	93	7510600	
6.1		6.3	28	101	7510610	
6.2		6.3	28	101	7510620	
6.3		6.3	28	101	7510630	
6.350	1/4	6.3	28	101	7520635	
6.4		6.3	28	101	7510640	
6.5		6.3	28	101	7510650	
6.6		6.3	28	101	7510660	
6.7		6.3	28	101	7510670	
6.8		7.1	31	109	7510680	
7		7.1	31	109	7510700	
7.1		7.1	31	109	7510710	
7.2		7.1	31	109	7510720	
7.3		7.1	31	109	7510730	
7.5		7.1	31	109	7510750	
7.8		8	33	117	7510780	
7.9		8	33	117	7510790	
7.937	5/16	8	33	117	7520794	

d		d1	l2	l1	Code	Price
mm	inch					
8		8	33	117	7510800	
8.1		8	33	117	7510810	
8.2		8	33	117	7510820	
8.3		8	33	117	7510830	
8.4		8	33	117	7510840	
8.5		8	33	117	7510850	
8.6		9	36	125	7510860	
8.8		9	36	125	7510880	
8.9		9	36	125	7510890	
9		9	36	125	7510900	
9.1		9	36	125	7510910	
9.5		9	36	125	7510950	
9.525	3/8	10	38	133	7520953	
9.6		10	38	133	7510960	
9.7		10	38	133	7510970	
9.8		10	38	133	7510980	
9.9		10	38	133	7510990	
10		10	38	133	7511000	
10.1		10	38	133	7511010	
10.2		10	38	133	7511020	
10.3		10	38	133	7511030	
10.5		10	38	133	7511050	
10.6		10	38	133	7511060	
10.7		10	41	142	7511070	
10.8		10	41	142	7511080	
10.9		10	41	142	7511090	
11		10	41	142	7511100	
11.1		10	41	142	7511110	
11.112	7/16	10	41	142	7521111	
11.5		10	41	142	7511150	
11.7		10	41	142	7511170	
11.8		10	41	142	7511180	
11.9		10	44	151	7511190	
12		10	44	151	7511200	
12.1		10	44	151	7511210	
12.2		10	44	151	7511220	
12.3		10	44	151	7511230	
12.4		10	44	151	7511240	
12.5		10	44	151	7511250	
12.6		10	44	151	7511260	
12.7		10	44	151	7511270	
12.700	1/2	10	44	151	7521270	
12.8		10	44	151	7511280	
12.9		10	44	151	7511290	
13		10	44	151	7511300	
13.5		12.5	47	160	7511350	
14		12.5	47	160	7511400	
14.287	9/16	12.5	50	162	7521429	
14.5		12.5	50	162	7511450	

Continued on next page...

Properties

mm inch	DIN 212	HSS Co5
H7	10°	RH
pg 150		

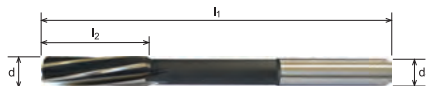




OSG GROUP COMPANY

Parallel Shank Machine Chucking Reamers

General machine reaming.



Codes
751 - 752

P					M				K				Ti				Ni				Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3		6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	●	○	○	○	●	●	●	●	●	○	○	●	○	○																

d		d ₁	l ₂	l ₁	Code	Price
mm	inch					
... from previous page						
15		12.5	50	162	7511500	
15.5		12.5	52	170	7511550	
15.875	5/8	12.5	52	170	7521588	
16		12.5	52	170	7511600	

d		d ₁	l ₂	l ₁	Code	Price
mm	inch					
17		14	54	175	7511700	
18		14	56	182	7511800	
19.050	3/4	16	60	195	7521905	
20		16	60	195	7512000	

Properties		
mm inch	DIN 212	HSS Co5
H7	10°	RH
pg 150		

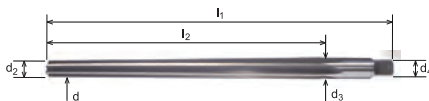


REAMERS,
COUNTERSINKS
& COUNTERBORES



Hand Taper Pin Reamers

Reaming holes to suit
standard taper pins.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	○	○	●				●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○		○					

d	d ₂	d ₃	d ₄	l ₂	a	l ₁	Code	Price
2	1.9	2.86	3.15	48	2.5	68	7310200	
2.5	2.4	3.36	3.15	48	2.5	68	7310250	
3	2.9	4.06	4	58	3.15	80	7310300	
4	3.9	5.26	5	68	4	93	7310400	
5	4.9	6.36	6.3	73	5	100	7310500	
6	5.9	8	8	105	6.3	135	7310600	
8	7.9	10.8	10	145	8	180	7310800	
10	9.9	13.4	12.5	175	10	215	7311000	
12	11.8	16	14	210	11.2	255	7311200	
13	12.8	17	15	210	11.2	255	7311300	
14	13.8	18	16	210	12.5	255	7311400	
16	15.8	20.4	18	230	14	280	7311600	
20	19.8	24.8	22.4	250	18	310	7312000	
25	24.7	30.7	28	300	22.4	370	7312500	

Code

731

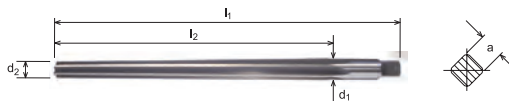
Properties

mm	DIN 9	HSS
1:50	STRAIGHT FLUTE	



Hand Taper Pin Reamers

Reaming holes to suit standard taper pins.



P				M				K				Ti				Ni				Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	○	○	●	○	○	○	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

Nominal Diameter	mm Equiv.	a	d ₁	d ₂	l ₂	l ₁	Code	Price
5/64	1.984	1.6	2.03	1.5	25.4	50.8	7320198	
3/32	2.381	2	2.41	1.75	31.8	57.2	7320238	
7/64	2.778	2.24	2.82	2.03	38.1	63.5	7320278	
1/8	3.175	2.5	3.23	2.29	44.5	69.9	7320318	
9/64	3.572	2.8	3.63	2.64	47.6	73	7320357	
5/32	3.969	3.15	4.01	2.95	50.8	76.2	7320397	
11/64	4.366	3.55	4.42	3.23	52.2	88.9	7320437	
3/16	4.762	4	4.95	3.5	69.9	101.6	7320476	
7/32	5.556	4.5	5.59	4.13	69.9	101.6	7320556	
1/4	6.350	5	6.43	4.64	85.7	117.5	7320635	
9/32	7.144	5.6	7.42	5.23	104.8	142.9	7320714	
5/16	7.937	6.3	8.03	5.84	104.8	142.9	7320794	
11/32	8.731	7.1	8.81	6.43	114.3	152.4	7320873	
3/8	9.525	8	9.68	7.03	127	165.1	7320953	
7/16	11.112	9	11.25	8.21	146.1	190.5	7321111	
1/2	12.700	10	12.85	9.41	165.1	209.6	7321270	
9/16	14.287	11.2	14.5	10.93	171.5	215.9	7321429	
5/8	15.875	12.5	16.08	12.11	190.5	235	7321588	
3/4	19.050	16	19.3	14.67	222.3	273.1	7321905	
7/8	22.225	18	22.48	17.45	241.3	304.8	7322223	



Hand Taper Pin Reamers

Reaming holes to suit standard taper pins.



P				M				K				Ti				Ni				Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	○	○	●	○	○	○	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

d	d ₂	d ₃	d ₄	l ₂	a	l ₁	Code	Price
4	3.9	5.26	5	68	4	93	7330400	

Not available once current stock is depleted.



Code
733

Properties		
mm	DIN 9	HSS
1:50	10°	
RH		



Reamers, Countersinks & Counterbores Cutting Data



If you have any cutting tool problem,
please feel free to contact our technical sales representatives.

Download the Somta Tools app to access machining data on your mobile or desktop.

761, 763 Uncoated

Material	Ø	6.3	8	10	12.5	16	20	25
	Vc m/min	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	1.1 ● 30	0.068-0.113	0.083-0.138	0.098-0.163	0.098-0.163	0.120-0.200	0.143-0.238	0.158-0.263
	1.2 ● 25	0.060-0.100	0.075-0.125	0.090-0.150	0.090-0.150	0.113-0.188	0.135-0.225	0.150-0.250
	1.3 ● 20	0.045-0.075	0.060-0.100	0.075-0.125	0.075-0.125	0.090-0.150	0.113-0.188	0.135-0.225
	1.4 ● 15	0.045-0.075	0.060-0.100	0.075-0.125	0.075-0.125	0.090-0.150	0.113-0.188	0.135-0.225
	1.5 ● 10	0.030-0.050	0.038-0.063	0.045-0.075	0.045-0.075	0.060-0.100	0.075-0.125	0.090-0.150
M	1.6 ● 6	0.023-0.038	0.030-0.050	0.038-0.063	0.038-0.063	0.045-0.075	0.060-0.100	0.068-0.113
	2.1 ○ 8	0.038-0.063	0.045-0.075	0.060-0.100	0.060-0.100	0.075-0.125	0.090-0.150	0.105-0.175
	2.2 ○ 6	0.030-0.050	0.038-0.063	0.045-0.075	0.045-0.075	0.060-0.100	0.075-0.125	0.090-0.150
K	2.3 ○ 4	0.023-0.038	0.030-0.050	0.038-0.063	0.038-0.063	0.045-0.075	0.060-0.100	0.068-0.113
	3.1 ● 25	0.068-0.113	0.083-0.138	0.098-0.163	0.098-0.163	0.120-0.200	0.143-0.238	0.158-0.263
	3.2 ● 15	0.045-0.075	0.060-0.100	0.075-0.125	0.075-0.125	0.090-0.150	0.113-0.188	0.135-0.225
	3.3 ● 12	0.038-0.063	0.045-0.075	0.060-0.100	0.060-0.100	0.075-0.125	0.090-0.150	0.105-0.175
	3.4 ● 8	0.038-0.063	0.045-0.075	0.060-0.100	0.060-0.100	0.075-0.125	0.090-0.150	0.105-0.175
Cu	6.1 ● 25	0.045-0.075	0.060-0.100	0.075-0.125	0.075-0.125	0.090-0.150	0.113-0.188	0.135-0.225
	6.2 ● 20	0.068-0.113	0.083-0.138	0.098-0.163	0.098-0.163	0.120-0.200	0.143-0.238	0.158-0.263
	6.3 ● 25	0.068-0.113	0.083-0.138	0.098-0.163	0.098-0.163	0.120-0.200	0.143-0.238	0.158-0.263
	6.4 ● 10	0.045-0.075	0.060-0.100	0.075-0.125	0.075-0.125	0.090-0.150	0.113-0.188	0.135-0.225
N	7.1 ● 30	0.075-0.125	0.090-0.150	0.113-0.188	0.113-0.188	0.135-0.225	0.150-0.250	0.165-0.275
	7.2 ● 25	0.068-0.113	0.083-0.138	0.098-0.163	0.098-0.163	0.120-0.200	0.143-0.238	0.158-0.263
	7.3 ● 20	0.068-0.113	0.083-0.138	0.098-0.163	0.098-0.163	0.120-0.200	0.143-0.238	0.158-0.263
	7.4 ● 10	0.068-0.113	0.083-0.138	0.098-0.163	0.098-0.163	0.120-0.200	0.143-0.238	0.158-0.263
Syn	8.1 ● 30	0.075-0.125	0.090-0.150	0.113-0.188	0.113-0.188	0.135-0.225	0.150-0.250	0.165-0.275
	8.2 ● 20	0.075-0.125	0.090-0.150	0.113-0.188	0.113-0.188	0.135-0.225	0.150-0.250	0.165-0.275

761, 763 TiN Coated

Material	Ø	6.3	8	10	12.5	16	20	25
	Vc m/min	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	1.1 ● 41	0.068-0.113	0.083-0.138	0.098-0.163	0.098-0.163	0.120-0.200	0.143-0.238	0.158-0.263
	1.2 ● 34	0.060-0.100	0.075-0.125	0.090-0.150	0.090-0.150	0.113-0.188	0.135-0.225	0.150-0.250
	1.3 ● 27	0.045-0.075	0.060-0.100	0.075-0.125	0.075-0.125	0.090-0.150	0.113-0.188	0.135-0.225
	1.4 ● 20	0.045-0.075	0.060-0.100	0.075-0.125	0.075-0.125	0.090-0.150	0.113-0.188	0.135-0.225
	1.5 ● 14	0.030-0.050	0.038-0.063	0.045-0.075	0.045-0.075	0.060-0.100	0.075-0.125	0.090-0.150
M	1.6 ● 8	0.023-0.038	0.030-0.050	0.038-0.063	0.038-0.063	0.045-0.075	0.060-0.100	0.068-0.113
	2.1 ● 11	0.038-0.063	0.045-0.075	0.060-0.100	0.060-0.100	0.075-0.125	0.090-0.150	0.105-0.175
	2.2 ● 8	0.030-0.050	0.038-0.063	0.045-0.075	0.045-0.075	0.060-0.100	0.075-0.125	0.090-0.150
K	2.3 ● 5	0.023-0.038	0.030-0.050	0.038-0.063	0.038-0.063	0.045-0.075	0.060-0.100	0.068-0.113
	3.1 ● 34	0.068-0.113	0.083-0.138	0.098-0.163	0.098-0.163	0.120-0.200	0.143-0.238	0.158-0.263
	3.2 ● 20	0.045-0.075	0.060-0.100	0.075-0.125	0.075-0.125	0.090-0.150	0.113-0.188	0.135-0.225
	3.3 ● 16	0.038-0.063	0.045-0.075	0.060-0.100	0.060-0.100	0.075-0.125	0.090-0.150	0.105-0.175
	3.4 ● 11	0.038-0.063	0.045-0.075	0.060-0.100	0.060-0.100	0.075-0.125	0.090-0.150	0.105-0.175
Cu	6.1 ● 34	0.045-0.075	0.060-0.100	0.075-0.125	0.075-0.125	0.090-0.150	0.113-0.188	0.135-0.225
	6.2 ● 27	0.068-0.113	0.083-0.138	0.098-0.163	0.098-0.163	0.120-0.200	0.143-0.238	0.158-0.263
	6.3 ● 34	0.068-0.113	0.083-0.138	0.098-0.163	0.098-0.163	0.120-0.200	0.143-0.238	0.158-0.263
	6.4 ● 14	0.045-0.075	0.060-0.100	0.075-0.125	0.075-0.125	0.090-0.150	0.113-0.188	0.135-0.225
N	7.1 ● 41	0.075-0.125	0.090-0.150	0.113-0.188	0.113-0.188	0.135-0.225	0.150-0.250	0.165-0.275
	7.2 ● 34	0.068-0.113	0.083-0.138	0.098-0.163	0.098-0.163	0.120-0.200	0.143-0.238	0.158-0.263
	7.3 ● 27	0.068-0.113	0.083-0.138	0.098-0.163	0.098-0.163	0.120-0.200	0.143-0.238	0.158-0.263
	7.4 ● 14	0.068-0.113	0.083-0.138	0.098-0.163	0.098-0.163	0.120-0.200	0.143-0.238	0.158-0.263
Syn	8.1 ● 41	0.075-0.125	0.090-0.150	0.113-0.188	0.113-0.188	0.135-0.225	0.150-0.250	0.165-0.275
	8.2 ● 27	0.075-0.125	0.090-0.150	0.113-0.188	0.113-0.188	0.135-0.225	0.150-0.250	0.165-0.275

Parameters based on ideal conditions.
Please adjust parameters accordingly to real applications.



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Material	Ø	Vc m/min	16	20	25	31.5	40	50	63	80
			F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	1.1	30	0.120-0.200	0.143-0.238	0.158-0.263	0.195-0.325	0.218-0.363	0.233-0.388	0.248-0.413	0.270-0.450
	1.2	25	0.113-0.188	0.135-0.225	0.150-0.250	0.188-0.313	0.203-0.338	0.210-0.350	0.225-0.375	0.240-0.400
	1.3	20	0.090-0.150	0.113-0.188	0.135-0.225	0.150-0.250	0.165-0.275	0.173-0.288	0.188-0.313	0.210-0.350
	1.4	15	0.090-0.150	0.113-0.188	0.135-0.225	0.150-0.250	0.165-0.275	0.173-0.288	0.188-0.313	0.210-0.350
	1.5	10	0.060-0.100	0.075-0.125	0.090-0.150	0.105-0.175	0.120-0.200	0.128-0.213	0.135-0.225	0.150-0.250
	1.6	6	0.045-0.075	0.060-0.100	0.068-0.113	0.075-0.125	0.090-0.150	0.098-0.163	0.105-0.175	0.120-0.200
M	2.1	8	0.075-0.125	0.090-0.150	0.105-0.175	0.120-0.200	0.135-0.225	0.143-0.238	0.150-0.250	0.165-0.275
	2.2	6	0.060-0.100	0.075-0.125	0.090-0.150	0.105-0.175	0.120-0.200	0.128-0.213	0.135-0.225	0.150-0.250
	2.3	4	0.045-0.075	0.060-0.100	0.068-0.113	0.075-0.125	0.090-0.150	0.098-0.163	0.105-0.175	0.120-0.200
K	3.1	25	0.120-0.200	0.143-0.238	0.158-0.263	0.195-0.325	0.218-0.363	0.233-0.388	0.248-0.413	0.270-0.450
	3.2	20	0.090-0.150	0.113-0.188	0.135-0.225	0.150-0.250	0.165-0.275	0.173-0.288	0.188-0.313	0.210-0.350
	3.3	12	0.075-0.125	0.090-0.150	0.105-0.175	0.120-0.200	0.135-0.225	0.143-0.238	0.150-0.250	0.165-0.275
Ti	3.4	8	0.075-0.125	0.090-0.150	0.105-0.175	0.120-0.200	0.135-0.225	0.143-0.238	0.150-0.250	0.165-0.275
	4.1	12	0.075-0.125	0.090-0.150	0.105-0.175	0.120-0.200	0.135-0.225	0.143-0.238	0.150-0.250	0.165-0.275
	4.2	10	0.045-0.075	0.060-0.100	0.068-0.113	0.075-0.125	0.090-0.150	0.098-0.163	0.105-0.175	0.120-0.200
Ni	4.3	8	0.045-0.075	0.060-0.100	0.068-0.113	0.075-0.125	0.090-0.150	0.098-0.163	0.105-0.175	0.120-0.200
	5.1	12	0.075-0.125	0.090-0.150	0.105-0.175	0.120-0.200	0.135-0.225	0.143-0.238	0.150-0.250	0.165-0.275
	5.2	6	0.060-0.100	0.075-0.125	0.090-0.150	0.105-0.175	0.120-0.200	0.128-0.213	0.135-0.225	0.150-0.250
Cu	5.3	4	0.045-0.075	0.060-0.100	0.068-0.113	0.075-0.125	0.090-0.150	0.098-0.163	0.105-0.175	0.120-0.200
	6.1	25	0.090-0.150	0.113-0.188	0.135-0.225	0.150-0.250	0.165-0.275	0.173-0.288	0.188-0.313	0.210-0.350
	6.2	20	0.120-0.200	0.143-0.238	0.158-0.263	0.195-0.325	0.218-0.363	0.233-0.388	0.248-0.413	0.270-0.450
N	6.3	25	0.120-0.200	0.143-0.238	0.158-0.263	0.195-0.325	0.218-0.363	0.233-0.388	0.248-0.413	0.270-0.450
	6.4	10	0.090-0.150	0.113-0.188	0.135-0.225	0.150-0.250	0.165-0.275	0.173-0.288	0.188-0.313	0.210-0.350
	7.1	30	0.135-0.225	0.150-0.250	0.165-0.275	0.210-0.350	0.240-0.400	0.255-0.425	0.270-0.450	0.300-0.500
Syn	7.2	25	0.120-0.200	0.143-0.238	0.158-0.263	0.195-0.325	0.218-0.363	0.233-0.388	0.248-0.413	0.270-0.450
	7.3	20	0.120-0.200	0.143-0.238	0.158-0.263	0.195-0.325	0.218-0.363	0.233-0.388	0.248-0.413	0.270-0.450
	7.4	10	0.120-0.200	0.143-0.238	0.158-0.263	0.195-0.325	0.218-0.363	0.233-0.388	0.248-0.413	0.270-0.450
Syn	8.1	30	0.135-0.225	0.150-0.250	0.165-0.275	0.210-0.350	0.240-0.400	0.255-0.425	0.270-0.450	0.300-0.500
	8.2	20	0.135-0.225	0.150-0.250	0.165-0.275	0.210-0.350	0.240-0.400	0.255-0.425	0.270-0.450	0.300-0.500

Material	Ø	Vc m/min	6	6.5	8	10	11	15	18	20
			F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	1.1	30	0.060-0.100	0.060-0.100	0.075-0.125	0.090-0.150	0.090-0.150	0.113-0.188	0.120-0.200	0.135-0.225
	1.2	25	0.060-0.100	0.060-0.100	0.075-0.125	0.090-0.150	0.090-0.150	0.113-0.188	0.120-0.200	0.135-0.225
	1.3	20	0.045-0.075	0.045-0.075	0.060-0.100	0.075-0.125	0.075-0.125	0.090-0.150	0.098-0.163	0.113-0.188
	1.4	15	0.045-0.075	0.045-0.075	0.060-0.100	0.075-0.125	0.075-0.125	0.090-0.150	0.098-0.163	0.113-0.188
	1.5	10	0.038-0.063	0.038-0.063	0.045-0.075	0.060-0.100	0.060-0.100	0.075-0.125	0.083-0.138	0.090-0.150
	1.6	6	0.038-0.063	0.038-0.063	0.045-0.075	0.060-0.100	0.060-0.100	0.075-0.125	0.083-0.138	0.090-0.150
M	2.1	8	0.045-0.075	0.045-0.075	0.060-0.100	0.075-0.125	0.075-0.125	0.090-0.150	0.098-0.163	0.113-0.188
	2.2	6	0.038-0.063	0.038-0.063	0.045-0.075	0.060-0.100	0.060-0.100	0.075-0.125	0.083-0.138	0.090-0.150
	3.1	25	0.060-0.100	0.060-0.100	0.075-0.125	0.090-0.150	0.090-0.150	0.113-0.188	0.120-0.200	0.135-0.225
K	3.2	20	0.060-0.100	0.060-0.100	0.075-0.125	0.090-0.150	0.090-0.150	0.113-0.188	0.120-0.200	0.135-0.225
	3.3	15	0.045-0.075	0.045-0.075	0.060-0.100	0.075-0.125	0.075-0.125	0.090-0.150	0.098-0.163	0.113-0.188
	3.4	8	0.038-0.063	0.038-0.063	0.045-0.075	0.060-0.100	0.060-0.100	0.075-0.125	0.083-0.138	0.090-0.150
Ti	4.1	12	0.060-0.100	0.060-0.100	0.075-0.125	0.090-0.150	0.090-0.150	0.113-0.188	0.120-0.200	0.135-0.225
	4.2	10	0.060-0.100	0.060-0.100	0.075-0.125	0.090-0.150	0.090-0.150	0.113-0.188	0.120-0.200	0.135-0.225
	4.3	8	0.060-0.100	0.060-0.100	0.075-0.125	0.090-0.150	0.090-0.150	0.113-0.188	0.120-0.200	0.135-0.225
Ni	5.1	12	0.060-0.100	0.060-0.100	0.075-0.125	0.090-0.150	0.090-0.150	0.113-0.188	0.120-0.200	0.135-0.225
	5.2	6	0.038-0.063	0.038-0.063	0.045-0.075	0.060-0.100	0.060-0.100	0.075-0.125	0.083-0.138	0.090-0.150
	5.3	4	0.060-0.100	0.060-0.100	0.075-0.125	0.090-0.150	0.090-0.150	0.113-0.188	0.120-0.200	0.135-0.225
Cu	6.1	25	0.038-0.063	0.038-0.063	0.045-0.075	0.060-0.100	0.060-0.100	0.075-0.125	0.083-0.138	0.090-0.150
	6.2	20	0.038-0.063	0.038-0.063	0.045-0.075	0.060-0.100	0.060-0.100	0.075-0.125	0.083-0.138	0.090-0.150
	6.3	15	0.038-0.063	0.038-0.063	0.045-0.075	0.060-0.100	0.060-0.100	0.075-0.125	0.083-0.138	0.090-0.150
N	7.1	30	0.075-0.125	0.075-0.125	0.090-0.150	0.113-0.188	0.113-0.188	0.135-0.225	0.143-0.238	0.150-0.250
	7.2	25	0.075-0.125	0.075-0.125	0.090-0.150	0.113-0.188	0.113-0.188	0.135-0.225	0.143-0.238	0.150-0.250
	7.3	20	0.075-0.125	0.075-0.125	0.090-0.150	0.113-0.188	0.113-0.188	0.135-0.225	0.143-0.238	0.150-0.250
Syn	7.4	10	0.060-0.100	0.060-0.100	0.075-0.125	0.090-0.150	0.090-0.150	0.113-0.188	0.120-0.200	0.135-0.225
	8.1	30	0.038-0.063	0.038-0.063	0.045-0.075	0.060-0.100	0.060-0.100	0.075-0.125	0.083-0.138	0.090-0.150
Syn	8.2	20	0.038-0.063	0.038-0.063	0.045-0.075	0.060-0.100	0.060-0.100	0.075-0.125	0.083-0.138	0.090-0.150



Material	Ø Vc m/min	15	18	20	24	26	30	33	36	40
		F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	1.1 ● 30	0.113-0.188	0.120-0.200	0.135-0.225	0.143-0.238	0.150-0.250	0.188-0.313	0.188-0.313	0.195-0.325	0.203-0.338
	1.2 ● 25	0.113-0.188	0.120-0.200	0.135-0.225	0.143-0.238	0.150-0.250	0.188-0.313	0.188-0.313	0.195-0.325	0.203-0.338
	1.3 ● 20	0.090-0.150	0.098-0.163	0.113-0.188	0.120-0.200	0.135-0.225	0.150-0.250	0.150-0.250	0.158-0.263	0.165-0.275
	1.4 ○ 15	0.090-0.150	0.098-0.163	0.113-0.188	0.120-0.200	0.135-0.225	0.150-0.250	0.150-0.250	0.158-0.263	0.165-0.275
	1.5 ○ 10	0.075-0.125	0.083-0.138	0.090-0.150	0.098-0.163	0.105-0.175	0.120-0.200	0.120-0.200	0.128-0.213	0.135-0.225
M	1.6 ○ 6	0.075-0.125	0.083-0.138	0.090-0.150	0.098-0.163	0.105-0.175	0.120-0.200	0.120-0.200	0.128-0.213	0.135-0.225
	2.1 ● 8	0.090-0.150	0.098-0.163	0.113-0.188	0.120-0.200	0.135-0.225	0.150-0.250	0.150-0.250	0.158-0.263	0.165-0.275
	2.2 ○ 6	0.075-0.125	0.083-0.138	0.090-0.150	0.098-0.163	0.105-0.175	0.120-0.200	0.120-0.200	0.128-0.213	0.135-0.225
K	3.1 ● 25	0.113-0.188	0.120-0.200	0.135-0.225	0.143-0.238	0.150-0.250	0.188-0.313	0.188-0.313	0.195-0.325	0.203-0.338
	3.2 ● 15	0.113-0.188	0.120-0.200	0.135-0.225	0.143-0.238	0.150-0.250	0.188-0.313	0.188-0.313	0.195-0.325	0.203-0.338
	3.3 ○ 12	0.090-0.150	0.098-0.163	0.113-0.188	0.120-0.200	0.135-0.225	0.150-0.250	0.150-0.250	0.158-0.263	0.165-0.275
Ti	3.4 ○ 8	0.075-0.125	0.083-0.138	0.090-0.150	0.098-0.163	0.105-0.175	0.120-0.200	0.120-0.200	0.128-0.213	0.135-0.225
	4.1 ○ 12	0.113-0.188	0.120-0.200	0.135-0.225	0.143-0.238	0.150-0.250	0.188-0.313	0.188-0.313	0.195-0.325	0.203-0.338
	4.2 ○ 10	0.113-0.188	0.120-0.200	0.135-0.225	0.143-0.238	0.150-0.250	0.188-0.313	0.188-0.313	0.195-0.325	0.203-0.338
Ni	4.3 ○ 8	0.113-0.188	0.120-0.200	0.135-0.225	0.143-0.238	0.150-0.250	0.188-0.313	0.188-0.313	0.195-0.325	0.203-0.338
	5.1 ○ 12	0.113-0.188	0.120-0.200	0.135-0.225	0.143-0.238	0.150-0.250	0.188-0.313	0.188-0.313	0.195-0.325	0.203-0.338
	5.2 ○ 6	0.075-0.125	0.083-0.138	0.090-0.150	0.098-0.163	0.105-0.175	0.120-0.200	0.120-0.200	0.128-0.213	0.135-0.225
Cu	5.3 ○ 4	0.113-0.188	0.120-0.200	0.135-0.225	0.143-0.238	0.150-0.250	0.188-0.313	0.188-0.313	0.195-0.325	0.203-0.338
	6.1 ● 25	0.075-0.125	0.083-0.138	0.090-0.150	0.098-0.163	0.105-0.175	0.120-0.200	0.120-0.200	0.128-0.213	0.135-0.225
	6.2 ○ 20	0.075-0.125	0.083-0.138	0.090-0.150	0.098-0.163	0.105-0.175	0.120-0.200	0.120-0.200	0.128-0.213	0.135-0.225
N	6.3 ○ 25	0.075-0.125	0.083-0.138	0.090-0.150	0.098-0.163	0.105-0.175	0.120-0.200	0.120-0.200	0.128-0.213	0.135-0.225
	7.1 ● 30	0.135-0.225	0.143-0.238	0.150-0.250	0.158-0.263	0.165-0.275	0.210-0.350	0.210-0.350	0.225-0.375	0.240-0.400
	7.2 ● 25	0.135-0.225	0.143-0.238	0.150-0.250	0.158-0.263	0.165-0.275	0.210-0.350	0.210-0.350	0.225-0.375	0.240-0.400
Syn	7.3 ○ 20	0.135-0.225	0.143-0.238	0.150-0.250	0.158-0.263	0.165-0.275	0.210-0.350	0.210-0.350	0.225-0.375	0.240-0.400
	7.4 ○ 10	0.113-0.188	0.120-0.200	0.135-0.225	0.143-0.238	0.150-0.250	0.188-0.313	0.188-0.313	0.195-0.325	0.203-0.338
	8.1 ● 30	0.075-0.125	0.083-0.138	0.090-0.150	0.098-0.163	0.105-0.175	0.120-0.200	0.120-0.200	0.128-0.213	0.135-0.225
	8.2 ○ 20	0.075-0.125	0.083-0.138	0.090-0.150	0.098-0.163	0.105-0.175	0.120-0.200	0.120-0.200	0.128-0.213	0.135-0.225

711 - 712, 721

Material	Ø Vc m/min	5	8	10	12	16	20	25	30	40	50
		F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	1.1 ● 18	0.139-0.231	0.165-0.275	0.195-0.325	0.214-0.356	0.251-0.419	0.293-0.488	0.330-0.550	0.360-0.600	0.450-0.750	0.510-0.850
	1.2 ● 14	0.139-0.231	0.165-0.275	0.195-0.325	0.214-0.356	0.251-0.419	0.293-0.488	0.330-0.550	0.360-0.600	0.450-0.750	0.510-0.850
	1.3 ● 11	0.139-0.231	0.165-0.275	0.195-0.325	0.214-0.356	0.251-0.419	0.293-0.488	0.330-0.550	0.360-0.600	0.450-0.750	0.510-0.850
	1.4 ● 10	0.113-0.188	0.135-0.225	0.158-0.263	0.180-0.300	0.210-0.350	0.233-0.388	0.270-0.450	0.300-0.500	0.375-0.625	0.413-0.688
	1.5 ○ 5	0.113-0.188	0.135-0.225	0.158-0.263	0.180-0.300	0.210-0.350	0.233-0.388	0.270-0.450	0.300-0.500	0.375-0.625	0.413-0.688
M	1.6 ○ 4	0.075-0.125	0.113-0.188	0.128-0.213	0.139-0.231	0.165-0.275	0.188-0.313	0.210-0.350	0.240-0.400	0.293-0.488	0.330-0.550
	2.1 ● 8	0.263-0.438	0.330-0.550	0.375-0.625	0.413-0.688	0.473-0.788	0.525-0.875	0.600-1.000	0.698-1.163	0.900-1.500	1.125-1.875
	3.1 ● 14	0.188-0.313	0.263-0.438	0.293-0.488	0.323-0.538	0.375-0.625	0.398-0.663	0.480-0.800	0.563-0.938	0.683-1.138	0.825-1.375
K	3.2 ○ 11	0.150-0.250	0.203-0.338	0.240-0.400	0.270-0.450	0.308-0.513	0.353-0.588	0.405-0.675	0.450-0.750	0.548-0.913	0.638-1.063
	3.3 ○ 10	0.139-0.231	0.165-0.275	0.195-0.325	0.214-0.356	0.251-0.419	0.293-0.488	0.330-0.550	0.360-0.600	0.450-0.750	0.510-0.850
	3.4 ○ 9	0.139-0.231	0.165-0.275	0.195-0.325	0.214-0.356	0.251-0.419	0.293-0.488	0.330-0.550	0.360-0.600	0.450-0.750	0.510-0.850
Ti	4.1 ○ 11	0.139-0.231	0.165-0.275	0.195-0.325	0.214-0.356	0.251-0.419	0.293-0.488	0.330-0.550	0.360-0.600	0.450-0.750	0.510-0.850
	4.2 ○ 5	0.113-0.188	0.135-0.225	0.158-0.263	0.180-0.300	0.210-0.350	0.233-0.388	0.270-0.450	0.300-0.500	0.375-0.625	0.413-0.688
	4.3 ○ 4	0.113-0.188	0.135-0.225	0.158-0.263	0.180-0.300	0.210-0.350	0.233-0.388	0.270-0.450	0.300-0.500	0.375-0.625	0.413-0.688
Ni	5.1 ○ 5	0.150-0.250	0.203-0.338	0.240-0.400	0.270-0.450	0.308-0.513	0.353-0.588	0.405-0.675	0.450-0.750	0.548-0.913	0.638-1.063
	5.2 ○ 3	0.139-0.231	0.165-0.275	0.195-0.325	0.214-0.356	0.251-0.419	0.293-0.488	0.330-0.550	0.360-0.600	0.450-0.750	0.510-0.850
	5.3 ○ 2	0.139-0.231	0.165-0.275	0.195-0.325	0.214-0.356	0.251-0.419	0.293-0.488	0.330-0.550	0.360-0.600	0.450-0.750	0.510-0.850
Cu	6.1 ○ 18	0.150-0.250	0.203-0.338	0.240-0.400	0.270-0.450	0.308-0.513	0.353-0.588	0.405-0.675	0.450-0.750	0.548-0.913	0.638-1.063
	6.2 ○ 20	0.188-0.313	0.263-0.438	0.293-0.488	0.323-0.538	0.375-0.625	0.398-0.663	0.480-0.800	0.563-0.938	0.683-1.138	0.825-1.375
	6.3 ○ 18	0.150-0.250	0.203-0.338	0.240-0.400	0.270-0.450	0.308-0.513	0.353-0.588	0.405-0.675	0.450-0.750	0.548-0.913	0.638-1.063
N	7.1 ○ 11	0.150-0.250	0.203-0.338	0.240-0.400	0.270-0.450	0.308-0.513	0.353-0.588	0.405-0.675	0.450-0.750	0.548-0.913	0.638-1.063
	7.4 ○ 23	0.263-0.438	0.330-0.550	0.375-0.625	0.413-0.688	0.473-0.788	0.525-0.875	0.600-1.000	0.698-1.163	0.900-1.500	1.125-1.875
	7.2 ○ 18	0.263-0.438	0.330-0.550	0.375-0.625	0.413-0.688	0.473-0.788	0.525-0.875	0.600-1.000	0.698-1.163	0.900-1.500	1.125-1.875
Syn	8.2 ○ 21	0.113-0.188	0.135-0.225	0.158-0.263	0.180-0.300	0.210-0.350	0.233-0.388	0.270-0.450	0.300-0.500	0.375-0.625	0.413-0.688

Parameters based on ideal conditions.
Please adjust parameters accordingly to real applications.



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741, 751 - 752

Material	Ø Vc m/min	2	3	5	8	10	12	16	20	25	30	40
		F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)	F (mm/rev.)
P	1.1 ● 25	0.064-0.106	0.101-0.169	0.139-0.231	0.165-0.275	0.195-0.325	0.214-0.356	0.251-0.419	0.293-0.488	0.330-0.550	0.360-0.600	0.450-0.750
	1.2 ● 20	0.064-0.106	0.101-0.169	0.139-0.231	0.165-0.275	0.195-0.325	0.214-0.356	0.251-0.419	0.293-0.488	0.330-0.550	0.360-0.600	0.450-0.750
	1.3 ● 16	0.064-0.106	0.101-0.169	0.139-0.231	0.165-0.275	0.195-0.325	0.214-0.356	0.251-0.419	0.293-0.488	0.330-0.550	0.360-0.600	0.450-0.750
	1.4 ● 15	0.054-0.090	0.083-0.138	0.113-0.188	0.135-0.225	0.158-0.263	0.180-0.300	0.210-0.350	0.233-0.388	0.270-0.450	0.300-0.500	0.375-0.625
	1.5 ● 9	0.054-0.090	0.083-0.138	0.113-0.188	0.135-0.225	0.158-0.263	0.180-0.300	0.210-0.350	0.233-0.388	0.270-0.450	0.300-0.500	0.375-0.625
	1.6 ● 5	0.041-0.069	0.059-0.098	0.075-0.125	0.113-0.188	0.128-0.213	0.139-0.231	0.165-0.275	0.188-0.313	0.210-0.350	0.240-0.400	0.293-0.488
M	2.1 ● 11	0.064-0.106	0.101-0.169	0.139-0.231	0.165-0.275	0.195-0.325	0.214-0.356	0.251-0.419	0.293-0.488	0.330-0.550	0.360-0.600	0.450-0.750
	2.2 ○ 6	0.054-0.090	0.083-0.138	0.113-0.188	0.135-0.225	0.158-0.263	0.180-0.300	0.210-0.350	0.233-0.388	0.270-0.450	0.300-0.500	0.375-0.625
	2.3 ○ 8	0.054-0.090	0.083-0.138	0.113-0.188	0.135-0.225	0.158-0.263	0.180-0.300	0.210-0.350	0.233-0.388	0.270-0.450	0.300-0.500	0.375-0.625
K	3.1 ● 16	0.105-0.175	0.135-0.225	0.188-0.313	0.263-0.438	0.293-0.488	0.323-0.538	0.375-0.625	0.398-0.663	0.480-0.800	0.563-0.938	0.683-1.138
	3.2 ● 15	0.083-0.138	0.120-0.200	0.150-0.250	0.203-0.338	0.240-0.400	0.270-0.450	0.308-0.513	0.353-0.588	0.405-0.675	0.450-0.750	0.548-0.913
	3.3 ● 13	0.064-0.106	0.101-0.169	0.139-0.231	0.165-0.275	0.195-0.325	0.214-0.356	0.251-0.419	0.293-0.488	0.330-0.550	0.360-0.600	0.450-0.750
	3.4 ● 11	0.064-0.106	0.101-0.169	0.139-0.231	0.165-0.275	0.195-0.325	0.214-0.356	0.251-0.419	0.293-0.488	0.330-0.550	0.360-0.600	0.450-0.750
Ti	4.1 ● 11	0.064-0.106	0.101-0.169	0.139-0.231	0.165-0.275	0.195-0.325	0.214-0.356	0.251-0.419	0.293-0.488	0.330-0.550	0.360-0.600	0.450-0.750
	4.2 ○ 5	0.054-0.090	0.083-0.138	0.113-0.188	0.135-0.225	0.158-0.263	0.180-0.300	0.210-0.350	0.233-0.388	0.270-0.450	0.300-0.500	0.375-0.625
	4.3 ○ 4	0.054-0.090	0.083-0.138	0.113-0.188	0.135-0.225	0.158-0.263	0.180-0.300	0.210-0.350	0.233-0.388	0.270-0.450	0.300-0.500	0.375-0.625
Ni	5.1 ● 5	0.083-0.138	0.120-0.200	0.150-0.250	0.203-0.338	0.240-0.400	0.270-0.450	0.308-0.513	0.353-0.588	0.405-0.675	0.450-0.750	0.548-0.913
	5.2 ○ 3	0.064-0.106	0.101-0.169	0.139-0.231	0.165-0.275	0.195-0.325	0.214-0.356	0.251-0.419	0.293-0.488	0.330-0.550	0.360-0.600	0.450-0.750
	5.3 ○ 2	0.064-0.106	0.101-0.169	0.139-0.231	0.165-0.275	0.195-0.325	0.214-0.356	0.251-0.419	0.293-0.488	0.330-0.550	0.360-0.600	0.450-0.750



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Parameters based on ideal conditions.
Please adjust parameters accordingly to real applications.

150

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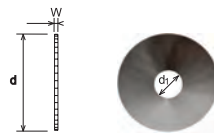


OSG GROUP COMPANY

B O R E C U T T E R S



Slitting Saws - Fine Pitch

Narrow slotting and sawing applications in thin materials.



Codes
440 - 441

P					M				K				Ti				Ni				Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3		6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●						●	●	●	●																						

Properties		
mm	DIN 1837A	HSS
 wsg10 osjs16	 pg 154	

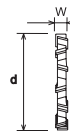
d	W	d ₁	Z Teeth	Code	Price	d	W	d ₁	Z Teeth	Code	Price
32	0.2	8	100*	4400033		100	0.8	27	128	4410117	
32	0.3	8	80	4400035		100	1	22	128	4410180	
32	0.6	8	64	4400038		100	1	27	127	4410119	
32	0.8	8	64	4400039		100	1.2	22	128	4410190	
32	1	8	64	4400040		100	1.5	22	100	4411211	
32	1.2	8	48	4400041		100	1.6	22	100	4410200	
32	1.6	8	48	4400042		100	2	22	100	4410210	
32	2	8	48	4400043		100	2.5	22	100	4410220	
50	0.5	13	100	4400069		100	3	22	80	4410230	
50	0.6	13	100	4400070		100	4	22	80	4410240	
50	0.8	13	80	4400071		100	4	27	80	4410131	
50	1	13	80	4400072		100	5	22	80	4410250	
50	1.2	13	80	4400073		100	6	22	64	4410260	
50	1.6	13	64	4400074		125	0.6	22	160*	4410270	
50	2	13	64	4400075		125	0.8	22	160*	4410280	
50	2.5	13	64	4400076		125	1	22	160	4410290	
50	3	13	48	4400077		125	1.2	22	128	4410300	
63	0.8	16	100	4400086		125	1.6	22	128	4410310	
63	1	16	100	4400087		125	2	22	128	4410320	
63	1.2	16	80	4400088		125	2	27	128	4410146	
63	1.5	16	80	4400089		125	2.5	22	100	4410330	
63	1.6	16	80	4400090		125	3	22	100	4410340	
63	2	16	80	4400091		125	4	22	100	4410350	
63	2.5	16	64	4400092		125	5	22	80	4410360	
80	0.3	22	160*	4410010		125	6	22	80	4410370	
80	0.4	22	160*	4410020		160	1	32	160*	4410380	
80	0.5	22	128*	4410030		160	1.2	32	160*	4410390	
80	0.6	22	128*	4410040		160	1.6	32	160*	4410400	
80	0.8	22	128	4410050		160	2	32	128*	4410410	
80	1	22	100	4410060		160	2.5	32	128*	4410420	
80	1.2	22	100	4410070		160	3	32	128*	4410430	
80	1.5	22	100	4410104		160	4	32	100*	4410440	
80	1.6	22	100	4410080		160	5	32	100*	4410450	
80	2	22	80	4410090		160	6	32	100*	4410460	
80	2.5	22	80	4410100		200	1	32	200*	4410470	
80	3	22	80	4410110		200	1.2	32	200*	4410480	
80	4	22	64	4410120		200	1.6	32	160*	4410490	
80	5	22	64	4410130		200	2	32	160*	4410500	
80	6	22	64	4410140		200	2.5	32	160*	4410510	
100	0.5	22	160*	4410150		200	3	32	128*	4410520	
100	0.6	22	160*	4410160		200	4	32	128*	4410530	
100	0.6	27	160*	4410115		200	5	32	128*	4410540	
100	0.8	22	128	4410170		200	6	32	100*	4410550	

* Denotes sizes which can be supplied with a boss on request.



Side & Face Cutters

Designed for heavy duty slotting operations in steel and in most soft materials.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	●	●	○		●	●	●	●	○	○	○	○	○	○	●	●	●	●	●	●	●	●	●						

d	W	d ₁	Z Teeth	Code	Price
63	18	22	12	4010018	

d	W	d ₁	Z Teeth	Code	Price
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Not available once current stock is depleted

Codes

401

Properties

mm	DIN 885A	HSS Co5
TYPE N		
pg 154		



Bore Cutters Cutting Data



**If you have any cutting tool problem,
please feel free to contact our technical sales representatives.**

Download the Somta Tools app to access machining data on your mobile or desktop.

440 - 441

Material	Ø	Vc m/min	32	50	63	80	100	125	160	200
			F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)
P	1.1	40	0.030-0.050	0.030-0.050	0.030-0.050	0.030-0.050	0.030-0.050	0.030-0.050	0.030-0.050	0.030-0.050
	1.2	30	0.030-0.050	0.030-0.050	0.030-0.050	0.030-0.050	0.030-0.050	0.030-0.050	0.030-0.050	0.030-0.050
	1.3	30	0.030-0.050	0.030-0.050	0.030-0.050	0.030-0.050	0.030-0.050	0.030-0.050	0.030-0.050	0.030-0.050
	1.4	20	0.015-0.025	0.015-0.025	0.015-0.025	0.015-0.025	0.015-0.025	0.015-0.025	0.015-0.025	0.015-0.025
K	3.1	30	0.030-0.050	0.030-0.050	0.030-0.050	0.030-0.050	0.030-0.050	0.030-0.050	0.030-0.050	0.030-0.050
	3.2	30	0.030-0.050	0.030-0.050	0.030-0.050	0.030-0.050	0.030-0.050	0.030-0.050	0.030-0.050	0.030-0.050

401 - 404, 406

Material	Ø	Vc m/min	50	63	80	100	125	160
			F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)
P	1.1	45	0.060-0.100	0.068-0.113	0.071-0.119	0.083-0.138	0.086-0.144	0.086-0.144
	1.2	40	0.060-0.100	0.068-0.113	0.071-0.119	0.083-0.138	0.086-0.144	0.086-0.144
	1.3	35	0.060-0.100	0.068-0.113	0.071-0.119	0.083-0.138	0.086-0.144	0.086-0.144
	1.4	30	0.060-0.100	0.068-0.113	0.071-0.119	0.083-0.138	0.086-0.144	0.086-0.144
	1.5	20	0.060-0.100	0.068-0.113	0.071-0.119	0.083-0.138	0.086-0.144	0.086-0.144
	1.6	10	0.060-0.100	0.068-0.113	0.071-0.119	0.083-0.138	0.086-0.144	0.086-0.144
M	2.1	30	0.060-0.100	0.068-0.113	0.071-0.119	0.083-0.138	0.086-0.144	0.086-0.144
	2.2	20	0.060-0.100	0.068-0.113	0.071-0.119	0.083-0.138	0.086-0.144	0.086-0.144
	2.3	10	0.068-0.113	0.075-0.125	0.079-0.131	0.083-0.138	0.086-0.144	0.094-0.156
K	3.1	30	0.068-0.113	0.075-0.125	0.079-0.131	0.083-0.138	0.086-0.144	0.094-0.156
	3.2	25	0.068-0.113	0.075-0.125	0.079-0.131	0.083-0.138	0.086-0.144	0.094-0.156
	3.3	40	0.068-0.113	0.075-0.125	0.079-0.131	0.083-0.138	0.086-0.144	0.094-0.156
	3.4	25	0.068-0.113	0.075-0.125	0.079-0.131	0.083-0.138	0.086-0.144	0.094-0.156
Ti	4.1	30	0.045-0.075	0.053-0.088	0.060-0.100	0.068-0.113	0.075-0.125	0.079-0.131
	4.2	20	0.053-0.088	0.060-0.100	0.068-0.113	0.075-0.125	0.079-0.131	0.083-0.138
	4.3	15	0.053-0.088	0.060-0.100	0.068-0.113	0.075-0.125	0.079-0.131	0.083-0.138
Ni	5.1	40	0.060-0.100	0.068-0.113	0.071-0.119	0.083-0.138	0.086-0.144	0.086-0.144
	5.2	15	0.053-0.088	0.060-0.100	0.068-0.113	0.075-0.125	0.079-0.131	0.083-0.138
	5.3	10	0.030-0.050	0.038-0.063	0.045-0.075	0.053-0.088	0.060-0.100	0.068-0.113
Cu	6.1	150	0.060-0.100	0.068-0.113	0.071-0.119	0.083-0.138	0.086-0.144	0.086-0.144
	6.2	150	0.060-0.100	0.068-0.113	0.071-0.119	0.083-0.138	0.086-0.144	0.086-0.144
	6.3	150	0.060-0.100	0.068-0.113	0.071-0.119	0.083-0.138	0.086-0.144	0.086-0.144
	6.4	15	0.030-0.050	0.038-0.063	0.045-0.075	0.053-0.088	0.060-0.100	0.068-0.113
N	7.1	400	0.068-0.113	0.075-0.125	0.079-0.131	0.083-0.138	0.086-0.144	0.094-0.156
	7.2	400	0.068-0.113	0.075-0.125	0.079-0.131	0.083-0.138	0.086-0.144	0.094-0.156
	7.3	100	0.068-0.113	0.075-0.125	0.079-0.131	0.083-0.138	0.086-0.144	0.094-0.156
	7.4	70	0.068-0.113	0.075-0.125	0.079-0.131	0.083-0.138	0.086-0.144	0.094-0.156
	8.1	150	0.030-0.050	0.038-0.063	0.045-0.075	0.053-0.088	0.060-0.100	0.068-0.113



OSG GROUP COMPANY

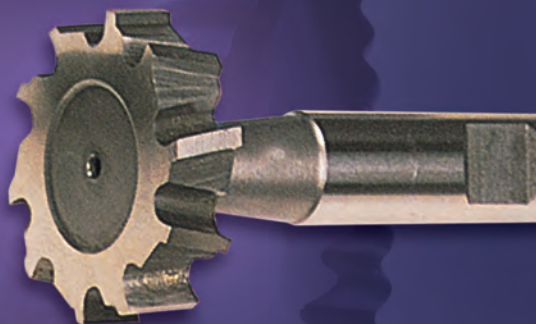


shaping your dreams

Download the Somta Tools app to
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mobile or desktop



Parameters based on ideal conditions.
Please adjust parameters accordingly to real applications.



shaping your dreams



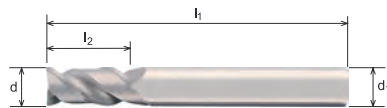
OSG GROUP COMPANY

S H A N K

C U T T E R S






Solid Carbide 2 Flute End Mills

Milling keyways and slots to size in one cut. Designed for plunging operations.



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
																								●	●	●	○							

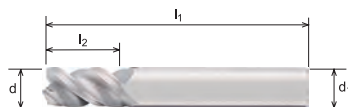
d	l ₂	l ₁	d ₁	Code	Price
1	3	50	6	02A0100	
2	6	50	6	02A0200	
3	8	57	6	02A0300	
4	11	57	6	02A0400	
5	13	57	6	02A0500	
6	13	57	6	02A0600	
8	19	63	8	02A0800	
10	22	75	10	02A1000	
12	26	83	12	02A1200	
16	32	92	16	02A1600	

Properties		
mm	WORKS STD.	SOLID CARBIDE
	TYPE W	
		45°
Z 2		UNCOATED
pg 196		

Code
02R

Solid Carbide 3 Flute End Mills






Multi-purpose tool used for slotting and profiling.



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
																								●	●	●	○							

d	l ₂	l ₁	d ₁	Code	Price
2	3	50	6	02R0200	
3	6	50	6	02R0300	
4	8	57	6	02R0400	
5	11	57	6	02R0500	
6	13	57	6	02R0600	
8	13	57	8	02R0800	
10	19	63	10	02R1000	
12	22	75	12	02R1200	
16	26	83	16	02R1600	

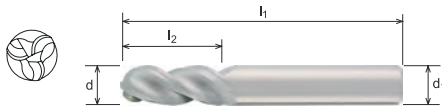
Not available once current stock is depleted

Properties		
mm	WORKS STD.	SOLID CARBIDE
	TYPE W	
		45°
Z 3		UNCOATED
pg 196		



Solid Carbide 3 Flute Ball Nose End Mills

For finishing of contours at high feed rates where a superior finish is required.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4

d	l ₂	l ₁	d ₁	Code	Price
3	12	38	3	02S0300	
4	15	51	4	02S0400	
5	20	64	5	02S0500	
6	20	64	6	02S0600	
8	20	64	8	02S0800	
10	25	70	10	02S1000	
12	25	76	12	02S1200	
16	35	89	16	02S1600	

Not available once current stock is depleted

Code

02S

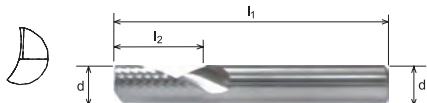
Properties

mm	WORKS STD.	SOLID CARBIDE
	TYPE W	
	40°	Z 3
	UNCOATED	pg 196

NEW

Solid Carbide Single Flute End Mills

For dry machining of soft materials.



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4

d	l ₂	l ₁	d ₁	Helix Direction	Code	Price
3	12	51	3	RH	02T0300	
3	12	51	3	LH	02T0301	
4	13	51	4	RH	02T0400	
4	13	51	4	LH	02T0401	
5	14	51	5	RH	02T0500	
5	14	51	5	LH	02T0501	
6	18	57	6	RH	02T0600	
6	18	57	6	LH	02T0601	
8	21	63	8	RH	02T0800	
8	21	63	8	LH	02T0801	
10	24	72	10	RH	02T1000	
10	24	72	10	LH	02T1001	
12	28	83	12	RH	02T1200	
12	28	83	12	LH	02T1201	

Code

02T

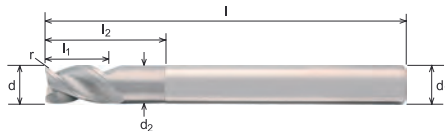
Properties

mm	WORKS STD.	SOLID CARBIDE
	TYPE W	
	25°	Z 1
	UNCOATED	pg 196







Solid Carbide 3 Flute Toroidal End Mills

For minimum vibration in heavy profile machining.



Code
02U

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
																								●	●	●	○							

Properties		
mm	WORKS STD.	SOLID CARBIDE
	TYPE W	
	39/40/41°	Z 3
	UNCOATED	pg 196

d	l ₁	l ₂	l	d ₁	d ₂	r	Code	Price
3	4.5	12	55	3	2.8	0.2	02U0300	
3	4.5	12	55	3	2.8	0.5	02U0301	
4	6	12	55	4	3.8	0.2	02U0400	
4	6	12	55	4	3.8	0.5	02U0401	
5	7.5	15	58	5	4.8	0.2	02U0500	
5	7.5	15	58	5	4.8	0.5	02U0501	
6	9	18	63	6	5.8	0.2	02U0600	
6	9	18	63	6	5.8	0.5	02U0601	
6	9	18	63	6	5.8	1	02U0602	
*6	9	18	63	6	5.8	-	02U0603	
8	12	24	76	8	7.7	0.5	02U0800	
8	12	24	76	8	7.7	1	02U0801	
*8	12	24	76	8	7.7	-	02U0803	
10	15	30	89	10	9.7	0.5	02U1000	
10	15	30	89	10	9.7	1	02U1001	
*10	15	30	89	10	9.7	-	02U1003	
12	18	36	100	12	11.6	0.5	02U1200	
12	18	36	100	12	11.6	1	02U1201	
*12	18	36	100	12	11.6	-	02U1203	
16	24	48	110	16	15.5	1	02U1600	
16	24	48	110	16	15.5	2	02U1601	
*16	24	48	110	16	15.5	-	02U1603	

Description	Code	Price
-------------	------	-------



Solid Carbide 3 Flute Toroidal End Mill Set

02U0003

THIS SET CONTAINS:

6mm - 02U0603, 8mm - 02U0803,
10mm - 02U1003, 12mm - 02U1203,
16mm - 02U1603

Not available once current stock is depleted

* Flat Bottom, not Corner Radius



SHANK
CUTTERS



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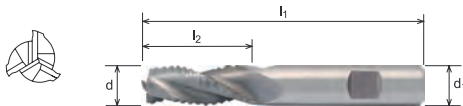
158

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Solid Carbide 3 Flute Roughing End Mills

Maximum stock removal at high feed rates in profiling applications.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4

d	l ₂	l ₁	d ₁	Code	Price
6	13	57	6	03C0600	
8	16	63	8	03C0800	
10	22	72	10	03C1000	
12	26	83	12	03C1200	
16	32	92	16	03C1600	
20	38	104	20	03C2000	

Code

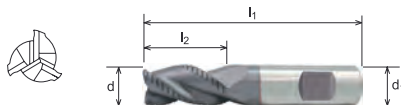
03C

Properties

mm	WORKS STD.	SOLID CARBIDE
	TYPE W	
		Z 3
		UNCOATED

Solid Carbide 3 Flute Roughing End Mills

Maximum stock removal at high feed rates in profiling applications.



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4

d	l ₂	l ₁	d ₁	Code	Price
10	19	72	10	03D1000X	
16	32	92	16	03D1600X	
20	38	104	20	03D2000X	

Code

03D

Properties

mm	WORKS STD.	SOLID CARBIDE
	TYPE UNI	
		Z 3
		COATED

Description	Code	Price
Solid Carbide 3 Flute Roughing End Mill Set	03D0000X	
THIS SET CONTAINS:		
6mm - 03D0600X, 8mm - 03D0800X,		
10mm - 03D1000X, 12mm - 03D1200X,		
16mm - 03D1600X		

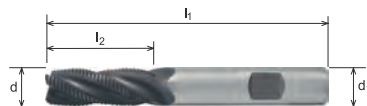


Not available once current stock is depleted



Solid Carbide 4 Flute Roughing End Mills

Maximum stock removal at high
feed rates in profiling applications.








P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	●	○	○		●	●	●	●	●																				

d	l2	l1	d1	Code	Price
6	13	57	6	03E0600X	
8	16	63	8	03E0800X	
10	22	72	10	03E1000X	
12	26	83	12	03E1200X	
16	32	92	16	03E1600X	
20	38	104	20	03E2000X	

Description	Code	Price
Solid Carbide 4 Flute Roughing End Mill Set	03E0000X	
THIS SET CONTAINS:		
6mm - 03E0600X, 8mm - 03E0800X,		
10mm - 03E1000X, 12mm - 03E1200X,		
16mm - 03E1600X		



Code
03E

Properties		
mm	WORKS STD.	SOLID CARBIDE
	TYPE UNI	
	30°	Z 4
	h6 HB	COATED
	pg 197	

Solid Carbide 4 Flute Roughing End Mills

Maximum stock removal at high feed
rates in profiling applications.








P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	●	○	○		●	●	●	●	●	○	○	○	○	○															

d	l2	l1	d1	Code	Price
6	13	57	6	03F0600X	
8	16	63	8	03F0800X	
10	22	72	10	03F1000X	
12	26	83	12	03F1200X	
16	32	92	16	03F1600X	
20	38	104	20	03F2000X	

Not available once current stock is depleted

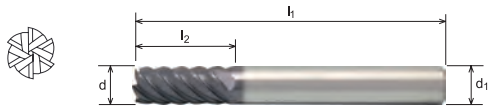
Code
03F

Properties		
mm	WORKS STD.	SOLID CARBIDE
	TYPE UNI	
	30°	Z 4
	h6 HB	COATED
	pg 197	



Solid Carbide 6 Flute Finishing End Mills

Designed for peripheral milling as a finishing operation.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4

d	l2	l1	d1	Code	Price
6	15	60	6	03G0600W	
8	20	75	8	03G0800W	
10	25	80	10	03G1000W	
12	30	100	12	03G1200W	
16	40	110	16	03G1600W	
20	45	120	20	03G2000W	

Description	Code	Price
Solid Carbide 6 Flute Finishing End Mill Set	03G0000W	
THIS SET CONTAINS:		
6mm - 03G0600W, 8mm - 03G0800W,		
10mm - 03G1000W, 12mm - 03G1200W,		
16mm - 03G1600W		



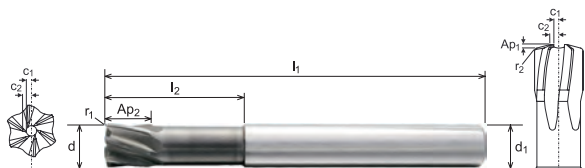
Not available once current stock is depleted

Code
03G

Properties		
mm	WORKS STD.	SOLID CARBIDE
45°	TYPE H	
COATED	Z 6	Ø h6
	pg 197	

Solid Carbide 6 Flute Hi-Feed End Mills

Designed for peripheral milling of contours and complex shapes in hard materials.



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4

d	d1	Ap1	Ap2	l2	l1	r1	r2	C1	C2	Code	Price
6	6	0.32	4.8	18	63	0.63	0.37	0.75	1.32	03H0600W	
8	8	0.42	6.4	24	76	0.83	0.5	1	1.76	03H0800W	
10	10	0.53	8	30	89	1.04	0.62	1.25	2.2	03H1000W	
12	12	0.63	9.6	36	100	1.24	0.75	1.5	2.64	03H1200W	
16	16	0.84	12.8	48	110	1.66	1	2	3.52	03H1600W	
20	20	1.05	16	60	125	2.07	1.25	2.5	4.4	03H2000W	

Code
03H

Properties		
mm	WORKS STD.	SOLID CARBIDE
20°	TYPE H	
COATED	Z 6	Ø h6
	pg 198	

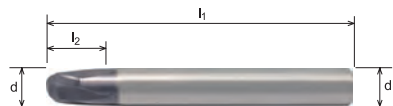




OSG GROUP COMPANY

Solid Carbide 2 Flute Ball Nose Finishing End Mills

Designed for peripheral milling of contours and complex shapes in hard materials.



P					M				K				Ti			Ni			Cu				N			Syn			H					
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
					●																										●	●	●	○

d	l2	l1	d1	Code	Price
16	16	89	16	03I1600W	
20	20	104	20	03I2000W	

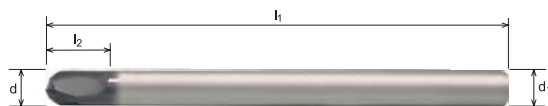
Not available once current stock is depleted

Code
03I

Properties		
mm	WORKS STD.	SOLID CARBIDE
	TYPE H	
15°	Z 2	Ø h6
COATED	pg 198	

Solid Carbide 2 Flute Ball Nose Finishing End Mills

Designed for peripheral milling of contours and complex shapes in hard materials.



P						M				K				Ti			Ni			Cu				N			Syn			H				
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
					●																										●	●	●	○

d	l2	l1	d1	Code	Price
4	4	76	6	03J0400W	
6	6	76	6	03J0600W	
8	8	100	8	03J0800W	
10	10	100	10	03J1000W	
12	12	125	12	03J1200W	
16	16	125	16	03J1600W	
20	20	150	20	03J2000W	

Not available once current stock is depleted

Code
03J

Properties		
mm	WORKS STD.	SOLID CARBIDE
	TYPE H	
15°	Z 2	Ø h6
COATED	pg 198	



SHANK CUTTERS



shaping your dreams

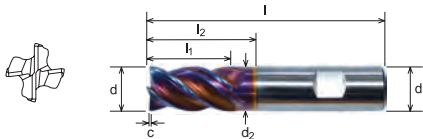
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Solid Carbide 4 Flute MultiForce End Mills

For roughing and finishing with high metal removal rates in multiple materials eliminating the use of multiple tools.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

d	l ₁	l ₂	l	d ₁	d ₂	c	Code	Price
5	13	18	57	6	4.8	0.2x45°	MFM-0-0500RA	
6	13	18	57	6	5.8	0.2x45°	MFM-0-0600RA	
8	19	24	63	8	7.7	0.25x45°	MFM-0-0800RA	
10	22	32	72	10	9.7	0.25x45°	MFM-0-1000RA	
12	26	36	83	12	11.6	0.3x45°	MFM-0-1200RA	
16	32	42	92	16	15.5	0.4x45°	MFM-0-1600RA	
20	38	48	104	20	19.5	0.4x45°	MFM-0-2000RA	

Code

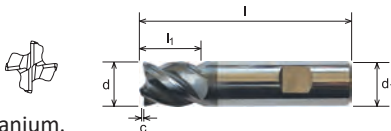
MFM-0

Properties

mm	DIN 6527L	SOLID CARBIDE
	TYPE UNI	
40°	Z 4	Ø h6 HB
RAINBOW COATED	pg 199	

Solid Carbide 4 Flute Stub VariCut End Mills

For roughing and finishing with high metal removal rates eliminating the use of multiple tools. Designed for tougher materials including Stainless steel and Titanium.



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

d	l ₁	l	d ₁	c	Code	Price
5	9	54	6	0.4x45°	04V0500X	
6	10	54	6	0.4x45°	04V0600X	
8	12	58	8	0.5x45°	04V0800X	
10	14	66	10	0.5x45°	04V1000X	
12	16	73	12	0.5x45°	04V1200X	
16	22	82	16	0.5x45°	04V1600X	
20	26	92	20	0.5x45°	04V2000X	

Code

04V

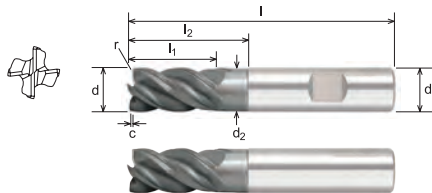
Properties

mm	DIN 6527K	SOLID CARBIDE
	TYPE UNI	
40°	Z 4	Ø h6 HB
COATED	pg 199	









Solid Carbide 4 Flute VariCut End Mills

For roughing and finishing with high metal removal rates eliminating the use of multiple tools. Designed for tougher materials including Stainless steel and Titanium.



Code
03V

Properties		
mm	DIN 6527L	SOLID CARBIDE
	TYPE UNI	
	Z 4	
	COATED	

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○				

d	l1	l2	l	d1	d2	c	r		Code	Price
5	13	18	57	6	4.8	0.2 x 45°	-	x	03V0500X	
5	13	25	57	6	4.8	-	0.5	-	03V0505X	
5	13	25	57	6	4.8	-	1	-	03V0510X	
5	13	-	57	6	-	0.4 x 45°	-	-	03V0545X	
6	13	18	57	6	5.8	0.2 x 45°	-	x	03V0600X	
6	13	25	57	6	5.8	-	0.5	-	03V0605X	
6	13	25	57	6	5.8	-	1	-	03V0610X	
6	13	-	57	6	-	0.4 x 45°	-	-	03V0645X	
8	19	24	63	8	7.7	0.25 x 45°	-	x	03V0800X	
8	19	31	63	8	7.8	-	0.5	-	03V0805X	
8	19	31	63	8	7.8	-	1	-	03V0810X	
8	19	-	63	8	-	0.5 x 45°	-	-	03V0845X	
10	22	32	72	10	9.7	0.25 x 45°	-	x	03V1000X	
10	22	34	72	10	9.8	-	0.5	-	03V1005X	
10	22	34	72	10	9.8	-	1	-	03V1010X	
10	22	-	72	10	-	0.5 x 45°	-	-	03V1045X	
12	26	36	83	12	11.6	0.3 x 45°	-	x	03V1200X	
12	26	38	83	12	11.8	-	0.5	-	03V1205X	
12	26	38	83	12	11.8	-	1	-	03V1210X	
12	26	-	83	12	-	0.75 x 45°	-	-	03V1245X	
16	32	42	92	16	15.5	0.4 x 45°	-	x	03V1600X	
16	32	44	92	16	15.8	-	1	-	03V1610X	
16	32	44	92	16	15.8	-	2	-	03V1620X	
16	32	-	92	16	-	0.75 x 45°	-	-	03V1645X	
20	38	48	104	20	19.5	0.4 x 45°	-	x	03V2000X	
20	38	50	104	20	19.8	-	1	-	03V2010X	
20	38	50	104	20	19.8	-	2	-	03V2020X	
20	38	-	104	20	-	0.75 x 45°	-	-	03V2045X	

Description	Code	Price
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Solid Carbide 4 Flute VariCut End Mill Set

03V0000X

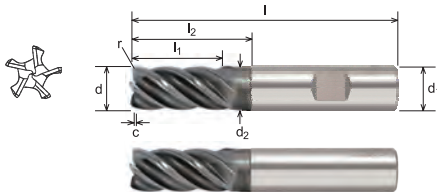
THIS SET CONTAINS:

5mm - 03V0500X, 6mm - 03V0600X,
8mm - 03V0800X, 10mm - 03V1000X,
12mm - 03V1200X



Solid Carbide 5 Flute VariCut End Mills

For roughing and finishing with high metal removal rates eliminating the use of multiple tools. Designed for tougher materials including Stainless steel and Titanium.



OSG GROUP COMPANY

Code

05V

Properties

mm	DIN 6527L	SOLID CARBIDE
	TYPE UNI	
40°	Z 5	
	COATED	pg 199

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4

d	l ₁	l ₂	l	d ₁	d ₂	c	r		Code	Price
5	13	18	57	6	4.8	0.2 x 45°	-	x	05V0500X	
5	13	25	57	6	4.8	-	0.5	-	05V0505X	
5	13	25	57	6	4.8	-	1	-	05V0510X	
5	13	-	57	6	-	0.4 x 45°	-	-	05V0545X	
6	13	18	57	6	5.8	0.2 x 45°	-	x	05V0600X	
6	13	25	57	6	5.8	-	0.5	-	05V0605X	
6	13	25	57	6	5.8	-	1	-	05V0610X	
6	13	-	57	6	-	0.4 x 45°	-	-	05V0645X	
8	19	24	63	8	7.7	0.25 x 45°	-	x	05V0800X	
8	19	31	63	8	7.8	-	0.5	-	05V0805X	
8	19	31	63	8	7.8	-	1	-	05V0810X	
8	19	-	63	8	-	0.5 x 45°	-	-	05V0845X	
10	22	32	72	10	9.7	0.25 x 45°	-	x	05V1000X	
10	22	34	72	10	9.8	-	0.5	-	05V1005X	
10	22	34	72	10	9.8	-	1	-	05V1010X	
10	22	-	72	10	-	0.5 x 45°	-	-	05V1045X	
12	26	36	83	12	11.6	0.3 x 45°	-	x	05V1200X	
12	26	38	83	12	11.8	-	0.5	-	05V1205X	
12	26	38	83	12	11.8	-	1	-	05V1210X	
12	26	-	83	12	-	0.75 x 45°	-	-	05V1245X	
16	32	42	92	16	15.5	0.4 x 45°	-	x	05V1600X	
16	32	44	92	16	15.8	-	1	-	05V1610X	
16	32	44	92	16	15.8	-	2	-	05V1620X	
16	32	-	92	16	-	0.75 x 45°	-	-	05V1645X	
20	38	48	104	20	19.5	0.4 x 45°	-	x	05V2000X	
20	38	50	104	20	19.8	-	1	-	05V2010X	
20	38	50	104	20	19.8	-	2	-	05V2020X	
20	38	-	104	20	-	0.75 x 45°	-	-	05V2045X	

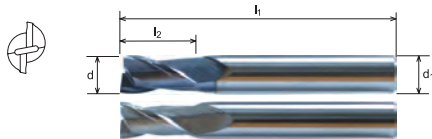
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OSG GROUP COMPANY

Solid Carbide 2 Flute End Mills
Milling keyways and slots to size in one cut.
Designed for plunging operations. High tensile
steels and other difficult materials.



Code
03A

P						M				K				Ti			Ni			Cu				N				Syn			H				
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4	
●	●	●	●	●		○	○	○		●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○			
○	○	○	○	○		○	○	○		○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	

Properties		
mm	WORKS STD.	SOLID CARBIDE
	TYPE N	
	COATED	
	UNCOATED	

d	l2	l1	d1	Coated		Uncoated	
				Code	Price	Code	Price
1	3	39	3	03A0100X		03A0100	
1.5	5	39	3	03A0150X		03A0150	
2	7	39	3	03A0200X		03A0200	
2.5	7	39	3	03A0250X		03A0250	
3	8	39	3	03A0300X		03A0300	
4	8	57	6	03A0400X		03A0400	
5	10	57	6	03A0500X		03A0500	
6	10	57	6	03A0600X		03A0600	
8	16	63	8	03A0800X		03A0800	
10	19	72	10	03A1000X		03A1000	
12	22	83	12	03A1200X		03A1200	
14	22	83	14	03A1400X		03A1400	
16	26	92	16	03A1600X		03A1600	
18	26	96	18	03A1800X		03A1800	
20	32	104	20	03A2000X		03A2000	

Description	Code	Price
Solid Carbide 2 Flute End Mill Set - Coated	03A0000X	
THIS SET CONTAINS:		
4mm - 03A0400X, 5mm - 03A0500X,		
6mm - 03A0600X, 8mm - 03A0800X,		
10mm - 03A1000X, 12mm - 03A1200X		



SHANK
CUTTERS



shaping your dreams

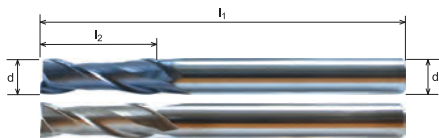
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Solid Carbide 2 Flute End Mills

Milling keyways and slots to size in one cut. Designed for plunging operations. High tensile steels and other difficult materials.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●		○	○	○		●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
																								○	○	○	○							

d	l2	l1	d1	Coated		Uncoated	
				Code	Price	Code	Price
3	19	57	3	03B0300X		03B0300	
4	19	57	4	03B0400X		03B0400	
5	25	64	5	03B0500X		03B0500	
6	28	76	6	03B0600X		03B0600	
8	29	76	8	03B0800X		03B0800	
10	32	102	10	03B1000X		03B1000	
12	51	102	12	03B1200X		03B1200	
14	57	127	14	03B1400X		03B1400	
16	57	127	16	03B1600X		03B1600	
18	57	127	18	03B1800X		03B1800	
20	57	127	20	03B2000X		03B2000	

Code
03B

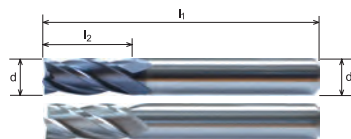
Properties		
mm	WORKS STD.	SOLID CARBIDE
	TYPE N	
	30°	Z 2
	COATED	
Ø h6	UNCOATED	pg 200,202





OSG GROUP COMPANY

**NEW DESIGN - 20% IMPROVED
TOOL PERFORMANCE AND 50%
IMPROVED TOOL LIFE!**



**BEST
SELLER**

Solid Carbide 4 Flute End Mills
For profile milling, high tensile steels
and other difficult materials.

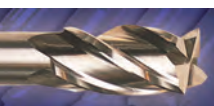
P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●		○	○	○		●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

d	l ₂	l ₁	d ₁	Coated		Uncoated	
				Code	Price	Code	Price
1	3	39	3	03K0100X		03K0100	
1.5	5	39	3	03K0150X		03K0150	
2	7	39	3	03K0200X		03K0200	
2.5	7	39	3	03K0250X		03K0250	
3	9	39	3	03K0300X		03K0300	
4	11	57	6	03K0400X		03K0400	
5	13	57	6	03K0500X		03K0500	
6	13	57	6	03K0600X		03K0600	
8	19	63	8	03K0800X		03K0800	
10	22	72	10	03K1000X		03K1000	
12	26	83	12	03K1200X		03K1200	
14	26	83	14	03K1400X		03K1400	
16	32	92	16	03K1600X		03K1600	
18	32	96	18	03K1800X		03K1800	
20	38	104	20	03K2000X		03K2000	

Description	Code	Price
Solid Carbide 4 Flute End Mill Set - Coated	03K0000X	
THIS SET CONTAINS:		
4mm - 03K0400X, 5mm - 03K0500X,		
6mm - 03K0600X, 8mm - 03K0800X,		
10mm - 03K1000X, 12mm - 03K1200X		



Not available once current stock is depleted



SHANK
CUTTERS



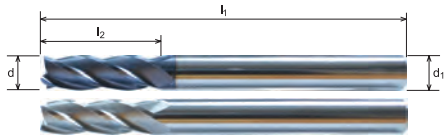
shaping your dreams

168

JUNE 2023 V3 SOMTA CATALOGUE

www.somta.co.za

**NEW DESIGN - 20% IMPROVED
TOOL PERFORMANCE AND 50%
IMPROVED TOOL LIFE!**



OSG GROUP COMPANY

Solid Carbide 4 Flute End Mills
For profile milling, high tensile steels
and other difficult materials.

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4

Code

03L

Properties

mm	WORKS STD.	SOLID CARBIDE
3 4 5 6 8 10 12 14 16 18 20	TYPE N	
	35°	Z 4
	COATED UNCOATED	

d	l2	l1	d1	Coated		Uncoated	
				Code	Price	Code	Price
3	19	57	3	03L0300X		03L0300	
4	19	57	4	03L0400X		03L0400	
5	25	64	5	03L0500X		03L0500	
6	28	76	6	03L0600X		03L0600	
8	29	76	8	03L0800X		03L0800	
10	32	102	10	03L1000X		03L1000	
12	51	102	12	03L1200X		03L1200	
14	57	127	14	03L1400X		03L1400	
16	57	127	16	03L1600X		03L1600	
18	57	127	18	03L1800X		03L1800	
20	57	127	20	03L2000X		03L2000	

Description	Code	Price
Solid Carbide 4 Flute End Mill Set - Coated	03L0000X	
THIS SET CONTAINS:		
4mm - 03L0400X, 5mm - 03L0500X,		
6mm - 03L0600X, 8mm - 03L0800X,		
10mm - 03L1000X, 12mm - 03L1200X		



Not available once current stock is depleted

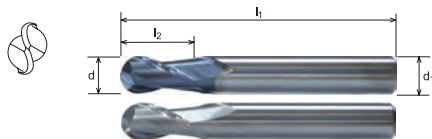




OSG GROUP COMPANY

Solid Carbide 2 Flute Ball Nose End Mills

Milling keyways and slots to size in one cut.
Designed for plunging operations & contouring.
Produces a radius at the bottom of the cut.



Code
03M

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●		○	○	○		●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
																								○	○	○	○							

Properties		
mm	WORKS STD.	SOLID CARBIDE
	TYPE N	
	30°	Z 2
	COATED UNCOATED	pg 200,202

d	l2	l1	d1	Coated		Uncoated	
				Code	Price	Code	Price
1	3	39	3	03M0100X		03M0100	
1.5	5	39	3	03M0150X		03M0150	
2	7	39	3	03M0200X		03M0200	
2.5	7	39	3	03M0250X		03M0250	
3	8	39	3	03M0300X		03M0300	
4	8	57	6	03M0400X		03M0400	
5	10	57	6	03M0500X		03M0500	
6	10	57	6	03M0600X		03M0600	
8	16	63	8	03M0800X		03M0800	
10	19	72	10	03M1000X		03M1000	
12	22	83	12	03M1200X		03M1200	
14	22	83	14	03M1400X		03M1400	
16	26	92	16	03M1600X		03M1600	
18	26	96	18	03M1800X		03M1800	
20	32	104	20	03M2000X		03M2000	

Description	Code	Price
Solid Carbide 2 Flute Ball Nose End Mill Set - Coated	03M0000X	
THIS SET CONTAINS:		
4mm - 03M0400X, 5mm - 03M0500X,		
6mm - 03M0600X, 8mm - 03M0800X,		
10mm - 03M1000X, 12mm - 03M1200X		



SHANK
CUTTERS



shaping your dreams

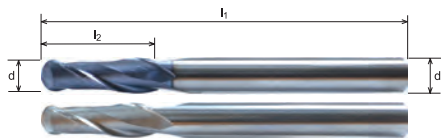
170

JUNE 2023 V3 SOMTA CATALOGUE

www.somta.co.za

Solid Carbide 2 Flute Ball Nose End Mills

Milling keyways and slots to size in one cut.
Designed for plunging operations & contouring.
Produces a radius at the bottom of the cut.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●		○	○	○		●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

d	l2	l1	d1	Coated		Uncoated	
				Code	Price	Code	Price
3	19	57	3	03N0300X		03N0300	
4	19	57	4	03N0400X		03N0400	
5	25	64	5	03N0500X		03N0500	
6	28	76	6	03N0600X		03N0600	
8	29	76	8	03N0800X		03N0800	
10	32	102	10	03N1000X		03N1000	
12	51	102	12	03N1200X		03N1200	
14	57	127	14	03N1400X		03N1400	
16	57	127	16	03N1600X		03N1600	
18	57	127	18	03N1800X		03N1800	
20	57	127	20	03N2000X		03N2000	

Code

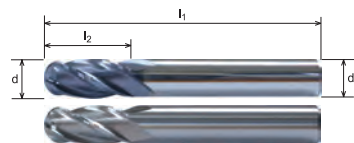
03N

Properties

mm	WORKS STD.	SOLID CARBIDE
	TYPE N	

Solid Carbide 4 Flute Ball Nose End Mills

For profile milling, high tensile steels
and other difficult materials.



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●		○	○	○		●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○				

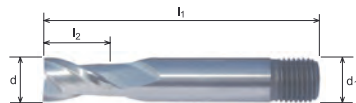
d	l2	l1	d1	Coated		Uncoated	
				Code	Price	Code	Price
1	3	39	3	03P0100X		03P0100	
1.5	5	39	3	03P0150X		03P0150	
2	7	39	3	03P0200X		03P0200	
2.5	7	39	3	03P0250X		03P0250	
3	9	39	3	03P0300X		03P0300	
4	11	57	6	03P0400X		03P0400	
5	13	57	6	03P0500X		03P0500	
6	13	57	6	03P0600X		03P0600	
8	19	63	8	03P0800X		03P0800	
10	22	72	10	03P1000X		03P1000	
12	26	83	12	03P1200X		03P1200	
14	26	83	14	03P1400X		03P1400	
16	32	92	16	03P1600X		03P1600	
18	32	96	18	03P1800X		03P1800	
20	38	104	20	03P2000X		03P2000	

Code

03P





Properties

mm	WORKS STD.	SOLID CARBIDE
	TYPE N	



Code
321, 323

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	○							○	○	○								○	○	○	○	○	○	○								

Properties		
mm inch	DIN 327 321	BS 122 323
HSS		TYPE N
		30°
Z 2		pg 203

d	l ₂	l ₁	d ₁	Code	Price
1.5	2.5	48	6	3210150	
2	4	48	6	3210200	
2.5	5	49	6	3210250	
3	5	49	6	3210300	
3.5	6	50	6	3210350	
4	7	51	6	3210400	
4.5	7	51	6	3210450	
5	8	52	6	3210500	
5.5	8	52	6	3210550	
6	8	52	6	3210600	
6.5	10	60	10	3210650	
7	10	60	10	3210700	
7.5	10	60	10	3210750	
8	11	61	10	3210800	
8.5	11	61	10	3210850	
9	11	61	10	3210900	
9.5	11	61	10	3210950	
10	13	63	10	3211000	
10.5	13	70	12	3211050	
11	13	70	12	3211100	
12	16	73	12	3211200	
13	16	73	12	3211300	

d	l ₂	l ₁	d ₁	Code	Price
14	16	73	12	3211400	
15	16	73	12	3211500	
16	19	79	16	3211600	
17	19	79	16	3211700	
18	19	79	16	3211800	
19	19	79	16	3211900	
*20	19	79	16	3212000	
*22	26	102	25	3212200	
24	26	102	25	3212400	
25	26	102	25	3212500	
26	26	102	25	3212600	
28	26	102	25	3212800	
30	26	102	25	3213000	
32	32	112	32	3213200	
35	32	112	32	3213500	
36	32	112	32	3213600	
38	38	118	32	3213800	
*40	38	118	32	3214000	
*42	38	118	32	3214200	
*45	38	118	32	3214500	
*50	45	125	32	3215000	

d	l ₂	l ₁	d ₁	Code	Price
1/4	11	56	1/4	3230635	
3/8	14	60	3/8	3230953	

d	l ₂	l ₁	d ₁	Code	Price
1/2	19	67	1/2	3231270	
3/4	25	77	5/8	3231905	

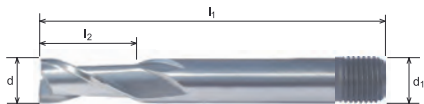
Not available once current stock is depleted

* Lengths not to DIN 327



2 Flute End Mills (Slot Drills)

Milling keyways and slots to size.
Designed for plunging operations.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	○							○	○	○								○	○	○	○	○	○	○								

d	l ₂	l ₁	d ₁	Code	Price	d	l ₂	l ₁	d ₁	Code	Price
2	4	51	6	3260200		9	22	82.5	10	3260900	
2.5	6.5	54	6	3260250		9.5	22	82.5	10	3260950	
3	11	60.5	6	3260300		10	22	82.5	10	3261000	
3.5	12.5	66.5	6	3260350		11	22	89	12	3261100	
4	12.5	66.5	6	3260400		12	25.5	95	12	3261200	
4.5	12.5	66.5	6	3260450		13	25.5	95	12	3261300	
5	12.5	70	6	3260500		14	28.5	101.5	12	3261400	
5.5	16	76	6	3260550		*15	31.5	108	12	3261500	
6	16	76	6	3260600		16	31.5	108	16	3261600	
6.5	16	76	10	3260650		17	35	114.5	16	3261700	
7	16	76	10	3260700		18	35	114.5	16	3261800	
7.5	16	76	10	3260750		19	38	120.5	16	3261900	
8	19	79.5	10	3260800		20	38	120.5	16	3262000	
8.5	22	82.5	10	3260850							

Not available once current stock is depleted

* Not to BS 122



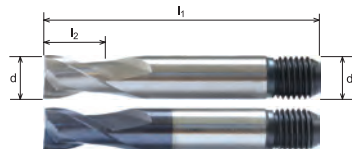
Code
326

Properties		
mm	BS 122	HSS
	TYPE N	
	30°	Z 2
	h8	pg 203



2 Flute End Mills (Slot Drills)

Milling keyways and slots to size in one cut.
Designed for plunging operations. High
tensile steels and other difficult materials.



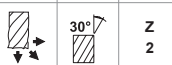
Code

348

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

Properties

mm **DIN 327** **HSS Co8**
TYPE N  e8

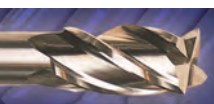
 30° **Z 2**

UNCOATED **TiAIN**  pg 204

d	l2	l1	d1	Uncoated		TiAIN Coated	
				Code	Price	Code	Price
1.5	2.5	48	6	3480150		3480150A	
2	4	48	6	3480200		3480200A	
2.5	5	49	6	3480250		3480250A	
3	5	49	6	3480300		3480300A	
3.5	6	50	6	3480350		3480350A	
4	7	51	6	3480400		3480400A	
4.5	7	51	6	3480450		3480450A	
5	8	52	6	3480500		3480500A	
5.5	8	52	6	3480550		3480550A	
6	8	52	6	3480600		3480600A	
6.5	10	60	10	3480650		3480650A	
7	10	60	10	3480700		3480700A	
7.5	10	60	10	3480750		3480750A	
8	11	61	10	3480800		3480800A	
8.5	11	61	10	3480850		3480850A	
9	11	61	10	3480900		3480900A	
9.5	11	61	10	3480950		3480950A	
10	13	63	10	3481000		3481000A	
10.5	13	70	12	3481050		3481050A	
11	13	70	12	3481100		3481100A	
11.5	13	70	12	3481150		3481150A	
12	16	73	12	3481200		3481200A	
13	16	73	12	3481300		3481300A	
14	16	73	12	3481400		3481400A	
15	16	73	12	3481500		3481500A	
16	19	79	16	3481600		3481600A	
17	19	79	16	3481700		3481700A	
18	19	79	16	3481800		3481800A	
19	19	79	16	3481900		3481900A	
*20	19	79	16	3482000		3482000A	
*22	26	102	25	3482200		3482200A	
24	26	102	25	3482400		3482400A	
25	26	102	25	3482500		3482500A	
26	26	102	25	3482600		3482600A	
28	26	102	25	3482800		3482800A	
30	26	102	25	3483000		3483000A	
32	32	112	32	3483200		3483200A	
35	32	112	32	3483500		3483500A	
36	32	112	32	3483600		3483600A	
38	38	118	32	3483800		3483800A	
*40	38	118	32	3484000		3484000A	
*42	38	118	32	3484200		3484200A	
*45	38	118	32	3484500		3484500A	
*50	45	125	32	3485000		3485000A	

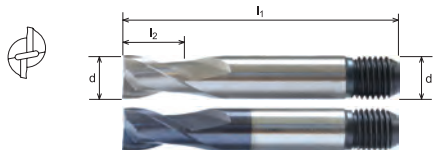
Not available once current stock is depleted

* Lengths not to DIN 327



2 Flute End Mills (Slot Drills)

Milling keyways and slots to size in one cut.
Designed for plunging operations. High
tensile steels and other difficult materials.



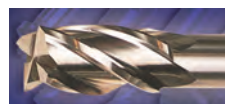
OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	○	○	○	○	○	○	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

d	l2	l1	d1	Uncoated		TiAlN Coated	
				Code	Price	Code	Price
1/16	2.5	48	1/4	3490159		3490159A	
1/8	8	51	1/4	3490318		3490318A	
3/16	10	52	1/4	3490476		3490476A	
1/4	11	56	1/4	3490635		3490635A	
5/16	13	60	3/8	3490794		3490794A	
3/8	14	60	3/8	3490953		3490953A	
7/16	17	65	1/2	3491111		3491111A	
1/2	19	67	1/2	3491270		3491270A	
9/16	22	69	1/2	3491429		3491429A	
5/8	22	72	5/8	3491588		3491588A	
3/4	25	77	5/8	3491905		3491905A	
7/8	25	100	1"	3492223		3492223A	
1"	27	95	1"	3492540		3492540A	
1.1/8	30	95	1"	3492858		3492858A	
1.1/4	35	117	1.1/4	3493175		3493175A	
1.3/8	40	111	1.1/4	3493493		3493493A	
1.1/2	43	115	1.1/4	3493810		3493810A	
1.5/8	48	118	1.1/4	3494128		3494128A	
1.3/4	48	118	1.1/4	3494445		3494445A	
1.7/8	51	118	1.1/4	3494763		3494763A	
2"	51	118	1.1/4	3495080		3495080A	

Code
349

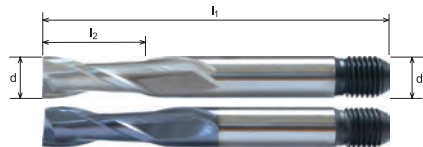
Properties		
inch	BS 122	HSS Co8
	TYPE N	
		Z 2
	UNCOATED TiAlN	
		pg 204





OSG GROUP COMPANY

2 Flute End Mills (Slot Drills)
Milling keyways and slots to size in one cut. Designed for plunging operations. High tensile steels and other difficult materials.



Code

350

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

Properties

mm	BS 122	HSS Co8
	TYPE N	
	30°	Z 2
	UNCOATED TiAlN	

d	l ₂	l ₁	d ₁	Uncoated		TiAlN Coated	
				Code	Price	Code	Price
2	4	51	6	3500200		3500200A	
2.5	6.5	54	6	3500250		3500250A	
3	11	60.5	6	3500300		3500300A	
3.5	12.5	66.5	6	3500350		3500350A	
4	12.5	66.5	6	3500400		3500400A	
4.5	12.5	66.5	6	3500450		3500450A	
5	12.5	70	6	3500500		3500500A	
5.5	16	76	6	3500550		3500550A	
6	16	76	6	3500600		3500600A	
6.5	16	76	10	3500650		3500650A	
7	16	76	10	3500700		3500700A	
7.5	16	76	10	3500750		3500750A	
8	19	79.5	10	3500800		3500800A	
8.5	22	82.5	10	3500850		3500850A	
9	22	82.5	10	3500900		3500900A	
9.5	22	82.5	10	3500950		3500950A	
10	22	82.5	10	3501000		3501000A	
11	22	89	12	3501100		3501100A	
12	25.5	95	12	3501200		3501200A	
13	25.5	95	12	3501300		3501300A	
14	28.5	101.5	12	3501400		3501400A	
*15	31.5	108	12	3501500		3501500A	
16	31.5	108	16	3501600		3501600A	
17	35	114.5	16	3501700		3501700A	
18	35	114.5	16	3501800		3501800A	
19	38	120.5	16	3501900		3501900A	
20	38	120.5	16	3502000		3502000A	

* Not to BS 122



SHANK
CUTTERS



shaping your dreams

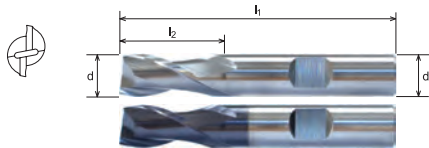
176

JUNE 2023 V3 SOMTA CATALOGUE

www.somta.co.za

2 Flute End Mills (Slot Drills)

Milling keyways and slots to size in one cut.
Designed for plunging operations. High tensile
steels and other difficult materials.



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	○		○	○			●	●	●	○				○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

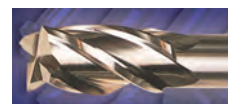
d	l2	l1	d1	Uncoated		TiAlN Coated	
				Code	Price	Code	Price
2	4	48	6	3050200	-	-	-
3	5	49	6	3050300	-	-	-
4	7	51	6	3050400	-	3050400A	-
5.5	8	52	6	3050550	-	-	-
6	8	52	6	3050600	-	3050600A	-
6.5	10	60	10	3050650	-	3050650A	-
7	10	60	10	3050700	-	3050700A	-
9	11	61	10	-	-	3050900A	-
10	13	63	10	3051000	-	3051000A	-
11	13	70	12	-	-	3051100A	-
15	16	73	12	3051500	-	3051500A	-
18	19	79	16	3051800	-	-	-
19	19	79	16	3051900	-	3051900A	-
22	22	88	20	3052200	-	-	-
24	26	102	25	3052400	-	-	-

Not available once current stock is depleted



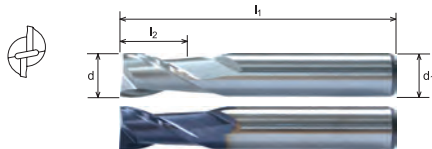
Code
305

Properties		
mm	DIN 327	HSS Co8
	TYPE N	
	30°	Z 2
	UNCOATED	
	TiAlN	pg 204



2 Flute End Mills (Slot Drills)

Milling keyways and slots to size in one cut.
Designed for plunging operations. High tensile
steels and other difficult materials.

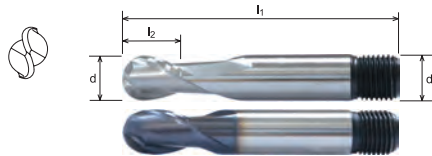


P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	○	○	○	○	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

d	l2	l1	d1	Uncoated		TiAlN Coated	
				Code	Price	Code	Price
2	4	48	6	3100200		-	
3	5	49	6	-		3100300A	
3.5	6	50	6	3100350		-	
4	7	51	6	3100400		-	
4.5	7	51	6	3100450		3100450A	
5.5	8	52	6	-		3100550A	
6.5	10	60	10	-		3100650A	
7	10	60	10	3100700		3100700A	
7.5	10	60	10	3100750		3100750A	
8.5	11	61	10	3100850		3100850A	
9	11	61	10	3100900		3100900A	
9.5	11	61	10	3100950		3100950A	
11	13	70	12	3101100		3101100A	
13	16	73	12	-		3101300A	
14	16	73	12	3101400		-	
17	19	79	16	3101700		3101700A	
18	19	79	16	3101800		-	
19	19	79	16	3101900		3101900A	

Not available once current stock is depleted





OSG GROUP COMPANY

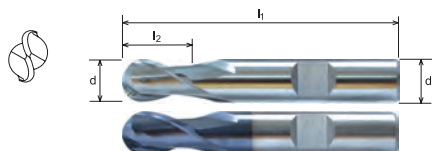
2 Flute Ball Nose End Mills

Milling keyways and slots to size in one cut.
Designed for plunging operations & contouring.
Produces a radius at the bottom of the cut.

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	○	○	○	○	○	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

d	l ₂	l ₁	d ₁	Uncoated		TiAlN Coated	
				Code	Price	Code	Price
2	4	48	6	3400200		3400200A	
3	5	49	6	3400300		3400300A	
4	7	51	6	3400400		3400400A	
5	8	52	6	3400500		3400500A	
6	8	52	6	3400600		3400600A	
7	10	60	10	3400700		3400700A	
8	11	61	10	3400800		3400800A	
9	11	61	10	3400900		3400900A	
10	13	63	10	3401000		3401000A	
11	13	70	12	3401100		3401100A	
12	16	73	12	3401200		3401200A	
13	16	73	12	3401300		3401300A	
14	16	73	12	3401400		3401400A	
15	16	73	12	3401500		3401500A	
16	19	79	16	3401600		3401600A	
18	19	79	16	3401800		3401800A	
*20	19	79	16	3402000		3402000A	
20	22	88	20	3402001		3402001A	
*22	26	102	25	3402200		3402200A	
24	26	102	25	3402400		3402400A	
25	26	102	25	3402500		3402500A	

* Lengths not to DIN 327



2 Flute Ball Nose End Mills

Milling keyways and slots to size in one cut.
Designed for plunging operations & contouring.
Produces a radius at the bottom of the cut.

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	○	○	○	○	○	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

d	l ₂	l ₁	d ₁	Uncoated		TiAlN Coated	
				Code	Price	Code	Price
5	8	52	6	-		3370500A	
6	8	52	6	3370600		3370600A	
8	11	61	10	3370800		-	
24	26	102	25	3372400		-	

Not available once current stock is depleted

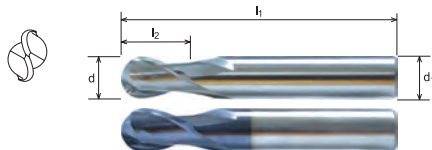


Code
337

Properties			
mm	DIN 327	HSS Co8	
	TYPE N		
	30°	Z 2	
	UNCOATED		
	h6	TiAlN	pg 204

2 Flute Ball Nose End Mills

Milling keyways and slots to size in one cut.
Designed for plunging operations & contouring.
Produces a radius at the bottom of the cut.



P						M				K				Ti			Ni				Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4	
●	●	●	●	●	●	○	○	○	○	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	

d	l2	l1	d1	Uncoated		TiAlN Coated	
				Code	Price	Code	Price
2	4	48	6	-	-	3120200A	-
3	5	49	6	-	-	3120300A	-
5	8	52	6	3120500	-	3120500A	-
6	8	52	6	-	-	3120600A	-
7	10	60	10	3120700	-	3120700A	-
8	11	61	10	-	-	3120800A	-
9	11	61	10	-	-	3120900A	-
11	13	70	12	3121100	-	3121100A	-
12	16	73	12	-	-	3121200A	-
13	16	73	12	3121300	-	-	-
14	16	73	12	3121400	-	3121400A	-
15	16	73	12	3121500	-	3121500A	-
16	19	79	16	3121600	-	3121600A	-
18	19	79	16	3121800	-	3121800A	-
24	26	102	25	3122400	-	-	-

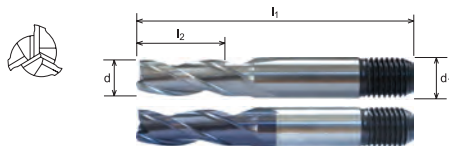
Not available once current stock is depleted



Code
342

3 Flute End Mills

Multi-purpose tool used for slotting and profiling. High tensile steels and other difficult materials.



P						M				K				Ti			Ni				Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4	
●	●	●	●	●	●	○	○	○	○	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	

d	l2	l1	d1	Uncoated		TiAlN Coated	
				Code	Price	Code	Price
4	12.5	57	6	3420400	-	-	-
7	15	60.5	10	-	-	3420700A	-
9	21	66.5	10	3420900	-	-	-
*15	26.5	71	12	3421500	-	-	-
19	38	83.5	16	3421900	-	3421900A	-

Not available once current stock is depleted

* Not to BS 122





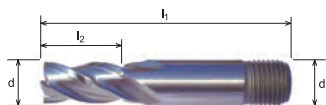
Multi-Flute End Mills For profile milling.



CENTRE CUT
20.0mm and below



CENTRE HOLE
sizes above 20.0mm



OSG GROUP COMPANY

P				M				K				Ti				Ni				Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	○						○	○	○								○	○	○	○	○	○	○								

d	l ₂	l ₁	d ₁	Z Teeth	Code	Price	d	l ₂	l ₁	d ₁	Z Teeth	Code	Price
2.5	6.5	51	6	4	3010250		13	24.5	70	12	4	3011300	
3	9.5	54	6	4	3010300		14	28.5	73	12	4	3011400	
3.5	12.5	57	6	4	3010350		*15	26.5	71	12	4	3011500	
4	12.5	57	6	4	3010400		16	26.5	77	16	4	3011600	
4.5	12.5	57	6	4	3010450		18	35	80	16	4	3011800	
5	16	60.5	6	4	3010500		19	38	83.5	16	4	3011900	
5.5	16	60.5	6	4	3010550		20	38	83.5	16	4	3012000	
6	16	60.5	6	4	3010600		22	41.5	98.5	25	6	3012200	
6.5	16	60.5	10	4	3010650		24	41.5	98.5	25	6	3012400	
7	15	60.5	10	4	3010700		25	44.5	101.5	25	6	3012500	
7.5	18	63.5	10	4	3010750		28	46	104.5	25	6	3012800	
8	18	63.5	10	4	3010800		30	46	104.5	25	6	3013000	
8.5	21	66.5	10	4	3010850		32	51	112.5	32	6	3013200	
9	21	66.5	10	4	3010900		35	54	116	32	6	3013500	
9.5	21	66.5	10	4	3010950		38	54	116	32	6	3013800	
10	21	66.5	10	4	3011000		40	55.5	117.5	32	8	3014000	
10.5	19	66.5	12	4	3011050		45	57	119	32	8	3014500	
11	19	66.5	12	4	3011100		50	65	127	32	8	3015000	
12	24	70	12	4	3011200								

d	l ₂	l ₁	d ₁	Z Teeth	Code	Price	d	l ₂	l ₁	d ₁	Z Teeth	Code	Price
1/8	10	54	1/4	4	3030318		5/8	32	77	5/8	4	3031588	
3/16	13	57	1/4	4	3030476		3/4	38	83	5/8	4	3031905	
1/4	16	60	1/4	4	3030635		7/8	41	98	1"	6	3032223	
5/16	18	64	3/8	4	3030794		15/16	41	98	1"	6	3032381	
3/8	22	67	3/8	4	3030953		1"	43	102	1"	6	3032540	
1/2	24	70	1/2	4	3031270		1.7/8	62	124	1.1/4	8	3034763	
9/16	29	73	1/2	4	3031429								

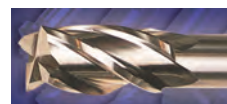
Not available once current stock is depleted

* Not to BS 122



Code
301, 303

Properties		
mm inch	BS 122	HSS
	TYPE N	
	30°	Z 4 - 8
	h8	pg 203





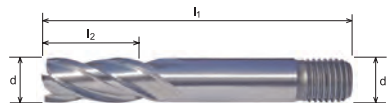
OSG GROUP COMPANY



CENTRE CUT
20,0mm and below



CENTRE HOLE
sizes above 20,0mm



Multi-Flute End Mills

For profile milling.

Code
306

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	○							○	○	○								○	○	○	○	○	○	○								

d	l ₂	l ₁	d ₁	Z Teeth	Code	Price
*15	58.5	103	12	4	3061500	

d	l ₂	l ₁	d ₁	Z Teeth	Code	Price
19	76	121.5	16	4	3061900	

Not available once current stock is depleted

* Not to BS 122



Properties		
mm	BS 122	HSS
	TYPE N	
	30°	Z 4 - 8
	h8	pg 203



SHANK
CUTTERS

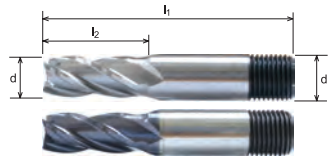


shaping your dreams

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JUNE 2023 V3 SOMTA CATALOGUE

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OSG GROUP COMPANY

Multi-Flute End Mills

For profile milling, high tensile steels and other difficult materials.

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	○		○	○	○	○	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	

Code
344

d	l ₂	l ₁	d ₁	Z Teeth	Uncoated		TiAlN Coated	
					Code	Price	Code	Price
2.5	6.5	51	6	4	3440250		3440250A	
3	9.5	54	6	4	3440300		3440300A	
3.5	12.5	57	6	4	3440350		3440350A	
4	12.5	57	6	4	3440400		3440400A	
4.5	12.5	57	6	4	3440450		3440450A	
5	16	60.5	6	4	3440500		3440500A	
5.5	16	60.5	6	4	3440550		3440550A	
6	16	60.5	6	4	3440600		3440600A	
6.5	16	60.5	10	4	3440650		3440650A	
7	15	60.5	10	4	3440700		3440700A	
7.5	18	63.5	10	4	3440750		3440750A	
8	18	63.5	10	4	3440800		3440800A	
8.5	21	66.5	10	4	3440850		3440850A	
9	21	66.5	10	4	3440900		3440900A	
9.5	21	66.5	10	4	3440950		3440950A	
10	21	66.5	10	4	3441000		3441000A	
10.5	19	66.5	12	4	3441050		3441050A	
11	19	66.5	12	4	3441100		3441100A	
12	24	70	12	4	3441200		3441200A	
13	24.5	70	12	4	3441300		3441300A	
14	28.5	73	12	4	3441400		3441400A	
*15	26.5	71	12	4	3441500		3441500A	
16	26.5	77	16	4	3441600		3441600A	
18	35	80	16	4	3441800		3441800A	
19	38	83.5	16	4	3441900		3441900A	
20	38	83.5	16	4	3442000		3442000A	
22	41.5	98.5	25	6	3442200		3442200A	
24	41.5	98.5	25	6	3442400		3442400A	
25	44.5	101.5	25	6	3442500		3442500A	
28	46	104.5	25	6	3442800		3442800A	
30	46	104.5	25	6	3443000		3443000A	
32	51	112.5	32	6	3443200		3443200A	
35	54	116	32	6	3443500		3443500A	
38	54	116	32	6	3443800		3443800A	
40	55.5	117.5	32	8	3444000		3444000A	
45	57	119	32	8	3444500		3444500A	
50	65	127	32	8	3445000		3445000A	

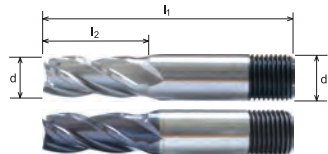
Properties			
mm	BS 122	HSS Co8	
	TYPE N		k10
	30°	Z	4 - 8
	h8	UNCOATED	TiAlN
			pg 204

* Not to BS 122





OSG GROUP COMPANY



Multi-Flute End Mills

For profile milling, high tensile steels and other difficult materials.

Code
345

P						M				K				Ti			Ni				Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4	
●	●	●	●	○	○	○	○	○	○	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	

Properties		
inch	BS 122	HSS Co8
	TYPE N	
	30°	Z 4
	UNCOATED TiAIN	

d	l ₂	l ₁	d ₁	Z Teeth	Uncoated		TiAlN Coated	
					Code	Price	Code	Price
1/8	10	54	1/4	4	3450318		3450318A	
1/4	16	60	1/4	4	3450635		3450635A	
5/16	18	64	3/8	4	3450794		3450794A	
3/8	22	67	3/8	4	3450953		3450953A	
7/16	22	67	1/2	4	3451111		3451111A	
1/2	24	70	1/2	4	3451270		3451270A	
5/8	32	77	5/8	4	3451588		3451588A	
3/4	38	83	5/8	4	3451905		3451905A	



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Multi-Flute End Mills

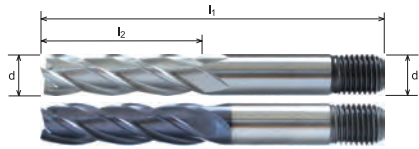
For profile milling, high tensile
steels and other difficult materials.



CENTRE CUT
20.0mm and below



CENTRE HOLE
sizes above 20.0mm



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	○	○	○	○	○	○	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

d	l2	l1	d1	Z Teeth	Uncoated		TiAlN Coated	
					Code	Price	Code	Price
3	19	63.5	6	4	3460300		3460300A	
4	25.5	70	6	4	3460400		3460400A	
5	31.5	76	6	4	3460500		3460500A	
6	31.5	76	6	4	3460600		3460600A	
7	34	79.5	10	4	3460700		3460700A	
8	34	79.5	10	4	3460800		3460800A	
9	37	82.5	10	4	3460900		3460900A	
10	37	82.5	10	4	3461000		3461000A	
11	41.5	89	12	4	3461100		3461100A	
12	49.5	95	12	4	3461200		3461200A	
13	50	95	12	4	3461300		3461300A	
14	57	101.5	12	4	3461400		3461400A	
*15	58.5	103	12	4	3461500		3461500A	
16	58.5	108.5	16	4	3461600		3461600A	
18	70	115	16	4	3461800		3461800A	
19	76	121.5	16	4	3461900		3461900A	
20	76	121.5	16	4	3462000		3462000A	
22	85.5	143	25	6	3462200		3462200A	
24	92	149	25	6	3462400		3462400A	
25	100	157	25	6	3462500		3462500A	
28	98.5	157	25	6	3462800		3462800A	
30	98.5	157	25	6	3463000		3463000A	
32	101.5	163.5	32	6	3463200		3463200A	

* Not to BS 122



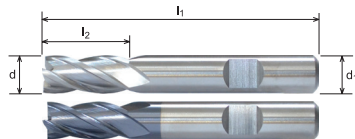
Code
346

Properties		
mm	BS 122	HSS Co8
	TYPE N	
	30°	Z 4 - 8
	UNCOATED TiAlN	
	h8	pg 204





OSG GROUP COMPANY



Multi-Flute End Mills

For profile milling, high tensile steels and other difficult materials.

Code
359

P						M				K				Ti			Ni			Cu				N				Syn			H					
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4			3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	○	○	○	○	○	○			●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	

Properties		
mm	DIN 844	HSS Co8
	TYPE N	
	30°	Z 4-6
	UNCOATED	
h6	TiAIN	pg 204

d	l ₂	l ₁	d ₁	Z Teeth	Uncoated		TiAIN Coated	
					Code	Price	Code	Price
3	8	52	6	4	3590300		3590300A	
4	11	55	6	4	3590400		3590400A	
5	13	57	6	4	3590500		3590500A	
6	13	57	6	4	3590600		3590600A	
7	16	66	10	4	3590700		3590700A	
8	19	69	10	4	3590800		3590800A	
9	19	69	10	4	3590900		3590900A	
10	22	72	10	4	3591000		3591000A	
11	22	79	12	4	3591100		3591100A	
12	26	83	12	4	3591200		3591200A	
13	26	83	12	4	3591300		3591300A	
14	26	83	12	4	3591400		3591400A	
15	26	83	12	4	3591500		3591500A	
16	32	92	16	4	3591600		3591600A	
18	32	92	16	4	3591800		3591800A	
20	38	104	20	4	3592000		3592000A	
22	38	104	20	6	3592200		3592200A	
25	45	121	25	6	3592500		3592500A	



SHANK
CUTTERS

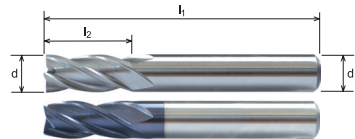


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JUNE 2023 V3 SOMTA CATALOGUE

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Multi-Flute End Mills

For profile milling, high tensile steels and other difficult materials.

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	○		○	○			●	●	●	○				○	○	○	○	○	○	○	○	○	○	○	○	○					

d	l ₂	l ₁	d ₁	Z Teeth	Uncoated		TiAlN Coated	
					Code	Price	Code	Price
3	8	52	6	4	3140300		3140300A	
4	11	55	6	4	3140400		3140400A	
5	13	57	6	4	3140500		3140500A	
6	13	57	6	4	3140600		3140600A	
7	16	66	10	4	3140700		3140700A	
8	19	69	10	4	3140800		3140800A	
9	19	69	10	4	3140900		3140900A	
10	22	72	10	4	3141000		3141000A	
11	22	79	12	4	3141100		3141100A	
12	26	83	12	4	3141200		3141200A	
13	26	83	12	4	3141300		3141300A	
14	26	83	12	4	3141400		3141400A	
15	26	83	12	4	3141500		3141500A	
16	32	92	16	4	3141600		3141600A	
18	32	92	16	4	3141800		3141800A	
19	32	92	16	4	3141900		3141900A	
20	38	104	20	4	3142000		3142000A	
22	38	104	20	6	3142200		3142200A	
25	45	121	25	6	3142500		3142500A	

Code
314

Properties		
mm	DIN 844	HSS Co8
	TYPE N	
	30°	Z 4 - 6
	UNCOATED	
	TiAlN	pg 204



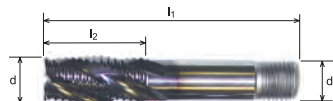


OSG GROUP COMPANY

Roughing End Mills
Maximum stock removal at high feed rates in profiling applications.



CENTRE CUT
20.0mm and below



P						M				K				Ti			Ni			Cu				N				Syn			H				
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4	
●	●	●	●	○	○	○	○			●	●	●	○				○	○	○	○	○	○	○	○	○	○	○	○	○	○	○				

d	l2	l1	d1	Z Teeth	Code	Price
6	16	60.5	6	4	3160600	
8	18	63.5	10	4	3160800	
10	21	66.5	10	4	3161000	
12	24	70	12	4	3161200	

d	l2	l1	d1	Z Teeth	Code	Price
14	28.5	73	12	4	3161400	
16	26.5	77	16	4	3161600	
20	38	83.5	16	4	3162000	

Code
316

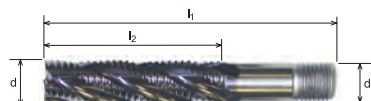
Properties		
mm	BS 122	HSS Co8
30°	Z 4	h8
NR	TiAIN	pg 205



Roughing End Mills
Maximum stock removal at high feed rates in profiling applications.



CENTRE CUT
20.0mm and below



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	○	○	○	○			●	●	●	○				○	○	○	○	○	○	○	○	○	○	○	○	○	○	○			

d	l2	l1	d1	Z Teeth	Code	Price
10	37	82.5	10	4	3181000	
12	49.5	95	12	4	3181200	
14	57	101.5	12	4	3181400	

d	l2	l1	d1	Z Teeth	Code	Price
16	58.5	108.5	16	4	3181600	
20	76	121.5	16	4	3182000	

Code
318

Properties		
mm	BS 122	HSS Co8
30°	Z 4	h8
NR	TiAIN	pg 205



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CUTTERS



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Roughing End Mills

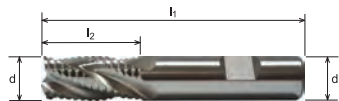
Maximum stock removal at high feed rates in profiling applications.



CENTRE CUT
20.0mm and below



CENTRE HOLE
sizes above 20.0mm



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	○	○	○	○			●	●	●	○				○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

d	l2	l1	d1	Z Teeth	Code	Price	d	l2	l1	d1	Z Teeth	Code	Price
6	13	57	6	4	3300600								

Not available once current stock is depleted



Code
330

Properties		
mm	DIN 844	HSS Co8
30°	Z 4 - 6	Ø h6
NR	pg 206	

Roughing End Mills

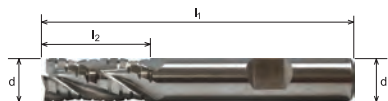
Maximum stock removal at high feed rates in profiling applications.



CENTRE CUT
20.0mm and below



CENTRE HOLE
sizes above 20.0mm



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	○	○	○	○	○	○	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

d	l2	l1	d1	Z Teeth	Code	Price	d	l2	l1	d1	Z Teeth	Code	Price
12	26	83	12	4	3681200		30	45	121	25	5	3683000	
14	26	83	12	4	3681400		40	63	155	32	6	3684000	

Not available once current stock is depleted



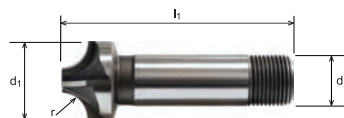
Code
368

Properties		
mm	DIN 844	HSS Co8
30°	Z 4 - 6	Ø h6
NF	pg 206	



Corner Rounding Cutters

To produce a true radius up to a quarter of a circle application.



Code
363

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	○	○	○	○	●	●	●	●							●	●	●	●	●	●	●	●	●	●	●	●	●	●	

r	d1	d2	l1	Code	Price
2	10	10	60	3630200	
3	12	12	60	3630300	
4	14	12	60	3630400	
5	16	12	60	3630500	
6	20	16	67	3630600	
8	24	16	71	3630800	

r	d1	d2	l1	Code	Price
10	28	25	85	3631000	
12	34	25	90	3631200	
14	44	25	100	3631400	
16	48	25	100	3631600	
20	52	32	112	3632000	

Properties			
mm	DIN 6518 FORM D	HSS Co8	
Z 4	pg 207		



Code
363

Corner Rounding Cutters

To produce a true radius up to a quarter of a circle application.



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	○	○	○	○	●	●	●	●							●	●	●	●	●	●	●	●	●	●	●	●	●	●	

r	d1	d2	l1	Code	Price
2	10	10	60	3630201	
3	12	12	60	3630301	
4	14	12	60	3630401	
5	16	12	60	3630501	
6	20	16	67	3630601	
8	24	16	71	3630801	

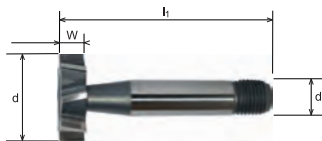
r	d1	d2	l1	Code	Price
10	28	25	85	3631001	
12	34	25	90	3631201	
14	44	25	100	3631401	
16	48	25	100	3631601	
18	54	32	112	3631801	
20	56	32	112	3632001	

Properties			
mm	DIN 6518 FORM B	HSS Co8	
Z 4	pg 207		



Woodruff Cutters

To produce a keyway to suit woodruff keys.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	○	○	○	○	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

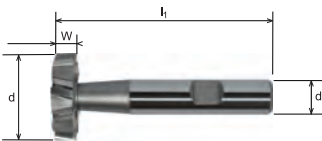
d	W	l1	d1	Z Teeth	Code	Price	d	W	l1	d1	Z Teeth	Code	Price
10.5	2	56	12	6	3660010		22.5	5	64	12	10	3660160	
10.5	2.5	56	12	6	3660020		22.5	6	64	12	10	3660170	
10.5	3	56	12	6	3660030		22.5	8	64	12	10	3660175	
13.5	3	56	12	10	3660060		25.5	6	70	12	10	3660190	
13.5	4	56	12	10	3660070		28.5	6	70	12	10	3660230	
16.5	3	56	12	10	3660090		28.5	8	70	12	10	3660250	
16.5	4	56	12	10	3660100		28.5	10	70	12	10	3660255	
16.5	5	56	12	10	3660110		32.5	7	70	12	10	3660280	
19.5	4	57	12	10	3660130		32.5	8	70	12	12	3660290	
19.5	5	57	12	10	3660140		32.5	10	70	12	12	3660295	
19.5	6	57	12	10	3660145		45.5	10	76	12	12	3660380	

pg 249



Woodruff Cutters

To produce a keyway to suit woodruff keys.



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	○	○	○	○	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

d	W	l1	d1	Z Teeth	Code	Price	d	W	l1	d1	Z Teeth	Code	Price
10.5	2	50	6	6	3741050		22.5	5	63	10	10	3742250	
10.5	2.5	50	6	6	3741051		22.5	6	63	10	10	3742251	
10.5	3	50	6	6	3741052		22.5	8	63	10	10	3742252	
13.5	3	56	10	10	3741350		25.5	6	63	10	10	3742550	
13.5	4	56	10	10	3741351		28.5	6	63	10	10	3742850	
16.5	3	56	10	10	3741650		28.5	8	63	10	10	3742851	
16.5	4	56	10	10	3741651		28.5	10	71	12	10	3742852	
16.5	5	56	10	10	3741652		32.5	8	71	12	12	3743250	
19.5	4	63	10	10	3741950		32.5	10	71	12	12	3743251	
19.5	5	63	10	10	3741951		45.5	10	71	12	12	3744550	
19.5	6	63	10	10	3741952								

pg 249



Code

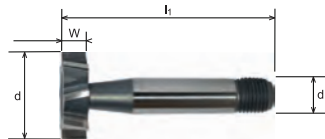
374

Properties

mm	DIN 850	HSS Co5
mm	W=8 d=h11	W=8 d=h11
h6	Z 8 - 12	pg 207




Woodruff Cutters

To produce a keyway to suit woodruff keys.



Code
367

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	○	○	○	○	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

Properties		
inch	BASED ON BS 122	HSS CoS
		
Z 8 - 10	pg 207	Ø h8

Size	d	W	L _i	d ₁	Z Teeth	Code	Price
204	1/2	1/16	56	1/2	8	3670010	
304	1/2	3/32	56	1/2	8	3670020	
404	1/2	1/8	56	1/2	8	3670030	
305	5/8	3/32	56	1/2	8	3670040	
405	5/8	1/8	56	1/2	8	3670050	
505	5/8	5/32	56	1/2	8	3670060	
406	3/4	1/8	56	1/2	8	3670070	
506	3/4	5/32	56	1/2	8	3670080	
606	3/4	3/16	56	1/2	8	3670090	
507	7/8	5/32	64	1/2	8	3670100	
607	7/8	3/16	64	1/2	8	3670110	
807	7/8	1/4	64	1/2	8	3670130	
608	1"	3/16	70	1/2	8	3670140	
808	1"	1/4	70	1/2	8	3670160	
1008	1"	5/16	70	1/2	8	3670170	
609	1.1/8	3/16	70	1/2	8	3670180	
809	1.1/8	1/4	70	1/2	8	3670200	
1009	1.1/8	5/16	70	1/2	8	3670210	
810	1.1/4	1/4	70	1/2	8	3670240	
1010	1.1/4	5/16	70	1/2	8	3670250	
1210	1.1/4	3/8	70	1/2	8	3670260	
1011	1.3/8	5/16	76	1/2	10	3670280	

Not available once current stock is depleted

Tolerance on Cutting Diameter (d)

+ 0.381

+0.127

Tolerance on Width (W)

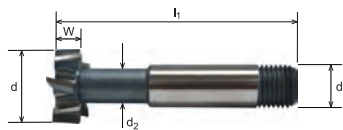
+0.000

-0.025



T-Slot Cutters

For opening out the bottom of previously milled slot to form a T-slot.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	○	○	○	○	●	●	●	●							●	●	●	●	●	●	●	●	●	●					

Bolt Size	d	W	d ₁	d ₂	l ₁	Z Teeth	Code	Price
6	12.5	6	10	5	55	6	3710600	
8	16	8	10	7	60	6	3710800	
10	18	8	12	8	62	6	3711000	
12	21	9	12	10	68	8	3711200	
14	25	11	16	12	70	8	3711400	
*16	28	12	16	13	75	8	3711600	

* Sizes not to DIN or ISO



Code

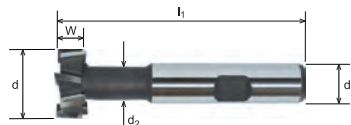
371

Properties

mm	BASED ON ISO 3337 DIN 851	HSS Co5
	Z 6 - 10	pg 208

T-Slot Cutters

For opening out the bottom of previously milled slot to form a T-slot.



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	○	○	○		●	●	●	●							●	●	●	●	●	●	●	●	●	●					

Bolt Size	d	W	d ₁	d ₂	l ₁	Z Teeth	Code	Price
6	12.5	6	10	5	57	6	3850600	
8	16	8	10	7	62	6	3850800	
10	18	8	12	8	70	6	3851000	
12	21	9	12	10	74	8	3851200	
14	25	11	16	12	82	8	3851400	
16	28	12	16	13	85	8	3851600	



Code

385

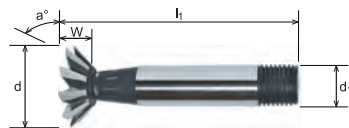
Properties

mm	DIN 851	HSS Co5
	Z 6 - 10	pg 208



Dovetail Cutters

To produce dovetail slides for machine tool tables, jigs and fixtures.



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	○	○	○		●	●	●	●							●	●	●	●	●	●	●	●	●	●					

d	d1	Z Teeth	a° = 45°				a° = 60°			
			W	L1	Code	Price	W	L1	Code	Price
16	12	6	4	60	3760020		6.3	60	3760120	
20	12	8	5	63	3760030		8	63	3760130	
25	12	10	6.3	67	3760040		10	67	3760140	
32	16	12	8	71	3760050		12.5	71	3760150	
*40	16	14	10	71	3760060		16	80	3760160	

* Sizes not to DIN or ISO



Code
386

Dovetail Cutters

To produce dovetail slides for machine tool tables, jigs and fixtures.



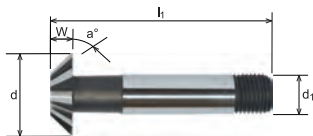
P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	○	○	○	○	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

d	d1	Z Teeth	a° = 45°				a° = 60°			
			W	L1	Code	Price	W	L1	Code	Price
16	12	6	4	60	3861600		6.3	60	3861601	
20	12	8	5	63	3862000		8	63	3862001	
25	12	10	6.3	67	3862500		10	67	3862501	
32	16	12	8	71	3863200		12.5	71	3863201	
40	16	14	10	71	3864000		16	80	3864001	



Inverted Dovetail Cutters

To produce opposite section of dovetail slide to Dovetail cutter.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	○	○	○	○	●	●	●	●							●	●	●	●	●	●	●	●	●	●	●	●	●	●	●

d	d1	Z Teeth	a° = 45°				a° = 60°			
			W	l1	Code	Price	W	l1	Code	Price
16	12	6	4	60	3780010		6.3	60	3780110	
20	12	8	5	63	3780020		8	63	3780120	
25	12	10	6.3	67	3780030		10	67	3780130	
32	16	12	8	71	3780040		12.5	71	3780140	
*40	16	14	10	71	3780050		-	-	-	

Not available once current stock is depleted

* Sizes not to DIN or ISO

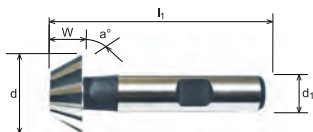


Code
378

Properties		
mm	BASED ON DIN 1833 ISO 3859	HSS Co5
		Z 6 - 14
	pg 208	

Inverted Dovetail Cutters

To produce opposite section of dovetail slide to Dovetail cutter.



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	○	○	○	○	●	●	●	●							●	●	●	●	●	●	●	●	●	●	●	●	●	●	●

d	d1	Z Teeth	a° = 45°				a° = 60°			
			W	l1	Code	Price	W	l1	Code	Price
16	12	6	4	60	3891600		6.3	60	3891601	
20	12	8	5	63	3892000		8	63	3892001	
25	12	10	6.3	67	3892500		10	67	3892501	
32	16	12	8	71	3893200		12.5	71	3893201	



Code
389

Properties		
mm	DIN 1833 FORM D	HSS Co5
		Z 6 - 14
	pg 208	



Shank Cutters Cutting Data



**If you have any cutting tool problem,
please feel free to contact our technical sales representatives.**

Download the Somta Tools app to access machining data on your mobile or desktop.

02A, 02R

Recommended feed in mm per tooth for Carbide End Mills based on 1.0 x D cutting depth with 0.5 x D cutting width.

For slotting up to 1.0 x D, reduce by 30%.

Material	Ø	Vc m/min	1	2	3	4	5	6	8	10	12	16
			F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)
N	7.1 ●	1250	0.011-0.018	0.014-0.023	0.020-0.034	0.027-0.045	0.034-0.056	0.041-0.068	0.054-0.090	0.068-0.113	0.081-0.135	0.108-0.180
	7.2 ●	1000	0.009-0.015	0.012-0.020	0.018-0.030	0.024-0.040	0.031-0.051	0.037-0.061	0.049-0.081	0.061-0.101	0.073-0.121	0.098-0.163
	7.3 ●	1000	0.009-0.015	0.012-0.020	0.018-0.030	0.024-0.040	0.031-0.051	0.037-0.061	0.049-0.081	0.061-0.101	0.073-0.121	0.098-0.163
	7.4 ○	1000	0.009-0.015	0.012-0.020	0.018-0.030	0.024-0.040	0.031-0.051	0.037-0.061	0.049-0.081	0.061-0.101	0.073-0.121	0.098-0.163

02S, 02U

Recommended feed in mm per tooth for Carbide End Mills based on 1.0 x D cutting depth with 0.5 x D cutting width.

For slotting up to 1.0 x D, reduce by 30%.

Material	Ø	Vc m/min	3	4	5	6	8	10	12	16
			F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)
N	7.1 ●	1250	0.024-0.040	0.031-0.051	0.037-0.061	0.045-0.075	0.060-0.100	0.075-0.125	0.090-0.150	0.120-0.200
	7.2 ●	1000	0.020-0.034	0.027-0.045	0.034-0.056	0.041-0.068	0.054-0.090	0.068-0.113	0.081-0.135	0.108-0.180
	7.3 ●	1000	0.020-0.034	0.027-0.045	0.034-0.056	0.041-0.068	0.054-0.090	0.068-0.113	0.081-0.135	0.108-0.180
	7.4 ○	1000	0.020-0.034	0.027-0.045	0.034-0.056	0.041-0.068	0.054-0.090	0.068-0.113	0.081-0.135	0.108-0.180

02T

Recommended feed in mm per tooth for Carbide End Mills based on 1.0 x D cutting depth with 1.0 x D cutting width.

Material	Ø	Vc m/min	3	4	5	6	8	10	12
			F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)
N	7.1 ●	180	0.006-0.010	0.011-0.019	0.011-0.019	0.019-0.031	0.023-0.038	0.030-0.050	0.038-0.063
	7.2 ○	140	0.006-0.010	0.011-0.019	0.011-0.019	0.019-0.031	0.023-0.038	0.030-0.050	0.038-0.063
	7.4 ○	110	0.006-0.010	0.011-0.019	0.011-0.019	0.019-0.031	0.023-0.038	0.030-0.050	0.038-0.063
	8.1 ●	180	0.006-0.010	0.011-0.019	0.011-0.019	0.019-0.031	0.023-0.038	0.030-0.050	0.038-0.063
Syn	8.2 ○	180	0.006-0.010	0.011-0.019	0.011-0.019	0.019-0.031	0.023-0.038	0.030-0.050	0.038-0.063

03C

Recommended feed in mm per tooth for Carbide End Mills based on 1.0 x D cutting depth with 0.5 x D cutting width.

For slotting up to 1.0 x D, reduce by 30%.

Material	Ø	Vc m/min	6	8	10	12	16	20
			F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)
N	7.1 ●	1250	0.050-0.083	0.066-0.110	0.083-0.138	0.099-0.165	0.132-0.220	0.165-0.275
	7.2 ●	1000	0.044-0.074	0.059-0.099	0.074-0.124	0.089-0.149	0.119-0.198	0.149-0.248
	7.3 ●	1000	0.044-0.074	0.059-0.099	0.074-0.124	0.089-0.149	0.119-0.198	0.149-0.248
	7.4 ○	1000	0.044-0.074	0.059-0.099	0.074-0.124	0.089-0.149	0.119-0.198	0.149-0.248



OSG GROUP COMPANY



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Parameters based on ideal conditions.
Please adjust parameters accordingly to real applications.

03D, 03F

Recommended feed in mm per tooth for Carbide End Mills based on 1.0 x D cutting depth with 0.5 x D cutting width.
For slotting up to 1.0 x D, reduce by 30%.

Material	Ø	Vc m/min	6	8	10	12	16	20
P	1.1 ●	175	0.033-0.055	0.045-0.075	0.054-0.090	0.062-0.104	0.076-0.126	0.086-0.143
	1.2 ●	175	0.033-0.055	0.045-0.075	0.054-0.090	0.062-0.104	0.076-0.126	0.086-0.143
	1.3 ●	140	0.027-0.045	0.038-0.063	0.046-0.076	0.053-0.088	0.065-0.109	0.076-0.126
	1.4 ●	140	0.027-0.045	0.038-0.063	0.046-0.076	0.053-0.088	0.065-0.109	0.076-0.126
	1.5 ●	120	0.025-0.041	0.034-0.056	0.041-0.068	0.047-0.078	0.058-0.096	0.066-0.110
	1.6 ●	120	0.025-0.041	0.034-0.056	0.041-0.068	0.047-0.078	0.058-0.096	0.066-0.110
M	2.1 ○	90	0.027-0.045	0.038-0.063	0.046-0.076	0.053-0.088	0.065-0.109	0.076-0.126
	2.2 ○	90	0.027-0.045	0.038-0.063	0.046-0.076	0.053-0.088	0.065-0.109	0.076-0.126
	2.3 ○	80	0.022-0.036	0.030-0.050	0.036-0.060	0.042-0.070	0.053-0.088	0.061-0.101
K	3.1 ●	140	0.033-0.055	0.045-0.075	0.054-0.090	0.062-0.104	0.076-0.126	0.086-0.143
	3.2 ●	115	0.022-0.036	0.030-0.050	0.036-0.060	0.042-0.070	0.053-0.088	0.061-0.101
	3.3 ●	125	0.027-0.045	0.038-0.063	0.046-0.076	0.053-0.088	0.065-0.109	0.076-0.126
	3.4 ●	115	0.022-0.036	0.030-0.050	0.036-0.060	0.042-0.070	0.053-0.088	0.061-0.101
Ti	4.1 ●	65	0.022-0.036	0.030-0.050	0.036-0.060	0.042-0.070	0.053-0.088	0.061-0.101
	4.2 ○	68	0.022-0.036	0.030-0.050	0.036-0.060	0.042-0.070	0.053-0.088	0.061-0.101
	4.3 ○	55	0.020-0.033	0.028-0.046	0.034-0.056	0.039-0.065	0.048-0.080	0.056-0.093
Ni	5.1 ○	30	0.014-0.024	0.020-0.033	0.024-0.040	0.028-0.046	0.035-0.058	0.041-0.068
	5.2 ○	30	0.014-0.024	0.020-0.033	0.024-0.040	0.028-0.046	0.035-0.058	0.041-0.068
	5.3 ○	30	0.014-0.024	0.020-0.033	0.024-0.040	0.028-0.046	0.035-0.058	0.041-0.068

03E

Recommended feed in mm per tooth for Carbide End Mills based on 1.0 x D cutting depth with 0.5 x D cutting width.
For slotting up to 1.0 x D, reduce by 30%.

Material	Ø	Vc m/min	6	8	10	12	16	20
P	1.1 ●	175	0.027-0.045	0.037-0.061	0.044-0.074	0.054-0.090	0.065-0.109	0.074-0.123
	1.2 ●	165	0.027-0.045	0.037-0.061	0.044-0.074	0.054-0.090	0.065-0.109	0.074-0.123
	1.3 ●	140	0.023-0.038	0.031-0.051	0.037-0.061	0.046-0.076	0.056-0.094	0.065-0.109
	1.4 ●	140	0.023-0.038	0.031-0.051	0.037-0.061	0.046-0.076	0.056-0.094	0.065-0.109
	1.5 ●	120	0.020-0.034	0.028-0.046	0.033-0.055	0.041-0.068	0.050-0.083	0.057-0.095
	1.6 ●	110	0.020-0.034	0.028-0.046	0.033-0.055	0.041-0.068	0.050-0.083	0.057-0.095
M	2.1 ○	90	0.023-0.038	0.031-0.051	0.037-0.061	0.046-0.076	0.056-0.094	0.065-0.109
	2.2 ○	90	0.023-0.038	0.031-0.051	0.037-0.061	0.046-0.076	0.056-0.094	0.065-0.109
	2.3 ○	80	0.018-0.030	0.025-0.041	0.029-0.049	0.037-0.061	0.045-0.075	0.053-0.088
K	3.1 ●	140	0.027-0.045	0.037-0.061	0.044-0.074	0.054-0.090	0.065-0.109	0.074-0.123
	3.2 ●	115	0.018-0.030	0.025-0.041	0.029-0.049	0.037-0.061	0.045-0.075	0.053-0.088
	3.3 ●	125	0.023-0.038	0.031-0.051	0.037-0.061	0.046-0.076	0.056-0.094	0.065-0.109
	3.4 ●	115	0.018-0.030	0.025-0.041	0.029-0.049	0.037-0.061	0.045-0.075	0.053-0.088
Ti	4.1 ●	65	0.018-0.030	0.025-0.041	0.029-0.049	0.037-0.061	0.045-0.075	0.053-0.088

03G

Recommended feed in mm per tooth for Coated Carbide End Mills based on 2.0 x D cutting depth with 0.15 x D cutting width.

Material	Ø	Vc m/min	6	8	10	12	16	20
P	1.6 ●	130	0.027-0.045	0.037-0.061	0.044-0.074	0.052-0.086	0.063-0.105	0.080-0.134

Recommended feed in mm per tooth for Coated Carbide End Mills based on 1.5 x D cutting depth with 0.02 x D cutting width.

Material	Ø	Vc m/min	6	8	10	12	16	20
H	9.1 ●	100	0.027-0.045	0.037-0.061	0.044-0.074	0.052-0.086	0.063-0.105	0.080-0.134
	9.2 ●	80	0.020-0.034	0.028-0.046	0.033-0.055	0.038-0.064	0.047-0.079	0.059-0.098
	9.3 ●	80	0.020-0.034	0.028-0.046	0.033-0.055	0.038-0.064	0.047-0.079	0.059-0.098
	9.4 ○	80	0.020-0.034	0.028-0.046	0.033-0.055	0.038-0.064	0.047-0.079	0.059-0.098

Parameters based on ideal conditions.
Please adjust parameters accordingly to real applications.



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03H

Recommended feed in mm per tooth for Coated Carbide End Mills based on Ap1 and Ap2 max.
For Circular Interpolation note min and max circle diameter range.

Material	Ø	Vc m/min	6	8	10	12	16	20
			F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)
P	1.6	110	0.150-0.250	0.188-0.313	0.225-0.375	0.300-0.500	0.375-0.625	0.450-0.750
	9.1	110	0.150-0.250	0.188-0.313	0.225-0.375	0.300-0.500	0.375-0.625	0.450-0.750
	9.2	85	0.113-0.188	0.150-0.250	0.188-0.313	0.225-0.375	0.300-0.500	0.375-0.625
	9.3	85	0.113-0.188	0.150-0.250	0.188-0.313	0.225-0.375	0.300-0.500	0.375-0.625
	9.4	85	0.113-0.188	0.150-0.250	0.188-0.313	0.225-0.375	0.300-0.500	0.375-0.625

	Ramping Guide for Circular and Linear Ramping							
	Circular Interpolation		Linear Ramping					
d	min	max	1°	2°	3°	4°	5°	
6	8.64	12.00	18.12	9.06	6.03	4.52	3.61	
8	11.52	16.00	24.16	12.08	8.05	6.03	4.82	
10	14.40	20.00	30.20	15.09	10.06	7.54	6.02	
12	17.28	24.00	36.24	18.11	12.07	9.05	7.23	
16	23.04	32.00	48.31	24.15	16.09	12.05	9.64	
20	28.80	40.00	50.39	30.19	20.11	15.08	12.05	
Recommended % of Programmed Feed Rate to use while Ramping:			100%	70%	50%	30%	10%	

03I, 03J

Recommended feed in mm per tooth for Coated Carbide End Mills based on 0.03 x D cutting depth with 0.03 x D cutting width.

Material	Ø	Vc m/min	4	6	8	10	12	16	20
			F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)
P	1.6	345	0.075-0.125	0.120-0.200	0.165-0.275	0.195-0.325	0.225-0.375	0.285-0.475	0.323-0.538

Recommended feed in mm per tooth for Coated Carbide End Mills based on 0.03 x D cutting depth with 0.02 x D cutting width.

Material	Ø	Vc m/min	4	6	8	10	12	16	20
			F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)
H	9.1	260	0.075-0.125	0.120-0.200	0.165-0.275	0.195-0.325	0.225-0.375	0.285-0.475	0.323-0.538
	9.2	205	0.060-0.100	0.090-0.150	0.120-0.200	0.150-0.250	0.173-0.288	0.210-0.350	0.240-0.400
	9.3	205	0.060-0.100	0.090-0.150	0.120-0.200	0.150-0.250	0.173-0.288	0.210-0.350	0.240-0.400
	9.4	205	0.060-0.100	0.090-0.150	0.120-0.200	0.150-0.250	0.173-0.288	0.210-0.350	0.240-0.400



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Parameters based on ideal conditions.
Please adjust parameters accordingly to real applications.

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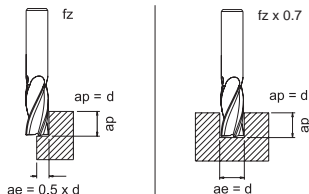


TABLE SHOWS fz VALUES

Material	Ø	Vc m/min	5	6	8	10	12	16	20	25
			F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)
P	1.1	175	0.027-0.045	0.033-0.055	0.045-0.075	0.054-0.090	0.062-0.103	0.076-0.126	0.086-0.143	0.093-0.155
	1.2	165	0.027-0.045	0.033-0.055	0.045-0.075	0.054-0.090	0.062-0.103	0.076-0.126	0.086-0.143	0.093-0.155
	1.3	140	0.023-0.038	0.027-0.045	0.037-0.061	0.044-0.074	0.050-0.084	0.062-0.104	0.071-0.118	0.077-0.128
	1.4	120	0.020-0.034	0.025-0.041	0.034-0.056	0.041-0.068	0.047-0.078	0.057-0.095	0.065-0.108	0.070-0.116
	1.5	120	0.020-0.034	0.025-0.041	0.034-0.056	0.041-0.068	0.047-0.078	0.057-0.095	0.065-0.108	0.070-0.116
	1.6	110	0.020-0.034	0.025-0.041	0.034-0.056	0.041-0.068	0.047-0.078	0.057-0.095	0.065-0.108	0.070-0.116
M	2.1	103	0.023-0.038	0.027-0.045	0.037-0.061	0.044-0.074	0.050-0.084	0.062-0.104	0.071-0.118	0.077-0.128
	2.2	103	0.023-0.038	0.027-0.045	0.037-0.061	0.044-0.074	0.050-0.084	0.062-0.104	0.071-0.118	0.077-0.128
	2.3	65	0.016-0.026	0.019-0.031	0.026-0.043	0.031-0.051	0.035-0.059	0.044-0.073	0.049-0.081	0.053-0.089
	2.4	63	0.016-0.026	0.019-0.031	0.026-0.043	0.031-0.051	0.035-0.059	0.044-0.073	0.049-0.081	0.053-0.089
K	3.1	135	0.027-0.045	0.033-0.055	0.045-0.075	0.054-0.090	0.062-0.103	0.076-0.126	0.086-0.143	0.093-0.155
	3.2	120	0.023-0.038	0.027-0.045	0.037-0.061	0.044-0.074	0.050-0.084	0.062-0.104	0.071-0.118	0.077-0.128
	3.3	135	0.027-0.045	0.033-0.055	0.045-0.075	0.054-0.090	0.062-0.103	0.076-0.126	0.086-0.143	0.093-0.155
	3.4	115	0.018-0.030	0.023-0.038	0.031-0.051	0.037-0.061	0.042-0.070	0.052-0.086	0.058-0.096	0.063-0.105
Ti	4.1	70	0.018-0.030	0.023-0.038	0.031-0.051	0.037-0.061	0.042-0.070	0.052-0.086	0.058-0.096	0.063-0.105
	4.2	63	0.016-0.026	0.019-0.031	0.026-0.043	0.031-0.051	0.035-0.059	0.044-0.073	0.049-0.081	0.053-0.089
	4.3	55	0.016-0.026	0.019-0.031	0.026-0.043	0.031-0.051	0.035-0.059	0.044-0.073	0.049-0.081	0.053-0.089
Ni	5.1	70	0.023-0.038	0.027-0.045	0.037-0.061	0.044-0.074	0.050-0.084	0.062-0.104	0.071-0.118	0.077-0.128
	5.2	70	0.023-0.038	0.027-0.045	0.037-0.061	0.044-0.074	0.050-0.084	0.062-0.104	0.071-0.118	0.077-0.128
	5.3	33	0.013-0.021	0.015-0.025	0.021-0.035	0.025-0.041	0.029-0.048	0.035-0.059	0.040-0.066	0.044-0.073
Cu	6.1	250	0.038-0.063	0.053-0.088	0.053-0.088	0.060-0.100	0.060-0.100	0.068-0.113	0.075-0.125	0.075-0.125
	6.2	240	0.038-0.063	0.053-0.088	0.053-0.088	0.060-0.100	0.060-0.100	0.068-0.113	0.075-0.125	0.075-0.125
	6.3	240	0.038-0.063	0.053-0.088	0.053-0.088	0.060-0.100	0.060-0.100	0.068-0.113	0.075-0.125	0.075-0.125
N	6.4	190	0.019-0.031	0.026-0.044	0.026-0.044	0.030-0.050	0.030-0.050	0.034-0.056	0.038-0.063	0.038-0.063
	7.1	450	0.038-0.063	0.075-0.125	0.150-0.250	0.150-0.250	0.150-0.250	0.225-0.375	0.375-0.625	0.375-0.625
	7.2	185	0.038-0.063	0.075-0.125	0.150-0.250	0.150-0.250	0.150-0.250	0.225-0.375	0.375-0.625	0.375-0.625
	7.3	120	0.038-0.063	0.075-0.125	0.150-0.250	0.150-0.250	0.150-0.250	0.225-0.375	0.375-0.625	0.375-0.625
	7.4	110	0.038-0.063	0.075-0.125	0.150-0.250	0.150-0.250	0.150-0.250	0.225-0.375	0.375-0.625	0.375-0.625
Syn	8.1	250	0.014-0.023	0.017-0.028	0.023-0.038	0.027-0.045	0.033-0.055	0.044-0.073	0.055-0.091	0.068-0.113
	8.2	250	0.014-0.023	0.017-0.028	0.023-0.038	0.027-0.045	0.033-0.055	0.044-0.073	0.055-0.091	0.068-0.113
	8.3	100	0.014-0.023	0.017-0.028	0.023-0.038	0.027-0.045	0.033-0.055	0.044-0.073	0.055-0.091	0.068-0.113

Parameters based on ideal conditions.
Please adjust parameters accordingly to real applications.

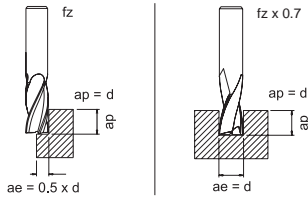


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Coated 03A, 03B, 03M, 03N, 03P

Use 50% of recommended feed rate for long series end mills.



TABLES SHOW fz VALUES

Material	Ø	Vc m/min	2	4	6	8	10	12	16	20	25
			F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)
P	1.1	175	0.019-0.031	0.019-0.031	0.024-0.039	0.035-0.059	0.040-0.067	0.050-0.083	0.058-0.096	0.063-0.104	0.068-0.114
	1.2	125	0.019-0.031	0.019-0.031	0.024-0.039	0.035-0.059	0.040-0.067	0.050-0.083	0.058-0.096	0.063-0.104	0.068-0.114
	1.3	100	0.019-0.031	0.019-0.031	0.024-0.039	0.035-0.059	0.040-0.067	0.050-0.083	0.058-0.096	0.063-0.104	0.068-0.114
	1.4	65	0.019-0.031	0.019-0.031	0.020-0.033	0.026-0.044	0.030-0.050	0.030-0.050	0.040-0.067	0.050-0.083	0.055-0.091
	1.5	40	0.019-0.031	0.019-0.031	0.020-0.033	0.026-0.044	0.030-0.050	0.030-0.050	0.040-0.067	0.050-0.083	0.055-0.091
M	2.1	65	0.006-0.010	0.008-0.013	0.011-0.019	0.015-0.025	0.023-0.038	0.030-0.050	0.038-0.063	0.045-0.075	0.053-0.088
	2.2	55	0.006-0.010	0.008-0.013	0.011-0.019	0.015-0.025	0.023-0.038	0.030-0.050	0.038-0.063	0.045-0.075	0.053-0.088
	2.3	48	0.006-0.010	0.006-0.009	0.008-0.013	0.011-0.019	0.015-0.025	0.023-0.038	0.030-0.050	0.034-0.056	0.038-0.063
K	3.1	120	0.019-0.031	0.019-0.031	0.024-0.039	0.035-0.059	0.040-0.067	0.050-0.083	0.058-0.096	0.063-0.104	0.068-0.114
	3.2	90	0.019-0.031	0.019-0.031	0.020-0.033	0.026-0.044	0.030-0.050	0.030-0.050	0.040-0.067	0.050-0.083	0.055-0.091
	3.3	120	0.019-0.031	0.019-0.031	0.024-0.039	0.035-0.059	0.040-0.067	0.050-0.083	0.058-0.096	0.063-0.104	0.068-0.114
	3.4	90	0.019-0.031	0.019-0.031	0.020-0.033	0.026-0.044	0.030-0.050	0.030-0.050	0.040-0.067	0.050-0.083	0.055-0.091
Ti	4.1	56	0.005-0.008	0.009-0.015	0.018-0.030	0.025-0.041	0.029-0.049	0.034-0.056	0.041-0.069	0.046-0.077	0.050-0.084
	4.2	50	0.004-0.006	0.008-0.013	0.015-0.025	0.020-0.034	0.025-0.041	0.028-0.047	0.035-0.058	0.039-0.065	0.043-0.071
	4.3	40	0.004-0.006	0.008-0.013	0.015-0.025	0.020-0.034	0.025-0.041	0.028-0.047	0.035-0.058	0.039-0.065	0.043-0.071
Ni	5.1	40	0.017-0.029	0.017-0.029	0.026-0.043	0.026-0.043	0.035-0.058	0.043-0.071	0.046-0.077	0.052-0.087	0.056-0.094
	5.2	33	0.012-0.019	0.012-0.019	0.017-0.029	0.017-0.029	0.023-0.038	0.027-0.045	0.029-0.048	0.035-0.058	0.038-0.063
	5.3	18	0.012-0.019	0.012-0.019	0.017-0.029	0.017-0.029	0.023-0.038	0.027-0.045	0.029-0.048	0.035-0.058	0.038-0.063
Cu	6.1	100	0.038-0.063	0.038-0.063	0.053-0.088	0.053-0.088	0.060-0.100	0.060-0.100	0.068-0.113	0.075-0.125	0.075-0.125
	6.2	100	0.038-0.063	0.038-0.063	0.053-0.088	0.053-0.088	0.060-0.100	0.060-0.100	0.068-0.113	0.075-0.125	0.075-0.125
	6.3	100	0.038-0.063	0.038-0.063	0.053-0.088	0.053-0.088	0.060-0.100	0.060-0.100	0.068-0.113	0.075-0.125	0.075-0.125
	6.4	75	0.019-0.031	0.019-0.031	0.026-0.044	0.026-0.044	0.030-0.050	0.030-0.050	0.034-0.056	0.038-0.063	0.038-0.063
N	7.1	105	0.038-0.063	0.038-0.063	0.075-0.125	0.150-0.250	0.150-0.250	0.150-0.250	0.225-0.375	0.375-0.625	0.375-0.625
	7.2	88	0.038-0.063	0.038-0.063	0.075-0.125	0.150-0.250	0.150-0.250	0.150-0.250	0.225-0.375	0.375-0.625	0.375-0.625
	7.3	63	0.038-0.063	0.038-0.063	0.075-0.125	0.150-0.250	0.150-0.250	0.150-0.250	0.225-0.375	0.375-0.625	0.375-0.625
	7.4	63	0.038-0.063	0.038-0.063	0.075-0.125	0.150-0.250	0.150-0.250	0.150-0.250	0.225-0.375	0.375-0.625	0.375-0.625
Syn	8.1	175	0.006-0.010	0.011-0.019	0.017-0.028	0.023-0.038	0.027-0.045	0.033-0.055	0.044-0.073	0.055-0.091	0.068-0.113
	8.2	175	0.006-0.010	0.011-0.019	0.017-0.028	0.023-0.038	0.027-0.045	0.033-0.055	0.044-0.073	0.055-0.091	0.068-0.113
	8.3	75	0.006-0.010	0.011-0.019	0.017-0.028	0.023-0.038	0.027-0.045	0.033-0.055	0.044-0.073	0.055-0.091	0.068-0.113



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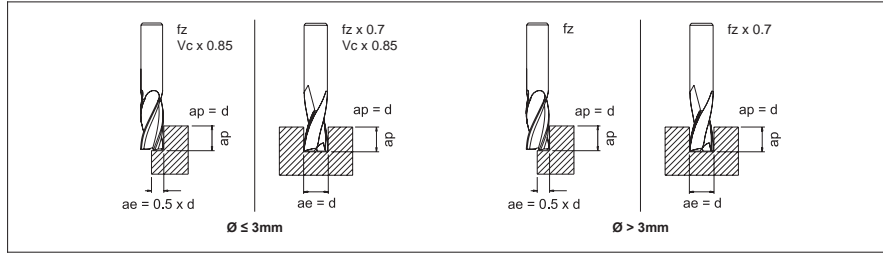
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Parameters based on ideal conditions.
Please adjust parameters accordingly to real applications.

Coated 03K, 03L

Use 50% of recommended feed rate for long series end mills.



TABLES SHOW fz VALUES

Material	Ø	Vc m/min	2	4	6	8	10	12	16	20	25
			F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)
P	1.1	210	0.019-0.031	0.019-0.031	0.024-0.039	0.035-0.059	0.040-0.067	0.050-0.083	0.058-0.096	0.063-0.104	0.068-0.114
	1.2	150	0.019-0.031	0.019-0.031	0.024-0.039	0.035-0.059	0.040-0.067	0.050-0.083	0.058-0.096	0.063-0.104	0.068-0.114
	1.3	120	0.019-0.031	0.019-0.031	0.024-0.039	0.035-0.059	0.040-0.067	0.050-0.083	0.058-0.096	0.063-0.104	0.068-0.114
	1.4	78	0.019-0.031	0.019-0.031	0.020-0.033	0.026-0.044	0.030-0.050	0.030-0.050	0.040-0.067	0.050-0.083	0.055-0.091
	1.5	48	0.019-0.031	0.019-0.031	0.020-0.033	0.026-0.044	0.030-0.050	0.030-0.050	0.040-0.067	0.050-0.083	0.055-0.091
M	2.1	78	0.006-0.010	0.008-0.013	0.011-0.019	0.015-0.025	0.023-0.038	0.030-0.050	0.038-0.063	0.045-0.075	0.053-0.088
	2.2	66	0.006-0.010	0.008-0.013	0.011-0.019	0.015-0.025	0.023-0.038	0.030-0.050	0.038-0.063	0.045-0.075	0.053-0.088
	2.3	58	0.006-0.010	0.006-0.009	0.008-0.013	0.011-0.019	0.015-0.025	0.023-0.038	0.030-0.050	0.034-0.056	0.038-0.063
K	3.1	144	0.019-0.031	0.019-0.031	0.024-0.039	0.035-0.059	0.040-0.067	0.050-0.083	0.058-0.096	0.063-0.104	0.068-0.114
	3.2	108	0.019-0.031	0.019-0.031	0.020-0.033	0.026-0.044	0.030-0.050	0.030-0.050	0.040-0.067	0.050-0.083	0.055-0.091
	3.3	144	0.019-0.031	0.019-0.031	0.024-0.039	0.035-0.059	0.040-0.067	0.050-0.083	0.058-0.096	0.063-0.104	0.068-0.114
	3.4	108	0.019-0.031	0.019-0.031	0.020-0.033	0.026-0.044	0.030-0.050	0.030-0.050	0.040-0.067	0.050-0.083	0.055-0.091
Ti	4.1	67	0.005-0.008	0.009-0.015	0.018-0.030	0.025-0.041	0.029-0.049	0.034-0.056	0.041-0.069	0.046-0.077	0.050-0.084
	4.2	60	0.004-0.006	0.008-0.013	0.015-0.025	0.020-0.034	0.025-0.041	0.028-0.047	0.035-0.058	0.039-0.065	0.043-0.071
	4.3	53	0.004-0.006	0.008-0.013	0.015-0.025	0.020-0.034	0.025-0.041	0.028-0.047	0.035-0.058	0.039-0.065	0.043-0.071
Ni	5.1	48	0.017-0.029	0.017-0.029	0.026-0.043	0.026-0.043	0.035-0.058	0.043-0.071	0.046-0.077	0.052-0.087	0.056-0.094
	5.2	40	0.012-0.019	0.012-0.019	0.017-0.029	0.017-0.029	0.023-0.038	0.027-0.045	0.029-0.048	0.035-0.058	0.038-0.063
	5.3	22	0.012-0.019	0.012-0.019	0.017-0.029	0.017-0.029	0.023-0.038	0.027-0.045	0.029-0.048	0.035-0.058	0.038-0.063
Cu	6.1	120	0.038-0.063	0.038-0.063	0.053-0.088	0.053-0.088	0.060-0.100	0.060-0.100	0.068-0.113	0.075-0.125	0.075-0.125
	6.2	120	0.038-0.063	0.038-0.063	0.053-0.088	0.053-0.088	0.060-0.100	0.060-0.100	0.068-0.113	0.075-0.125	0.075-0.125
	6.3	120	0.038-0.063	0.038-0.063	0.053-0.088	0.053-0.088	0.060-0.100	0.060-0.100	0.068-0.113	0.075-0.125	0.075-0.125
	6.4	90	0.019-0.031	0.019-0.031	0.026-0.044	0.026-0.044	0.030-0.050	0.030-0.050	0.034-0.056	0.038-0.063	0.038-0.063
N	7.1	126	0.038-0.063	0.038-0.063	0.075-0.125	0.150-0.250	0.150-0.250	0.150-0.250	0.225-0.375	0.375-0.625	0.375-0.625
	7.2	106	0.038-0.063	0.038-0.063	0.075-0.125	0.150-0.250	0.150-0.250	0.150-0.250	0.225-0.375	0.375-0.625	0.375-0.625
	7.3	76	0.038-0.063	0.038-0.063	0.075-0.125	0.150-0.250	0.150-0.250	0.150-0.250	0.225-0.375	0.375-0.625	0.375-0.625
	7.4	76	0.038-0.063	0.038-0.063	0.075-0.125	0.150-0.250	0.150-0.250	0.150-0.250	0.225-0.375	0.375-0.625	0.375-0.625
Syn	8.1	210	0.006-0.010	0.011-0.019	0.017-0.028	0.023-0.038	0.027-0.045	0.033-0.055	0.044-0.073	0.055-0.091	0.068-0.113
	8.2	210	0.006-0.010	0.011-0.019	0.017-0.028	0.023-0.038	0.027-0.045	0.033-0.055	0.044-0.073	0.055-0.091	0.068-0.113
	8.3	90	0.006-0.010	0.011-0.019	0.017-0.028	0.023-0.038	0.027-0.045	0.033-0.055	0.044-0.073	0.055-0.091	0.068-0.113

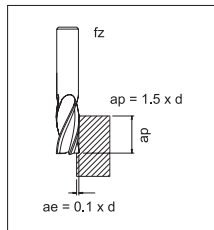


TABLE SHOWS fz VALUES

Material	Ø	Vc m/min	H	9.1
				F (mm/tooth)
4	75	0.014-0.023		
5	75	0.020-0.034		
6	75	0.023-0.039		
8	75	0.031-0.051		
10	75	0.038-0.064		
12	75	0.047-0.079		
14	75	0.053-0.089		
16	75	0.060-0.100		
18	75	0.067-0.111		
20	75	0.070-0.116		

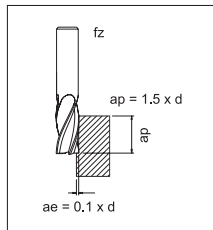


TABLE SHOWS fz VALUES

Material	Ø	Vc m/min	H	9.2
				F (mm/tooth)
4	55	0.006-0.010		
5	55	0.008-0.013		
6	55	0.009-0.015		
8	55	0.013-0.021		
10	55	0.015-0.025		
12	55	0.019-0.031		
14	55	0.022-0.036		
16	55	0.023-0.038		
18	55	0.023-0.038		
20	55	0.023-0.038		

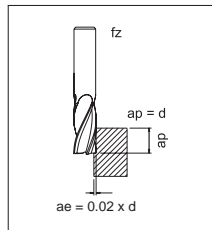


TABLE SHOWS fz VALUES

Material	Ø	Vc m/min	H	9.3
				F (mm/tooth)
4	50	0.006-0.010		
5	50	0.008-0.013		
6	50	0.008-0.013		
8	50	0.013-0.021		
10	50	0.016-0.026		
12	50	0.019-0.031		
14	50	0.022-0.036		
16	50	0.022-0.036		
18	50	0.023-0.038		
20	50	0.023-0.038		

Parameters based on ideal conditions.
Please adjust parameters accordingly to real applications.

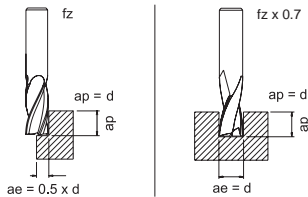


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Uncoated 03A, 03B, 03K, 03L, 03M, 03N, 03P

Use 50% of recommended feed rate for long series end mills.



TABLES SHOW fz VALUES

Material	Ø	Vc m/min	2	4	6	8	10	12	16	20	25
			F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)
P	1.1 ●	101	0.019-0.031	0.019-0.031	0.024-0.039	0.035-0.059	0.040-0.067	0.050-0.083	0.058-0.096	0.063-0.104	0.068-0.114
	1.2 ●	72	0.019-0.031	0.019-0.031	0.024-0.039	0.035-0.059	0.040-0.067	0.050-0.083	0.058-0.096	0.063-0.104	0.068-0.114
	1.3 ●	58	0.019-0.031	0.019-0.031	0.024-0.039	0.035-0.059	0.040-0.067	0.050-0.083	0.058-0.096	0.063-0.104	0.068-0.114
	1.4 ●	37	0.019-0.031	0.019-0.031	0.020-0.033	0.026-0.044	0.030-0.050	0.030-0.050	0.040-0.067	0.050-0.083	0.055-0.091
	1.5 ●	23	0.019-0.031	0.019-0.031	0.020-0.033	0.026-0.044	0.030-0.050	0.030-0.050	0.040-0.067	0.050-0.083	0.055-0.091
M	2.1 ○	37	0.006-0.010	0.008-0.013	0.011-0.019	0.015-0.025	0.023-0.038	0.030-0.050	0.038-0.063	0.045-0.075	0.053-0.088
	2.2 ○	32	0.006-0.010	0.008-0.013	0.011-0.019	0.015-0.025	0.023-0.038	0.030-0.050	0.038-0.063	0.045-0.075	0.053-0.088
K	3.1 ●	69	0.019-0.031	0.019-0.031	0.024-0.039	0.035-0.059	0.040-0.067	0.050-0.083	0.058-0.096	0.063-0.104	0.068-0.114
	3.2 ●	52	0.019-0.031	0.019-0.031	0.020-0.033	0.026-0.044	0.030-0.050	0.030-0.050	0.040-0.067	0.050-0.083	0.055-0.091
	3.3 ●	69	0.019-0.031	0.019-0.031	0.024-0.039	0.035-0.059	0.040-0.067	0.050-0.083	0.058-0.096	0.063-0.104	0.068-0.114
	3.4 ●	52	0.019-0.031	0.019-0.031	0.020-0.033	0.026-0.044	0.030-0.050	0.030-0.050	0.040-0.067	0.050-0.083	0.055-0.091
	4.1 ○	32	0.005-0.008	0.009-0.015	0.018-0.030	0.025-0.041	0.029-0.049	0.034-0.056	0.041-0.069	0.046-0.077	0.050-0.084
Ti	4.2 ○	29	0.004-0.006	0.008-0.013	0.015-0.025	0.020-0.034	0.025-0.041	0.028-0.047	0.035-0.058	0.039-0.065	0.043-0.071
	4.3 ○	25	0.004-0.006	0.008-0.013	0.015-0.025	0.020-0.034	0.025-0.041	0.028-0.047	0.035-0.058	0.039-0.065	0.043-0.071
Ni	5.1 ○	23	0.017-0.029	0.017-0.029	0.026-0.043	0.026-0.043	0.035-0.058	0.043-0.071	0.046-0.077	0.052-0.087	0.056-0.094
	5.2 ○	19	0.012-0.019	0.012-0.019	0.017-0.029	0.017-0.029	0.023-0.038	0.027-0.045	0.029-0.048	0.035-0.058	0.038-0.063
Cu	5.3 ○	10	0.012-0.019	0.012-0.019	0.017-0.029	0.017-0.029	0.023-0.038	0.027-0.045	0.029-0.048	0.035-0.058	0.038-0.063
	6.1 ○	58	0.038-0.063	0.038-0.063	0.053-0.088	0.053-0.088	0.060-0.100	0.060-0.100	0.068-0.113	0.075-0.125	0.075-0.125
	6.2 ○	58	0.038-0.063	0.038-0.063	0.053-0.088	0.053-0.088	0.060-0.100	0.060-0.100	0.068-0.113	0.075-0.125	0.075-0.125
	6.3 ○	58	0.038-0.063	0.038-0.063	0.053-0.088	0.053-0.088	0.060-0.100	0.060-0.100	0.068-0.113	0.075-0.125	0.075-0.125
	6.4 ○	43	0.019-0.031	0.019-0.031	0.026-0.044	0.026-0.044	0.030-0.050	0.030-0.050	0.034-0.056	0.038-0.063	0.038-0.063
N	7.1 ●	105	0.038-0.063	0.038-0.063	0.075-0.125	0.150-0.250	0.150-0.250	0.150-0.250	0.225-0.375	0.375-0.625	0.375-0.625
	7.2 ●	88	0.038-0.063	0.038-0.063	0.075-0.125	0.150-0.250	0.150-0.250	0.150-0.250	0.225-0.375	0.375-0.625	0.375-0.625
	7.3 ●	63	0.038-0.063	0.038-0.063	0.075-0.125	0.150-0.250	0.150-0.250	0.150-0.250	0.225-0.375	0.375-0.625	0.375-0.625
	7.4 ●	63	0.038-0.063	0.038-0.063	0.075-0.125	0.150-0.250	0.150-0.250	0.150-0.250	0.225-0.375	0.375-0.625	0.375-0.625
Syn	8.1 ○	101	0.006-0.010	0.011-0.019	0.017-0.028	0.023-0.038	0.027-0.045	0.033-0.055	0.044-0.073	0.055-0.091	0.068-0.113
	8.2 ○	101	0.006-0.010	0.011-0.019	0.017-0.028	0.023-0.038	0.027-0.045	0.033-0.055	0.044-0.073	0.055-0.091	0.068-0.113
	8.3 ○	43	0.006-0.010	0.011-0.019	0.017-0.028	0.023-0.038	0.027-0.045	0.033-0.055	0.044-0.073	0.055-0.091	0.068-0.113



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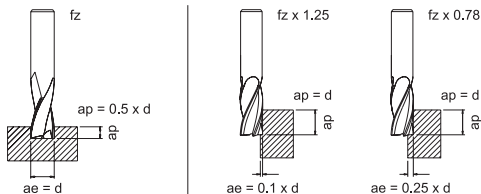
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Parameters based on ideal conditions.
Please adjust parameters accordingly to real applications.

301, 303, 306, 321, 323, 326

Use 50% of recommended feed rate for long series end mills.



TABLES SHOW fz VALUES

Material	Ø	3	4	5	6	8	10	12	14	16	18	20	22
	Vc m/min	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)
P	1.1 ● 35	0.008-0.013	0.011-0.019	0.014-0.023	0.017-0.028	0.023-0.038	0.027-0.045	0.033-0.055	0.038-0.064	0.044-0.073	0.049-0.081	0.055-0.091	0.060-0.100
	1.2 ● 28	0.008-0.013	0.011-0.019	0.014-0.023	0.017-0.028	0.023-0.038	0.027-0.045	0.033-0.055	0.038-0.064	0.044-0.073	0.049-0.081	0.055-0.091	0.060-0.100
	1.3 ● 22	0.008-0.013	0.011-0.019	0.014-0.023	0.017-0.028	0.023-0.038	0.027-0.045	0.033-0.055	0.038-0.064	0.044-0.073	0.049-0.081	0.055-0.091	0.060-0.100
	1.4 ○ 15	0.007-0.011	0.010-0.016	0.012-0.020	0.015-0.025	0.020-0.034	0.024-0.040	0.030-0.050	0.035-0.058	0.039-0.065	0.044-0.073	0.049-0.081	0.054-0.090
K	3.1 ○ 18	0.008-0.013	0.012-0.020	0.017-0.028	0.021-0.035	0.027-0.045	0.030-0.050	0.034-0.056	0.042-0.070	0.048-0.080	0.053-0.088	0.060-0.100	0.066-0.110
	3.2 ○ 14	0.008-0.013	0.012-0.020	0.017-0.028	0.021-0.035	0.027-0.045	0.030-0.050	0.034-0.056	0.042-0.070	0.048-0.080	0.053-0.088	0.060-0.100	0.066-0.110
	3.3 ○ 18	0.008-0.013	0.012-0.020	0.017-0.028	0.021-0.035	0.027-0.045	0.030-0.050	0.034-0.056	0.042-0.070	0.048-0.080	0.053-0.088	0.060-0.100	0.066-0.110
	6.1 ○ 65	0.010-0.016	0.014-0.024	0.017-0.029	0.021-0.035	0.029-0.049	0.035-0.058	0.043-0.071	0.050-0.083	0.056-0.094	0.064-0.106	0.069-0.115	0.078-0.130
Cu	6.2 ○ 55	0.010-0.016	0.014-0.024	0.017-0.029	0.021-0.035	0.029-0.049	0.035-0.058	0.043-0.071	0.050-0.083	0.056-0.094	0.064-0.106	0.069-0.115	0.078-0.130
	6.3 ○ 35	0.010-0.016	0.014-0.024	0.017-0.029	0.021-0.035	0.029-0.049	0.035-0.058	0.043-0.071	0.050-0.083	0.056-0.094	0.064-0.106	0.069-0.115	0.078-0.130
	6.4 ○ 20	0.010-0.016	0.014-0.024	0.017-0.029	0.021-0.035	0.029-0.049	0.035-0.058	0.043-0.071	0.050-0.083	0.056-0.094	0.064-0.106	0.069-0.115	0.078-0.130
	7.1 ○ 850	0.008-0.013	0.011-0.019	0.014-0.023	0.017-0.028	0.023-0.038	0.027-0.045	0.033-0.055	0.038-0.064	0.044-0.073	0.049-0.081	0.055-0.091	0.060-0.100
N	7.2 ○ 175	0.008-0.013	0.011-0.019	0.014-0.023	0.017-0.028	0.023-0.038	0.027-0.045	0.033-0.055	0.038-0.064	0.044-0.073	0.049-0.081	0.055-0.091	0.060-0.100
	7.3 ○ 70	0.008-0.013	0.011-0.019	0.014-0.023	0.017-0.028	0.023-0.038	0.027-0.045	0.033-0.055	0.038-0.064	0.044-0.073	0.049-0.081	0.055-0.091	0.060-0.100

Material	Ø	25	28	30	32	35	40	50
	Vc m/min	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)
P	1.1 ● 35	0.068-0.113	0.077-0.128	0.083-0.138	0.087-0.145	0.098-0.163	0.098-0.163	0.098-0.163
	1.2 ● 28	0.068-0.113	0.077-0.128	0.083-0.138	0.087-0.145	0.098-0.163	0.098-0.163	0.098-0.163
	1.3 ● 22	0.068-0.113	0.077-0.128	0.083-0.138	0.087-0.145	0.098-0.163	0.098-0.163	0.098-0.163
	1.4 ○ 15	0.060-0.100	0.068-0.114	0.075-0.125	0.078-0.130	0.088-0.146	0.088-0.146	0.088-0.146
K	3.1 ○ 18	0.071-0.119	0.083-0.138	0.090-0.150	0.095-0.159	0.107-0.178	0.107-0.178	0.107-0.178
	3.2 ○ 14	0.071-0.119	0.083-0.138	0.090-0.150	0.095-0.159	0.107-0.178	0.107-0.178	0.107-0.178
	3.3 ○ 18	0.071-0.119	0.083-0.138	0.090-0.150	0.095-0.159	0.107-0.178	0.107-0.178	0.107-0.178
	6.1 ○ 65	0.088-0.146	0.099-0.165	0.107-0.179	0.113-0.188	0.128-0.213	0.128-0.213	0.128-0.213
Cu	6.2 ○ 55	0.088-0.146	0.099-0.165	0.107-0.179	0.113-0.188	0.128-0.213	0.128-0.213	0.128-0.213
	6.3 ○ 35	0.088-0.146	0.099-0.165	0.107-0.179	0.113-0.188	0.128-0.213	0.128-0.213	0.128-0.213
	6.4 ○ 20	0.088-0.146	0.099-0.165	0.107-0.179	0.113-0.188	0.128-0.213	0.128-0.213	0.128-0.213
	7.1 ○ 850	0.068-0.113	0.077-0.128	0.083-0.138	0.087-0.145	0.098-0.163	0.098-0.163	0.098-0.163
N	7.2 ○ 175	0.068-0.113	0.077-0.128	0.083-0.138	0.087-0.145	0.098-0.163	0.098-0.163	0.098-0.163
	7.3 ○ 70	0.068-0.113	0.077-0.128	0.083-0.138	0.087-0.145	0.098-0.163	0.098-0.163	0.098-0.163

Parameters based on ideal conditions.
Please adjust parameters accordingly to real applications.



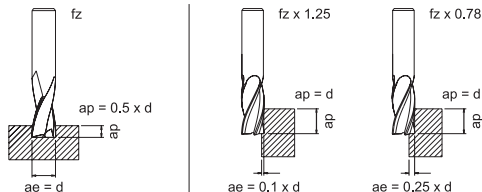
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305, 310, 312, 314, 337, 340, 342, 344, 345, 346, 348, 349, 350, 359

Use 50% of recommended feed rate for long series end mills.

For coated end mills increase surface speed by 20% for all materials, except Aluminium which remains the same.



TABLES SHOW fz VALUES

Material	Ø	3	4	5	6	8	10	12	14	16	18	20	22
	Vc m/min	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)
P	1.1	35	0.008-0.013	0.011-0.019	0.014-0.023	0.017-0.028	0.023-0.038	0.027-0.045	0.033-0.055	0.038-0.064	0.044-0.073	0.049-0.081	0.055-0.091
	1.2	28	0.008-0.013	0.011-0.019	0.014-0.023	0.017-0.028	0.023-0.038	0.027-0.045	0.033-0.055	0.038-0.064	0.044-0.073	0.049-0.081	0.055-0.091
	1.3	22	0.008-0.013	0.011-0.019	0.014-0.023	0.017-0.028	0.023-0.038	0.027-0.045	0.033-0.055	0.038-0.064	0.044-0.073	0.049-0.081	0.055-0.091
	1.4	15	0.007-0.011	0.010-0.016	0.012-0.020	0.015-0.025	0.020-0.034	0.024-0.040	0.030-0.050	0.035-0.058	0.039-0.065	0.044-0.073	0.049-0.081
M	1.5	12	0.006-0.010	0.009-0.015	0.011-0.018	0.014-0.023	0.018-0.030	0.022-0.036	0.027-0.045	0.030-0.050	0.035-0.058	0.039-0.065	0.044-0.073
	2.1	15	0.008-0.013	0.011-0.019	0.014-0.023	0.017-0.028	0.023-0.038	0.027-0.045	0.033-0.055	0.038-0.064	0.044-0.073	0.049-0.081	0.055-0.091
	2.2	8	0.008-0.013	0.011-0.019	0.014-0.023	0.017-0.028	0.023-0.038	0.027-0.045	0.033-0.055	0.038-0.064	0.044-0.073	0.049-0.081	0.055-0.091
	3.1	18	0.008-0.013	0.012-0.020	0.017-0.028	0.021-0.035	0.027-0.045	0.030-0.050	0.034-0.056	0.042-0.070	0.048-0.080	0.053-0.088	0.060-0.100
K	3.2	14	0.008-0.013	0.012-0.020	0.017-0.028	0.021-0.035	0.027-0.045	0.030-0.050	0.034-0.056	0.042-0.070	0.048-0.080	0.053-0.088	0.060-0.100
	3.3	18	0.008-0.013	0.012-0.020	0.017-0.028	0.021-0.035	0.027-0.045	0.030-0.050	0.034-0.056	0.042-0.070	0.048-0.080	0.053-0.088	0.060-0.100
	3.4	14	0.008-0.013	0.012-0.020	0.017-0.028	0.021-0.035	0.027-0.045	0.030-0.050	0.034-0.056	0.042-0.070	0.048-0.080	0.053-0.088	0.060-0.100
	4.1	6	0.006-0.010	0.009-0.015	0.011-0.018	0.014-0.023	0.018-0.030	0.022-0.036	0.027-0.045	0.030-0.050	0.035-0.058	0.039-0.065	0.044-0.073
Ni	5.2	6	0.006-0.010	0.009-0.015	0.011-0.018	0.014-0.023	0.018-0.030	0.022-0.036	0.027-0.045	0.030-0.050	0.035-0.058	0.039-0.065	0.044-0.073
	5.3	6	0.006-0.010	0.009-0.015	0.011-0.018	0.014-0.023	0.018-0.030	0.022-0.036	0.027-0.045	0.030-0.050	0.035-0.058	0.039-0.065	0.044-0.073
	6.1	65	0.010-0.016	0.014-0.024	0.017-0.029	0.021-0.035	0.029-0.049	0.035-0.058	0.043-0.071	0.050-0.083	0.056-0.094	0.064-0.106	0.069-0.115
	6.2	55	0.010-0.016	0.014-0.024	0.017-0.029	0.021-0.035	0.029-0.049	0.035-0.058	0.043-0.071	0.050-0.083	0.056-0.094	0.064-0.106	0.069-0.115
Cu	6.3	35	0.010-0.016	0.014-0.024	0.017-0.029	0.021-0.035	0.029-0.049	0.035-0.058	0.043-0.071	0.050-0.083	0.056-0.094	0.064-0.106	0.069-0.115
	6.4	20	0.010-0.016	0.014-0.024	0.017-0.029	0.021-0.035	0.029-0.049	0.035-0.058	0.043-0.071	0.050-0.083	0.056-0.094	0.064-0.106	0.069-0.115
	7.1	850	0.008-0.013	0.011-0.019	0.014-0.023	0.017-0.028	0.023-0.038	0.027-0.045	0.033-0.055	0.038-0.064	0.044-0.073	0.049-0.081	0.055-0.091
	7.2	175	0.008-0.013	0.011-0.019	0.014-0.023	0.017-0.028	0.023-0.038	0.027-0.045	0.033-0.055	0.038-0.064	0.044-0.073	0.049-0.081	0.055-0.091
N	7.3	70	0.008-0.013	0.011-0.019	0.014-0.023	0.017-0.028	0.023-0.038	0.027-0.045	0.033-0.055	0.038-0.064	0.044-0.073	0.049-0.081	0.055-0.091
	8.1	125	0.008-0.013	0.011-0.019	0.014-0.023	0.017-0.028	0.023-0.038	0.027-0.045	0.033-0.055	0.038-0.064	0.044-0.073	0.049-0.081	0.055-0.091
	8.2	125	0.008-0.013	0.011-0.019	0.014-0.023	0.017-0.028	0.023-0.038	0.027-0.045	0.033-0.055	0.038-0.064	0.044-0.073	0.049-0.081	0.055-0.091
	8.2	125	0.008-0.013	0.011-0.019	0.014-0.023	0.017-0.028	0.023-0.038	0.027-0.045	0.033-0.055	0.038-0.064	0.044-0.073	0.049-0.081	0.055-0.091

Material	Ø	25	28	30	32	35	40	50
	Vc m/min	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)
P	1.1	35	0.068-0.113	0.077-0.128	0.083-0.138	0.087-0.145	0.098-0.163	0.098-0.163
	1.2	28	0.068-0.113	0.077-0.128	0.083-0.138	0.087-0.145	0.098-0.163	0.098-0.163
	1.3	22	0.068-0.113	0.077-0.128	0.083-0.138	0.087-0.145	0.098-0.163	0.098-0.163
	1.4	15	0.060-0.100	0.068-0.114	0.075-0.125	0.078-0.130	0.088-0.146	0.088-0.146
M	1.5	12	0.054-0.090	0.061-0.101	0.066-0.110	0.069-0.115	0.078-0.130	0.078-0.130
	2.1	15	0.068-0.113	0.077-0.128	0.083-0.138	0.087-0.145	0.098-0.163	0.098-0.163
	2.2	8	0.068-0.113	0.077-0.128	0.083-0.138	0.087-0.145	0.098-0.163	0.098-0.163
	3.1	18	0.071-0.119	0.083-0.138	0.090-0.150	0.095-0.159	0.107-0.178	0.107-0.178
K	3.2	14	0.071-0.119	0.083-0.138	0.090-0.150	0.095-0.159	0.107-0.178	0.107-0.178
	3.3	18	0.071-0.119	0.083-0.138	0.090-0.150	0.095-0.159	0.107-0.178	0.107-0.178
	3.4	14	0.071-0.119	0.083-0.138	0.090-0.150	0.095-0.159	0.107-0.178	0.107-0.178
	4.1	6	0.054-0.090	0.061-0.101	0.066-0.110	0.069-0.115	0.078-0.130	0.078-0.130
Ni	5.2	6	0.054-0.090	0.061-0.101	0.066-0.110	0.069-0.115	0.078-0.130	0.078-0.130
	5.3	6	0.054-0.090	0.061-0.101	0.066-0.110	0.069-0.115	0.078-0.130	0.078-0.130
	6.1	65	0.088-0.146	0.099-0.165	0.107-0.179	0.113-0.188	0.128-0.213	0.128-0.213
	6.2	55	0.088-0.146	0.099-0.165	0.107-0.179	0.113-0.188	0.128-0.213	0.128-0.213
Cu	6.3	35	0.088-0.146	0.099-0.165	0.107-0.179	0.113-0.188	0.128-0.213	0.128-0.213
	6.4	20	0.088-0.146	0.099-0.165	0.107-0.179	0.113-0.188	0.128-0.213	0.128-0.213
	7.1	850	0.068-0.113	0.077-0.128	0.083-0.138	0.087-0.145	0.098-0.163	0.098-0.163
	7.2	175	0.068-0.113	0.077-0.128	0.083-0.138	0.087-0.145	0.098-0.163	0.098-0.163
N	7.3	70	0.068-0.113	0.077-0.128	0.083-0.138	0.087-0.145	0.098-0.163	0.098-0.163
	8.1	125	0.068-0.113	0.077-0.128	0.083-0.138	0.087-0.145	0.098-0.163	0.098-0.163
	8.2	125	0.068-0.113	0.077-0.128	0.083-0.138	0.087-0.145	0.098-0.163	0.098-0.163
	8.2	125	0.068-0.113	0.077-0.128	0.083-0.138	0.087-0.145	0.098-0.163	0.098-0.163



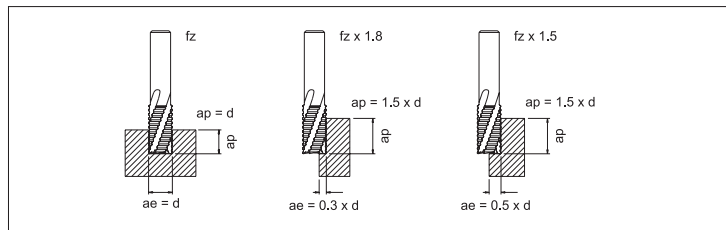
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Parameters based on ideal conditions.
Please adjust parameters accordingly to real applications.

316, 318

Use 50% of recommended feed rate for long series end mills.



TABLES SHOW fz VALUES

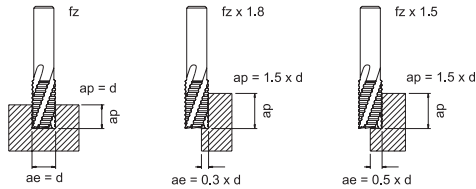
Material	Ø	Vc m/min	6	8	10	12	14	16	22
			F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)
P	1.1	34	0.007-0.012	0.012-0.020	0.015-0.026	0.021-0.035	0.023-0.039	0.027-0.045	0.029-0.048
	1.2	28	0.007-0.012	0.012-0.020	0.018-0.030	0.023-0.038	0.027-0.045	0.034-0.057	0.036-0.060
	1.3	28	0.007-0.012	0.012-0.020	0.018-0.030	0.023-0.038	0.027-0.045	0.034-0.057	0.036-0.060
	1.4	28	0.007-0.012	0.012-0.020	0.018-0.030	0.023-0.038	0.027-0.045	0.034-0.057	0.036-0.060
	1.5	22	0.008-0.014	0.014-0.023	0.018-0.030	0.023-0.038	0.027-0.045	0.034-0.057	0.036-0.060
M	1.6	22	0.008-0.014	0.014-0.023	0.018-0.030	0.023-0.038	0.027-0.045	0.034-0.057	0.036-0.060
	2.1	15	0.009-0.015	0.014-0.023	0.019-0.032	0.030-0.050	0.033-0.056	0.040-0.066	0.043-0.072
K	2.2	15	0.009-0.015	0.014-0.023	0.019-0.032	0.030-0.050	0.033-0.056	0.040-0.066	0.043-0.072
	3.1	34	0.009-0.015	0.014-0.023	0.019-0.032	0.030-0.050	0.033-0.056	0.040-0.066	0.043-0.072
	3.2	15	0.007-0.012	0.012-0.020	0.015-0.026	0.021-0.035	0.023-0.039	0.027-0.045	0.029-0.048
	3.3	22	0.008-0.014	0.014-0.023	0.018-0.030	0.023-0.038	0.027-0.045	0.034-0.057	0.036-0.060
Ni	3.4	15	0.007-0.012	0.012-0.020	0.015-0.026	0.021-0.035	0.023-0.039	0.027-0.045	0.029-0.048
	5.1	114	0.009-0.015	0.014-0.023	0.019-0.032	0.030-0.050	0.033-0.056	0.040-0.066	0.043-0.072
	5.2	241	0.009-0.015	0.014-0.023	0.019-0.032	0.030-0.050	0.033-0.056	0.040-0.066	0.043-0.072
Cu	5.3	10	0.009-0.015	0.014-0.023	0.019-0.032	0.030-0.050	0.033-0.056	0.040-0.066	0.043-0.072
	6.1	65	0.005-0.009	0.008-0.014	0.012-0.020	0.014-0.024	0.019-0.032	0.022-0.036	0.023-0.038
	6.2	58	0.005-0.009	0.008-0.014	0.012-0.020	0.014-0.024	0.019-0.032	0.022-0.036	0.023-0.038
	6.3	40	0.007-0.012	0.011-0.018	0.015-0.026	0.022-0.036	0.023-0.039	0.030-0.050	0.034-0.057
N	6.4	20	0.007-0.012	0.011-0.018	0.015-0.026	0.022-0.036	0.023-0.039	0.030-0.050	0.034-0.057
	7.1	850	0.007-0.012	0.011-0.018	0.015-0.026	0.022-0.036	0.023-0.039	0.030-0.050	0.034-0.057
	7.2	175	0.007-0.012	0.011-0.018	0.015-0.026	0.022-0.036	0.023-0.039	0.030-0.050	0.034-0.057
	7.3	70	0.007-0.012	0.011-0.018	0.015-0.026	0.022-0.036	0.023-0.039	0.030-0.050	0.034-0.057
Syn	8.1	225	0.005-0.009	0.008-0.014	0.011-0.018	0.012-0.020	0.014-0.023	0.017-0.029	0.020-0.033
	8.2	225	0.005-0.009	0.008-0.014	0.011-0.018	0.012-0.020	0.014-0.023	0.017-0.029	0.020-0.033
	8.3	225	0.005-0.009	0.008-0.014	0.011-0.018	0.012-0.020	0.014-0.023	0.017-0.029	0.020-0.033

Parameters based on ideal conditions.
Please adjust parameters accordingly to real applications.



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TABLES SHOW fz VALUES

Material	Ø	Vc m/min	6	8	10	12	14	16	22	25	28	30	32	35
P	1.1	34	0.006-0.010	0.010-0.016	0.013-0.021	0.017-0.029	0.020-0.033	0.023-0.038	0.024-0.040	0.026-0.044	0.026-0.044	0.030-0.050	0.032-0.053	0.032-0.053
	1.2	28	0.006-0.010	0.010-0.016	0.015-0.025	0.019-0.031	0.023-0.038	0.029-0.048	0.030-0.050	0.032-0.053	0.034-0.056	0.034-0.056	0.038-0.063	0.038-0.063
	1.3	28	0.006-0.010	0.010-0.016	0.015-0.025	0.019-0.031	0.023-0.038	0.029-0.048	0.030-0.050	0.032-0.053	0.034-0.056	0.034-0.056	0.038-0.063	0.038-0.063
	1.4	28	0.006-0.010	0.010-0.016	0.015-0.025	0.019-0.031	0.023-0.038	0.029-0.048	0.030-0.050	0.032-0.053	0.034-0.056	0.034-0.056	0.038-0.063	0.038-0.063
	1.5	22	0.007-0.011	0.011-0.019	0.015-0.025	0.019-0.031	0.023-0.038	0.029-0.048	0.030-0.050	0.032-0.053	0.032-0.053	0.034-0.056	0.038-0.063	0.038-0.063
	1.6	22	0.007-0.011	0.011-0.019	0.015-0.025	0.019-0.031	0.023-0.038	0.029-0.048	0.030-0.050	0.032-0.053	0.032-0.053	0.034-0.056	0.038-0.063	0.038-0.063
M	2.1	15	0.008-0.013	0.011-0.019	0.016-0.026	0.025-0.041	0.028-0.046	0.033-0.055	0.036-0.060	0.038-0.063	0.038-0.063	0.042-0.070	0.048-0.080	0.048-0.080
	2.2	15	0.008-0.013	0.011-0.019	0.016-0.026	0.025-0.041	0.028-0.046	0.033-0.055	0.036-0.060	0.038-0.063	0.038-0.063	0.042-0.070	0.048-0.080	0.048-0.080
	3.1	34	0.008-0.013	0.011-0.019	0.016-0.026	0.025-0.041	0.028-0.046	0.033-0.055	0.036-0.060	0.038-0.063	0.038-0.063	0.042-0.070	0.048-0.080	0.048-0.080
	3.2	15	0.006-0.010	0.010-0.016	0.013-0.021	0.017-0.029	0.020-0.033	0.023-0.038	0.024-0.040	0.026-0.044	0.026-0.044	0.030-0.050	0.032-0.053	0.032-0.053
K	3.3	22	0.007-0.011	0.011-0.019	0.015-0.025	0.019-0.031	0.023-0.038	0.029-0.048	0.030-0.050	0.032-0.053	0.032-0.053	0.034-0.056	0.038-0.063	0.038-0.063
	3.4	15	0.006-0.010	0.010-0.016	0.013-0.021	0.017-0.029	0.020-0.033	0.023-0.038	0.024-0.040	0.026-0.044	0.026-0.044	0.030-0.050	0.032-0.053	0.032-0.053
Ni	5.1	52	0.007-0.011	0.011-0.019	0.015-0.025	0.019-0.031	0.023-0.038	0.029-0.048	0.030-0.050	0.032-0.053	0.032-0.053	0.034-0.056	0.038-0.063	0.038-0.063
	5.2	14	0.008-0.013	0.011-0.019	0.016-0.026	0.025-0.041	0.028-0.046	0.033-0.055	0.036-0.060	0.038-0.063	0.038-0.063	0.042-0.070	0.048-0.080	0.048-0.080
	5.3	6	0.008-0.013	0.011-0.019	0.016-0.026	0.025-0.041	0.028-0.046	0.033-0.055	0.036-0.060	0.038-0.063	0.038-0.063	0.042-0.070	0.048-0.080	0.048-0.080
Cu	6.1	65	0.005-0.008	0.007-0.011	0.010-0.016	0.012-0.020	0.016-0.026	0.018-0.030	0.019-0.031	0.021-0.035	0.021-0.035	0.023-0.038	0.027-0.045	0.027-0.045
	6.2	58	0.005-0.008	0.007-0.011	0.010-0.016	0.012-0.020	0.016-0.026	0.018-0.030	0.019-0.031	0.021-0.035	0.021-0.035	0.023-0.038	0.027-0.045	0.027-0.045
	6.3	40	0.006-0.010	0.009-0.015	0.013-0.021	0.018-0.030	0.020-0.033	0.025-0.041	0.029-0.048	0.030-0.050	0.030-0.050	0.030-0.050	0.033-0.055	0.033-0.055
	6.4	20	0.006-0.010	0.009-0.015	0.013-0.021	0.018-0.030	0.020-0.033	0.025-0.041	0.029-0.048	0.030-0.050	0.030-0.050	0.030-0.050	0.033-0.055	0.033-0.055
N	7.1	850	0.006-0.010	0.009-0.015	0.013-0.021	0.018-0.030	0.020-0.033	0.025-0.041	0.029-0.048	0.030-0.050	0.030-0.050	0.030-0.050	0.033-0.055	0.033-0.055
	7.2	175	0.006-0.010	0.009-0.015	0.013-0.021	0.018-0.030	0.020-0.033	0.025-0.041	0.029-0.048	0.030-0.050	0.030-0.050	0.030-0.050	0.033-0.055	0.033-0.055
	7.3	70	0.006-0.010	0.009-0.015	0.013-0.021	0.018-0.030	0.020-0.033	0.025-0.041	0.029-0.048	0.030-0.050	0.030-0.050	0.030-0.050	0.033-0.055	0.033-0.055
Syn	8.1	225	0.005-0.008	0.007-0.011	0.009-0.015	0.010-0.016	0.011-0.019	0.014-0.024	0.017-0.028	0.019-0.031	0.019-0.031	0.021-0.035	0.026-0.044	0.026-0.044
	8.2	225	0.005-0.008	0.007-0.011	0.009-0.015	0.010-0.016	0.011-0.019	0.014-0.024	0.017-0.028	0.019-0.031	0.019-0.031	0.021-0.035	0.026-0.044	0.026-0.044
	8.3	225	0.005-0.008	0.007-0.011	0.009-0.015	0.010-0.016	0.011-0.019	0.014-0.024	0.017-0.028	0.019-0.031	0.019-0.031	0.021-0.035	0.026-0.044	0.026-0.044

Material	Ø	Vc m/min	38	40
P	1.1	34	0.034-0.056	0.034-0.056
	1.2	28	0.043-0.071	0.043-0.071
	1.3	28	0.043-0.071	0.043-0.071
	1.4	28	0.043-0.071	0.043-0.071
	1.5	22	0.043-0.071	0.043-0.071
	1.6	22	0.043-0.071	0.043-0.071
M	2.1	15	0.053-0.088	0.053-0.088
	2.2	15	0.053-0.088	0.053-0.088
	3.1	34	0.053-0.088	0.053-0.088
K	3.2	15	0.034-0.056	0.034-0.056
	3.3	22	0.043-0.071	0.043-0.071
	3.4	15	0.034-0.056	0.034-0.056
Ni	5.1	52	0.043-0.071	0.043-0.071
	5.2	14	0.053-0.088	0.053-0.088
	5.3	6	0.053-0.088	0.053-0.088
Cu	6.1	65	0.030-0.050	0.030-0.050
	6.2	58	0.030-0.050	0.030-0.050
	6.3	40	0.036-0.060	0.036-0.060
	6.4	20	0.036-0.060	0.036-0.060
N	7.1	850	0.036-0.060	0.036-0.060
	7.2	175	0.036-0.060	0.036-0.060
	7.3	70	0.036-0.060	0.036-0.060
Syn	8.1	225	0.026-0.044	0.029-0.048
	8.2	225	0.026-0.044	0.029-0.048
	8.3	225	0.026-0.044	0.029-0.048

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Parameters based on ideal conditions.
Please adjust parameters accordingly to real applications.



Material	Ø Vc m/min	10	12	14	16	20	24	28	34	44	48/52	54	56
		F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)
P	1.1 ● 35	0.030-0.050	0.030-0.050	0.030-0.050	0.038-0.063	0.053-0.088	0.060-0.100	0.060-0.100	0.060-0.100	0.068-0.113	0.068-0.113	0.075-0.125	0.075-0.125
	1.2 ● 35	0.030-0.050	0.030-0.050	0.030-0.050	0.038-0.063	0.053-0.088	0.060-0.100	0.060-0.100	0.060-0.100	0.068-0.113	0.068-0.113	0.075-0.125	0.075-0.125
	1.3 ● 25	0.030-0.050	0.030-0.050	0.030-0.050	0.038-0.063	0.045-0.075	0.053-0.088	0.053-0.088	0.053-0.088	0.060-0.100	0.060-0.100	0.068-0.113	0.068-0.113
	1.4 ● 25	0.030-0.050	0.030-0.050	0.030-0.050	0.038-0.063	0.045-0.075	0.053-0.088	0.053-0.088	0.053-0.088	0.060-0.100	0.060-0.100	0.068-0.113	0.068-0.113
	1.5 ● 15	0.030-0.050	0.030-0.050	0.030-0.050	0.030-0.050	0.038-0.063	0.045-0.075	0.045-0.075	0.045-0.075	0.053-0.088	0.053-0.088	0.060-0.100	0.060-0.100
	1.6 ● 15	0.030-0.050	0.030-0.050	0.030-0.050	0.030-0.050	0.038-0.063	0.045-0.075	0.045-0.075	0.045-0.075	0.053-0.088	0.053-0.088	0.060-0.100	0.060-0.100
M	2.1 ○ 20	0.023-0.038	0.023-0.038	0.023-0.038	0.023-0.038	0.030-0.050	0.038-0.063	0.038-0.063	0.038-0.063	0.045-0.075	0.045-0.075	0.053-0.088	0.053-0.088
	2.2 ○ 15	0.023-0.038	0.023-0.038	0.023-0.038	0.023-0.038	0.030-0.050	0.038-0.063	0.038-0.063	0.038-0.063	0.045-0.075	0.045-0.075	0.053-0.088	0.053-0.088
	2.3 ○ 10	0.023-0.038	0.023-0.038	0.023-0.038	0.023-0.038	0.030-0.050	0.038-0.063	0.038-0.063	0.038-0.063	0.045-0.075	0.045-0.075	0.053-0.088	0.053-0.088
K	3.1 ● 20	0.030-0.050	0.030-0.050	0.030-0.050	0.038-0.063	0.053-0.088	0.060-0.100	0.060-0.100	0.060-0.100	0.068-0.113	0.068-0.113	0.075-0.125	0.075-0.125
	3.2 ● 15	0.030-0.050	0.030-0.050	0.030-0.050	0.038-0.063	0.053-0.088	0.060-0.100	0.060-0.100	0.060-0.100	0.068-0.113	0.068-0.113	0.075-0.125	0.075-0.125
	3.3 ● 25	0.030-0.050	0.030-0.050	0.030-0.050	0.038-0.063	0.045-0.075	0.053-0.088	0.053-0.088	0.053-0.088	0.060-0.100	0.060-0.100	0.068-0.113	0.068-0.113
Cu	6.1 ● 15	0.030-0.050	0.030-0.050	0.030-0.050	0.038-0.063	0.045-0.075	0.053-0.088	0.053-0.088	0.053-0.088	0.060-0.100	0.060-0.100	0.068-0.113	0.068-0.113
	6.2 ● 90	0.038-0.063	0.038-0.063	0.038-0.063	0.053-0.088	0.060-0.100	0.068-0.113	0.068-0.113	0.068-0.113	0.075-0.125	0.075-0.125	0.083-0.138	0.083-0.138
	6.3 ● 90	0.030-0.050	0.030-0.050	0.030-0.050	0.038-0.063	0.053-0.088	0.060-0.100	0.060-0.100	0.060-0.100	0.068-0.113	0.068-0.113	0.075-0.125	0.075-0.125
N	7.1 ● 245	0.045-0.075	0.045-0.075	0.045-0.075	0.053-0.088	0.068-0.113	0.075-0.125	0.075-0.125	0.075-0.125	0.083-0.138	0.083-0.138	0.090-0.150	0.090-0.150
	7.2 ● 230	0.045-0.075	0.045-0.075	0.045-0.075	0.053-0.088	0.068-0.113	0.075-0.125	0.075-0.125	0.075-0.125	0.083-0.138	0.083-0.138	0.090-0.150	0.090-0.150
	7.3 ● 60	0.045-0.075	0.045-0.075	0.045-0.075	0.053-0.088	0.068-0.113	0.075-0.125	0.075-0.125	0.075-0.125	0.083-0.138	0.083-0.138	0.090-0.150	0.090-0.150
Syn	8.1 ● 40	0.038-0.063	0.038-0.063	0.038-0.063	0.053-0.088	0.060-0.100	0.068-0.113	0.068-0.113	0.068-0.113	0.075-0.125	0.075-0.125	0.083-0.138	0.083-0.138
	8.2 ● 50	0.045-0.075	0.045-0.075	0.045-0.075	0.053-0.088	0.068-0.113	0.075-0.125	0.075-0.125	0.075-0.125	0.083-0.138	0.083-0.138	0.090-0.150	0.090-0.150
	8.2 ● 50	0.045-0.075	0.045-0.075	0.045-0.075	0.053-0.088	0.068-0.113	0.075-0.125	0.075-0.125	0.075-0.125	0.083-0.138	0.083-0.138	0.090-0.150	0.090-0.150

366, 367, 374

Material	Ø Vc m/min	10.5	1/2"	13.5	5/8"/16.5	3/4"	19.5	7/8"/22.5	1"/25.5	28.5/1.18"	1.14"/32.5	1.38"/1.12"	45.5
		F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)
P	1.1 ● 25	0.023-0.038	0.023-0.038	0.032-0.054	0.032-0.054	0.040-0.066	0.040-0.066	0.044-0.073	0.048-0.080	0.050-0.083	0.047-0.078	0.051-0.085	0.051-0.085
	1.2 ● 25	0.023-0.038	0.023-0.038	0.032-0.054	0.032-0.054	0.040-0.066	0.040-0.066	0.044-0.073	0.048-0.080	0.050-0.083	0.047-0.078	0.051-0.085	0.051-0.085
	1.3 ● 20	0.019-0.031	0.019-0.031	0.023-0.038	0.023-0.038	0.031-0.051	0.031-0.051	0.037-0.061	0.041-0.069	0.042-0.071	0.042-0.070	0.044-0.073	0.044-0.073
	1.4 ● 20	0.019-0.031	0.019-0.031	0.023-0.038	0.023-0.038	0.031-0.051	0.031-0.051	0.037-0.061	0.041-0.069	0.042-0.071	0.042-0.070	0.044-0.073	0.044-0.073
	1.5 ● 10	0.017-0.028	0.017-0.028	0.020-0.034	0.020-0.034	0.027-0.045	0.027-0.045	0.031-0.052	0.035-0.058	0.039-0.065	0.039-0.065	0.044-0.073	0.044-0.073
	1.6 ● 10	0.017-0.028	0.017-0.028	0.020-0.034	0.020-0.034	0.027-0.045	0.027-0.045	0.031-0.052	0.035-0.058	0.039-0.065	0.039-0.065	0.044-0.073	0.044-0.073
M	2.1 ○ 15	0.013-0.021	0.013-0.021	0.017-0.028	0.017-0.028	0.022-0.036	0.022-0.036	0.026-0.043	0.029-0.048	0.031-0.051	0.031-0.051	0.033-0.055	0.033-0.055
	2.2 ○ 10	0.013-0.021	0.013-0.021	0.017-0.028	0.017-0.028	0.022-0.036	0.022-0.036	0.026-0.043	0.029-0.048	0.031-0.051	0.031-0.051	0.033-0.055	0.033-0.055
	2.3 ○ 10	0.013-0.021	0.013-0.021	0.017-0.028	0.017-0.028	0.022-0.036	0.022-0.036	0.026-0.043	0.029-0.048	0.031-0.051	0.031-0.051	0.033-0.055	0.033-0.055
K	3.1 ● 20	0.023-0.038	0.023-0.038	0.032-0.054	0.032-0.054	0.040-0.066	0.040-0.066	0.044-0.073	0.048-0.080	0.050-0.083	0.047-0.078	0.051-0.085	0.051-0.085
	3.2 ● 20	0.023-0.038	0.023-0.038	0.032-0.054	0.032-0.054	0.040-0.066	0.040-0.066	0.044-0.073	0.048-0.080	0.050-0.083	0.047-0.078	0.051-0.085	0.051-0.085
	3.3 ● 20	0.019-0.031	0.019-0.031	0.023-0.038	0.023-0.038	0.031-0.051	0.031-0.051	0.037-0.061	0.041-0.069	0.042-0.071	0.042-0.070	0.044-0.073	0.044-0.073
Cu	6.1 ● 15	0.019-0.031	0.019-0.031	0.023-0.038	0.023-0.038	0.031-0.051	0.031-0.051	0.037-0.061	0.041-0.069	0.042-0.071	0.042-0.070	0.044-0.073	0.044-0.073
	6.2 ● 50	0.034-0.056	0.034-0.056	0.036-0.060	0.036-0.060	0.042-0.069	0.042-0.069	0.045-0.075	0.048-0.080	0.050-0.083	0.050-0.083	0.051-0.085	0.051-0.085
	6.3 ● 55	0.023-0.038	0.023-0.038	0.032-0.054	0.032-0.054	0.040-0.066	0.040-0.066	0.044-0.073	0.048-0.080	0.050-0.083	0.047-0.078	0.051-0.085	0.051-0.085
N	7.1 ● 65	0.041-0.069	0.041-0.069	0.053-0.088	0.053-0.088	0.069-0.116	0.069-0.116	0.080-0.133	0.089-0.149	0.092-0.153	0.092-0.154	0.095-0.158	0.095-0.158
	7.2 ● 50	0.041-0.069	0.041-0.069	0.053-0.088	0.053-0.088	0.069-0.116	0.069-0.116	0.080-0.133	0.089-0.149	0.092-0.153	0.092-0.154	0.095-0.158	0.095-0.158
	7.3 ● 35	0.041-0.069	0.041-0.069	0.053-0.088	0.053-0.088	0.069-0.116	0.069-0.116	0.080-0.133	0.089-0.149	0.092-0.153	0.092-0.154	0.095-0.158	0.095-0.158
Syn	8.1 ● 20	0.034-0.056	0.034-0.056	0.036-0.060	0.036-0.060	0.042-0.069	0.042-0.069	0.045-0.075	0.048-0.080	0.050-0.083	0.050-0.083	0.051-0.085	0.051-0.085
	8.2 ● 50	0.041-0.069	0.041-0.069	0.053-0.088	0.053-0.088	0.069-0.116	0.069-0.116	0.080-0.133	0.089-0.149	0.092-0.153	0.092-0.154	0.095-0.158	0.095-0.158
	8.2 ● 50	0.041-0.069	0.041-0.069	0.053-0.088	0.053-0.088	0.069-0.116	0.069-0.116	0.080-0.133	0.089-0.149	0.092-0.153	0.092-0.154	0.095-0.158	0.095-0.158

Parameters based on ideal conditions.
Please adjust parameters accordingly to real applications.



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371, 385

Material	Ø	Vc m/min	12.5	16	18	21	25	28	32	36	40
			F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)
P	1.1	40	0.023-0.038	0.032-0.054	0.040-0.066	0.047-0.079	0.048-0.080	0.047-0.079	0.047-0.078	0.051-0.085	0.051-0.085
	1.2	40	0.023-0.038	0.032-0.054	0.040-0.066	0.047-0.079	0.048-0.080	0.047-0.079	0.047-0.078	0.051-0.085	0.051-0.085
	1.3	30	0.019-0.031	0.023-0.038	0.031-0.051	0.039-0.065	0.041-0.069	0.042-0.069	0.042-0.070	0.044-0.073	0.044-0.073
	1.4	25	0.019-0.031	0.023-0.038	0.031-0.051	0.039-0.065	0.041-0.069	0.042-0.069	0.042-0.070	0.044-0.073	0.044-0.073
	1.5	20	0.017-0.028	0.020-0.034	0.027-0.045	0.034-0.056	0.035-0.058	0.037-0.061	0.039-0.065	0.044-0.073	0.044-0.073
	1.6	15	0.017-0.028	0.020-0.034	0.027-0.045	0.034-0.056	0.035-0.058	0.037-0.061	0.039-0.065	0.044-0.073	0.044-0.073
M	2.1	25	0.013-0.021	0.017-0.028	0.022-0.036	0.027-0.045	0.029-0.048	0.030-0.049	0.031-0.051	0.033-0.055	0.033-0.055
	2.2	15	0.013-0.021	0.017-0.028	0.022-0.036	0.027-0.045	0.029-0.048	0.030-0.049	0.031-0.051	0.033-0.055	0.033-0.055
	2.3	10	0.013-0.021	0.017-0.028	0.022-0.036	0.027-0.045	0.029-0.048	0.030-0.049	0.031-0.051	0.033-0.055	0.033-0.055
K	3.1	25	0.023-0.038	0.032-0.054	0.040-0.066	0.047-0.079	0.048-0.080	0.047-0.079	0.047-0.078	0.051-0.085	0.051-0.085
	3.2	20	0.023-0.038	0.032-0.054	0.040-0.066	0.047-0.079	0.048-0.080	0.047-0.079	0.047-0.078	0.051-0.085	0.051-0.085
	3.3	30	0.019-0.031	0.023-0.038	0.031-0.051	0.039-0.065	0.041-0.069	0.042-0.069	0.042-0.070	0.044-0.073	0.044-0.073
Cu	3.4	20	0.019-0.031	0.023-0.038	0.031-0.051	0.039-0.065	0.041-0.069	0.042-0.069	0.042-0.070	0.044-0.073	0.044-0.073
	6.1	100	0.034-0.056	0.036-0.060	0.042-0.069	0.047-0.079	0.048-0.080	0.049-0.081	0.050-0.083	0.051-0.085	0.051-0.085
	6.2	100	0.023-0.038	0.032-0.054	0.040-0.066	0.047-0.079	0.048-0.080	0.047-0.079	0.047-0.078	0.051-0.085	0.051-0.085
N	6.3	100	0.023-0.038	0.032-0.054	0.040-0.066	0.047-0.079	0.048-0.080	0.047-0.079	0.047-0.078	0.051-0.085	0.051-0.085
	6.4	15	0.019-0.031	0.023-0.038	0.031-0.051	0.039-0.065	0.041-0.069	0.042-0.069	0.042-0.070	0.044-0.073	0.044-0.073
	7.1	260	0.041-0.069	0.053-0.088	0.069-0.116	0.086-0.144	0.089-0.149	0.091-0.151	0.092-0.154	0.095-0.158	0.095-0.158
Syn	7.2	260	0.041-0.069	0.053-0.088	0.069-0.116	0.086-0.144	0.089-0.149	0.091-0.151	0.092-0.154	0.095-0.158	0.095-0.158
	7.3	66	0.041-0.069	0.053-0.088	0.069-0.116	0.086-0.144	0.089-0.149	0.091-0.151	0.092-0.154	0.095-0.158	0.095-0.158
	7.4	44	0.034-0.056	0.036-0.060	0.042-0.069	0.047-0.079	0.048-0.080	0.049-0.081	0.050-0.083	0.051-0.085	0.051-0.085
Syn	8.1	100	0.041-0.069	0.053-0.088	0.069-0.116	0.086-0.144	0.089-0.149	0.091-0.151	0.092-0.154	0.095-0.158	0.095-0.158
	8.2	100	0.041-0.069	0.053-0.088	0.069-0.116	0.086-0.144	0.089-0.149	0.091-0.151	0.092-0.154	0.095-0.158	0.095-0.158

376, 386

Material	Ø	Vc m/min	16	20	25	32	40
			F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)
P	1.1	20	0.053-0.089	0.067-0.111	0.075-0.125	0.084-0.140	0.094-0.156
	1.2	20	0.053-0.089	0.067-0.111	0.075-0.125	0.084-0.140	0.094-0.156
	1.3	15	0.047-0.079	0.061-0.101	0.069-0.115	0.077-0.129	0.086-0.143
	1.4	15	0.047-0.079	0.061-0.101	0.069-0.115	0.077-0.129	0.086-0.143
	1.5	10	0.044-0.073	0.055-0.091	0.063-0.105	0.071-0.119	0.079-0.131
	1.6	5	0.044-0.073	0.055-0.091	0.063-0.105	0.071-0.119	0.079-0.131
M	2.1	10	0.034-0.056	0.043-0.071	0.048-0.080	0.056-0.093	0.063-0.105
	2.2	10	0.034-0.056	0.043-0.071	0.048-0.080	0.056-0.093	0.063-0.105
	2.3	5	0.034-0.056	0.043-0.071	0.048-0.080	0.056-0.093	0.063-0.105
K	3.1	15	0.053-0.089	0.067-0.111	0.075-0.125	0.084-0.140	0.094-0.156
	3.2	15	0.053-0.089	0.067-0.111	0.075-0.125	0.084-0.140	0.094-0.156
	3.3	15	0.047-0.079	0.061-0.101	0.069-0.115	0.077-0.129	0.086-0.143
Cu	3.4	10	0.047-0.079	0.061-0.101	0.069-0.115	0.077-0.129	0.086-0.143
	6.1	40	0.066-0.110	0.080-0.133	0.090-0.150	0.100-0.166	0.110-0.184
	6.2	45	0.053-0.089	0.067-0.111	0.075-0.125	0.084-0.140	0.094-0.156
N	6.3	15	0.053-0.089	0.067-0.111	0.075-0.125	0.084-0.140	0.094-0.156
	6.4	5	0.047-0.079	0.061-0.101	0.069-0.115	0.077-0.129	0.086-0.143
	7.1	50	0.071-0.119	0.086-0.143	0.098-0.163	0.107-0.179	0.118-0.196
Syn	7.2	40	0.071-0.119	0.086-0.143	0.098-0.163	0.107-0.179	0.118-0.196
	7.3	25	0.071-0.119	0.086-0.143	0.098-0.163	0.107-0.179	0.118-0.196
	7.4	17	0.066-0.110	0.080-0.133	0.090-0.150	0.100-0.166	0.110-0.184
Syn	8.1	40	0.071-0.119	0.086-0.143	0.098-0.163	0.107-0.179	0.118-0.196
	8.2	40	0.071-0.119	0.086-0.143	0.098-0.163	0.107-0.179	0.118-0.196

378, 389

Material	Ø	Vc m/min	16	20	25	32	40
			F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)	F (mm/tooth)
P	1.1	30	0.053-0.089	0.067-0.111	0.075-0.125	0.084-0.140	0.094-0.156
	1.2	30	0.053-0.089	0.067-0.111	0.075-0.125	0.084-0.140	0.094-0.156
	1.3	25	0.047-0.079	0.061-0.101	0.069-0.115	0.077-0.129	0.086-0.143
	1.4	20	0.047-0.079	0.061-0.101	0.069-0.115	0.077-0.129	0.086-0.143
	1.5	15	0.044-0.073	0.055-0.091	0.063-0.105	0.071-0.119	0.079-0.131
	1.6	10	0.044-0.073	0.055-0.091	0.063-0.105	0.071-0.119	0.079-0.131
M	2.1	20	0.034-0.056	0.043-0.071	0.048-0.080	0.056-0.093	0.063-0.105
	2.2	15	0.034-0.056	0.043-0.071	0.048-0.080	0.056-0.093	0.063-0.105
	2.3	10	0.034-0.056	0.043-0.071	0.048-0.080	0.056-0.093	0.063-0.105
K	3.1	20	0.053-0.089	0.067-0.111	0.075-0.125	0.084-0.140	0.094-0.156
	3.2	15	0.053-0.089	0.067-0.111	0.075-0.125	0.084-0.140	0.094-0.156
	3.3	25	0.047-0.079	0.061-0.101	0.069-0.115	0.077-0.129	0.086-0.143
Cu	3.4	15	0.047-0.079	0.061-0.101	0.069-0.115	0.077-0.129	0.086-0.143
	6.1	90	0.066-0.110	0.080-0.133	0.090-0.150	0.100-0.166	0.110-0.184
	6.2	90	0.053-0.089	0.067-0.111	0.075-0.125	0.084-0.140	0.094-0.156
N	6.3	75	0.053-0.089	0.067-0.111	0.075-0.125	0.084-0.140	0.094-0.156
	6.4	10	0.047-0.079	0.061-0.101	0.069-0.115	0.077-0.129	0.086-0.143
	7.1	190	0.071-0.119	0.086-0.143	0.098-0.163	0.107-0.179	0.118-0.196
Syn	7.2	190	0.071-0.119	0.086-0.143	0.098-0.163	0.107-0.179	0.118-0.196
	7.3	55	0.071-0.119	0.086-0.143	0.098-0.163	0.107-0.179	0.118-0.196
	7.4	35	0.066-0.110	0.080-0.133	0.090-0.150	0.100-0.166	0.110-0.184
Syn	8.1	75	0.071-0.119	0.086-0.143	0.098-0.163	0.107-0.179	0.118-0.196
	8.2	75	0.071-0.119	0.086-0.143	0.098-0.163	0.107-0.179	0.118-0.196



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Parameters based on ideal conditions.
Please adjust parameters accordingly to real applications.



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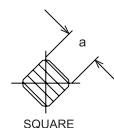
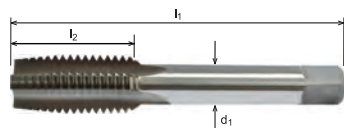


OSG GROUP COMPANY

T H R E A D I N G T O O L S






Short Hand Taps

For general hand tapping.



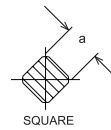
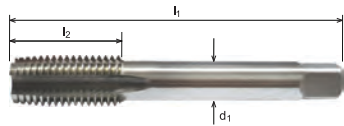
Code
501

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	○						○	○	○								○	○			○	○									

Properties		
M	ISO 529	HSS
	ISO 2 6H	STRAIGHT FLUTE
		
		

Size	Pitch	l ₁	l ₂	d ₁	a	No. of Flutes	Tap Set		Code			Price
							Code	Price	Taper	Second	Bottom	
M1	0.25	38.5	5.5	2.5	2	3	5010100		5010101	5010102	5010103	
M1.1	0.25	38.5	5.5	2.5	2	3	5010110		5010111	5010112	5010113	
M1.2	0.25	38.5	5.5	2.5	2	3	5010120		5010121	5010122	5010123	
M1.4	0.3	40	7	2.5	2	3	5010140		5010141	5010142	5010143	
M1.6	0.35	41	8	2.5	2	3	5010160		5010161	5010162	5010163	
M1.8	0.35	41	8	2.5	2	3	5010180		5010181	5010182	5010183	
M2	0.4	41	8	2.5	2	3	5010200		5010201	5010202	5010203	
M2.2	0.45	44.5	9.5	2.8	2.24	3	5010220		5010221	5010222	5010223	
M2.5	0.45	44.5	9.5	2.8	2.24	3	5010250		5010251	5010252	5010253	
M3	0.5	48	11	3.15	2.5	3	5010300		5010301	5010302	5010303	
M3.5	0.6	50	13	3.55	2.8	3	5010350		5010351	5010352	5010353	
M4	0.7	53	13	4	3.15	3	5010400		5010401	5010402	5010403	
M4.5	0.75	53	13	4.5	3.55	3	5010450		5010451	5010452	5010453	
M5	0.8	58	16	5	4	3	5010500		5010501	5010502	5010503	
M6	1	66	19	6.3	5	3	5010600		5010601	5010602	5010603	
M7	1	66	19	7.1	5.6	4	5010700		5010701	5010702	5010703	
M8	1.25	72	22	8	6.3	4	5010800		5010801	5010802	5010803	
M9	1.25	72	22	9	7.1	4	5010900		5010901	5010902	5010903	
M10	1.5	80	24	10	8	4	5011000		5011001	5011002	5011003	
M11	1.5	85	25	8	6.3	4	5011100		5011101	5011102	5011103	
M12	1.75	89	29	9	7.1	4	5011200		5011201	5011202	5011203	
M14	2	95	30	11.2	9	4	5011400		5011401	5011402	5011403	
M16	2	102	32	12.5	10	4	5011600		5011601	5011602	5011603	
M18	2.5	112	37	14	11.2	4	5011800		5011801	5011802	5011803	
M20	2.5	112	37	14	11.2	4	5012000		5012001	5012002	5012003	
M22	2.5	118	38	16	12.5	4	5012200		5012201	5012202	5012203	
M24	3	130	45	18	14	4	5012400		5012401	5012402	5012403	
M27	3	135	45	20	16	4	5012700		5012701	5012702	5012703	
M30	3.5	138	48	20	16	4	5013000		5013001	5013002	5013003	
M33	3.5	151	51	22.4	18	4	5013300		5013301	5013302	5013303	
M36	4	162	57	25	20	4	5013600		5013601	5013602	5013603	
M39	4	170	60	28	22.4	6	5013900		5013901	5013902	5013903	
M42	4.5	170	60	28	22.4	6	5014200		5014201	5014202	5014203	
M45	4.5	187	67	31.5	25	6	5014500		5014501	5014502	5014503	
M48	5	187	67	31.5	25	6	5014800		5014801	5014802	5014803	
M52	5	200	70	35.5	28	6	5015200		5015201	5015202	5015203	
M56	5.5	200	70	35.5	28	6	5015600		5015601	5015602	5015603	
M60	5.5	221	76	40	31.5	6	5016000		5016001	5016002	5016003	
M64	6	224	79	40	31.5	6	5016400		5016401	5016402	5016403	
M68	6	234	79	45	35.5	8	5016800		5016801	5016802	5016803	





OSG GROUP COMPANY

Left Hand Short Hand Taps

For general hand tapping.

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	○						○	○	○								○	○			○	○									

Code

519

Size	Pitch	l ₁	l ₂	d ₁	a	No. of Flutes	Tap Set		Code			Price
							Code	Price	Taper	Second	Bottom	
M3	0.5	48	11	3.15	2.5	3	5190300		5190301	5190302	5190303	
M4	0.7	53	13	4	3.15	3	5190400		5190401	5190402	5190403	
M5	0.8	58	16	5	4	3	5190500		5190501	5190502	5190503	
M6	1	66	19	6.3	5	3	5190600		5190601	5190602	5190603	
M8	1.25	72	22	8	6.3	4	5190800		5190801	5190802	5190803	
M10	1.5	80	24	10	8	4	5191000		5191001	5191002	5191003	
M12	1.75	89	29	9	7.1	4	5191200		5191201	5191202	5191203	
M14	2	95	30	11.2	9	4	5191400		5191401	5191402	5191403	
M16	2	102	32	12.5	10	4	5191600		5191601	5191602	5191603	
M18	2.5	112	37	14	11.2	4	5191800		5191801	5191802	5191803	
M20	2.5	112	37	14	11.2	4	5192000		5192001	5192002	5192003	
M22	2.5	118	38	16	12.5	4	5192200		5192201	5192202	5192203	
M24	3	130	45	18	14	4	5192400		5192401	5192402	5192403	
M27	3	135	45	20	16	4	-		-	5192702	-	
M30	3.5	138	48	20	16	4	-		-	5193002	-	
M33	3.5	151	51	22.4	18	4	-		-	5193302	-	
M36	4	162	57	25	20	4	-		-	5193602	-	



Properties

M	ISO 529	HSS
	ISO 2 6H	STRAIGHT FLUTE





OSG GROUP COMPANY

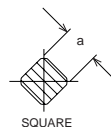
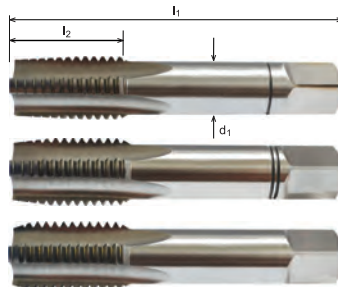
Code

518

Properties

M **DIN 352** **HSSE**

 **ISO 2 6H** **STRAIGHT FLUTE**



Serial Hand Taps
For tapping in tougher materials.

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4

Size	Pitch	l ₁	l ₂	d ₁	a	No. of Flutes	Tap Set		Code			Price
							Code	Price	Rougher	Intermediate	Finisher	
M3	0.5	40	11	3.5	2.7	3	5180300		5180301	5180302	5180303	
M3.5	0.6	45	13	4	3	3	5180350		5180351	5180352	5180353	
M4	0.7	45	13	4.5	3.4	3	5180400		5180401	5180402	5180403	
M4.5	0.75	50	16	6	4.9	3	5180450		5180451	5180452	5180453	
M5	0.8	50	16	6	4.9	3	5180500		5180501	5180502	5180503	
M6	1	50	19	6	4.9	3	5180600		5180601	5180602	5180603	
M7	1	50	19	6	4.9	4	5180700		5180701	5180702	5180703	
M8	1.25	56	22	6	4.9	4	5180800		5180801	5180802	5180803	
M9	1.25	63	22	7	5.5	4	5180900		5180901	5180902	5180903	
M10	1.5	70	24	7	5.5	4	5181000		5181001	5181002	5181003	
M12	1.75	75	29	9	7	4	5181200		5181201	5181202	5181203	
M14	2	80	30	11	9	4	5181400		5181401	5181402	5181403	
M16	2	80	32	12	9	4	5181600		5181601	5181602	5181603	
M18	2.5	95	40	14	11	4	5181800		5181801	5181802	5181803	
M20	2.5	95	40	16	12	4	5182000		5182001	5182002	5182003	
M22	2.5	100	40	18	14.5	4	5182200		5182201	5182202	5182203	
M24	3	110	50	18	14.5	4	5182400		5182401	5182402	5182403	



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shaping your dreams

212

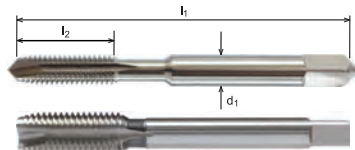
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**BEST
SELLER**






























Gun Nose Short Machine Taps

For machine tapping of through holes.



OSG GROUP COMPANY

Vc: m/min

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
																																		
25	22	18	16	10	5	6	5			15	8	15	8	10	5		12	5		12	30	20		40	35	20	15	30						

Size	Pitch	l ₁	l ₂	d ₁	a	No. of Flutes	Code	Price
M2	0.4	41	8	2.5	2	3	5080200	
M3	0.5	48	11	3.15	2.5	3	5080300	
M3.5	0.6	50	13	3.55	2.8	3	5080350	
M4	0.7	53	13	4	3.15	3	5080400	
M5	0.8	58	16	5	4	3	5080500	
M6	1	66	19	6.3	5	3	5080600	
M7	1	66	19	7.1	5.6	3	5080700	
M8	1.25	72	22	8	6.3	3	5080800	
M9	1.25	72	22	9	7.1	3	5080900	
M10	1.5	80	24	10	8	3	5081000	
M11	1.5	85	25	8	6.3	3	5081100	
M12	1.75	89	29	9	7.1	3	5081200	
M14	2	95	30	11.2	9	3	5081400	
M16	2	102	32	12.5	10	4	5081600	
M18	2.5	112	37	14	11.2	4	5081800	
M20	2.5	112	37	14	11.2	4	5082000	
M22	2.5	118	38	16	12.5	4	5082200	
M24	3	130	45	18	14	4	5082400	
M27	3	135	45	20	16	4	5082700	
M30	3.5	138	48	20	16	4	5083000	
M33	3.5	151	51	22.4	18	4	5083300	
M36	4	162	57	25	20	4	5083600	



Code
508

Properties		
M	ISO 529	HSSE
	ISO 2 6H	GUN NOSE SPIRAL POINT

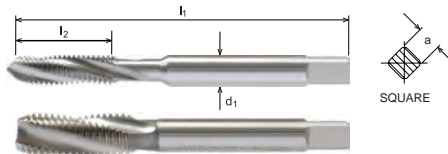




OSG GROUP COMPANY

Spiral Flute Short Machine Taps

For machine tapping of blind holes in tougher materials.



Vc: m/min

Code

509

P				M				K				Ti				Ni				Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	●	●	●	○	○			○	○	○	○	○	○		○	○	○	○	○	○	○	○	○	○	○	○						
25	22	18	16	10	6	6	5			15	8	15	8	10	5		12	5		12	30	20		40	35	20	15	30						

Properties

M **ISO 529** **HSSE**



Size	Pitch	l ₁	l ₂	d ₁	a	No. of Flutes	Code	Price
M3	0.5	48	11	3.15	2.5	3	5090300	
M3.5	0.6	50	13	3.55	2.8	3	5090350	
M4	0.7	53	13	4	3.15	3	5090400	
M5	0.8	58	16	5	4	3	5090500	
M6	1	66	19	6.3	5	3	5090600	
M7	1	66	19	7.1	5.6	3	5090700	
M8	1.25	72	22	8	6.3	3	5090800	
M9	1.25	72	22	9	7.1	3	5090900	
M10	1.5	80	24	10	8	3	5091000	
M11	1.5	85	25	8	6.3	3	5091100	
M12	1.75	89	29	9	7.1	3	5091200	
M14	2	95	30	11.2	9	3	5091400	
M16	2	102	32	12.5	10	3	5091600	
M18	2.5	112	37	14	11.2	4	5091800	
M20	2.5	112	37	14	11.2	4	5092000	
M22	2.5	118	38	16	12.5	4	5092200	
M24	3	130	45	18	14	4	5092400	



THREADING
TOOLS



shaping your dreams

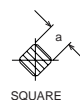
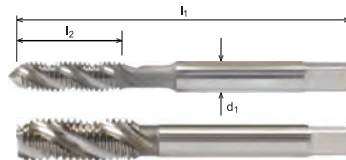
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

Spiral Flute Short Machine Taps

For machine tapping of blind holes.



OSG GROUP COMPANY

Vc: m/min

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
																																		
25	22	18	16	10	5	6	5			15	8	15	8	10	5		12	5		12	30	20		40	35	20	15	30						

Size	Pitch	l ₁	l ₂	d ₁	a	No. of Flutes	Code	Price
M3	0.5	48	11	3.15	2.5	3	5100300	
M3.5	0.6	50	13	3.55	2.8	3	5100350	
M4	0.7	53	13	4	3.15	3	5100400	
M5	0.8	58	16	5	4	3	5100500	
M6	1	66	19	6.3	5	3	5100600	
M7	1	66	19	7.1	5.6	3	5100700	
M8	1.25	72	22	8	6.3	3	5100800	
M9	1.25	72	22	9	7.1	3	5100900	
M10	1.5	80	24	10	8	3	5101000	
M11	1.5	85	25	8	6.3	3	5101100	
M12	1.75	89	29	9	7.1	3	5101200	
M14	2	95	30	11.2	9	3	5101400	
M16	2	102	32	12.5	10	3	5101600	
M18	2.5	112	37	14	11.2	4	5101800	
M20	2.5	112	37	14	11.2	4	5102000	
M22	2.5	118	38	16	12.5	4	5102200	
M24	3	130	45	18	14	4	5102400	



Code		
510		
Properties		
M	ISO 529	HSSE
60°	ISO 2 6H	35°
C-3		RH





OSG GROUP COMPANY

Code

MFT-5SP

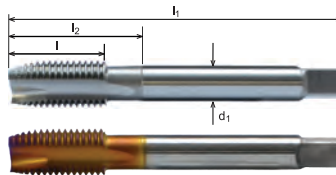
Properties

M	DIN 371 M3 - M10	DIN 376 M12-M20
HSSE	ISO 2 6H	GUN NOSE SPIRAL POINT
UNCOATED		
RAINBOW COATED		



MultiForce Gun Nose Taps

For machine tapping of through holes in multiple materials.



Vc: m/min

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
25	22	18	16	8	6	6	5	3		15	8	15	8							12	30	20		16	35	12	15							
40	40	32	27	13	11	8	7	5		22	18	25	18							18	45	35		48	40	30	22							

Size	Pitch	l1	l	l2	d1	a	No. of Flutes	Uncoated		Rainbow Coated	
								Code	Price	Code	Price
M3	0.5	56	-	18	3.5	2.7	3	MFT-5SP-0300		MFT-5SP-0300RT	
M4	0.7	63	-	21	4.5	3.4	3	MFT-5SP-0400		MFT-5SP-0400RT	
M5	0.8	70	-	25	6	4.9	3	MFT-5SP-0500		MFT-5SP-0500RT	
M6	1	80	-	30	6	4.9	3	MFT-5SP-0600		MFT-5SP-0600RT	
M8	1.25	90	-	35	8	6.2	3	MFT-5SP-0800		MFT-5SP-0800RT	
M10	1.5	100	-	39	10	8	3	MFT-5SP-1000		MFT-5SP-1000RT	
M12	1.75	110	28	-	9	7	3	MFT-5SP-1200		MFT-5SP-1200RT	
M14	2	110	30	-	11	9	3	MFT-5SP-1400		MFT-5SP-1400RT	
M16	2	110	32	-	12	9	3	MFT-5SP-1600		MFT-5SP-1600RT	
M18	2.5	125	34	-	14	11	3	MFT-5SP-1800		MFT-5SP-1800RT	
M20	2.5	140	34	-	16	12	3	MFT-5SP-2000		MFT-5SP-2000RT	

Code

MFT-5SF

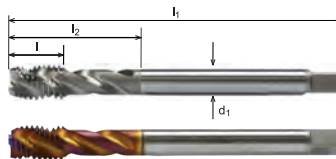
Properties

M	DIN 371 M3 - M10	DIN 376 M12-M20
HSSE	ISO 2 6H	40°
UNCOATED		
RAINBOW COATED		



MultiForce Spiral Flute Taps

For machine tapping of blind holes in multiple materials.



Vc: m/min

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
25	22	18	16	8	6	6	5	3		15	8	15	8							12	30	20		16	35	12	15							
40	40	32	27	13	11	8	7	5		22	18	25	18							18	45	35		48	40	30	22							

Size	Pitch	l1	l	l2	d1	a	No. of Flutes	Uncoated		Rainbow Coated	
								Code	Price	Code	Price
M3	0.5	56	-	18	3.5	2.7	3	MFT-5SF-0300		MFT-5SF-0300RT	
M4	0.7	63	-	21	4.5	3.4	3	MFT-5SF-0400		MFT-5SF-0400RT	
M5	0.8	70	-	25	6	4.9	3	MFT-5SF-0500		MFT-5SF-0500RT	
M6	1	80	-	30	6	4.9	3	MFT-5SF-0600		MFT-5SF-0600RT	
M8	1.25	90	-	35	8	6.2	3	MFT-5SF-0800		MFT-5SF-0800RT	
M10	1.5	100	-	39	10	8	3	MFT-5SF-1000		MFT-5SF-1000RT	
M12	1.75	110	18	-	9	7	3	MFT-5SF-1200		MFT-5SF-1200RT	
M14	2	110	20	-	11	9	3	MFT-5SF-1400		MFT-5SF-1400RT	
M16	2	110	20	-	12	9	3	MFT-5SF-1600		MFT-5SF-1600RT	
M18	2.5	125	25	-	14	11	4	MFT-5SF-1800		MFT-5SF-1800RT	
M20	2.5	140	25	-	16	12	4	MFT-5SF-2000		MFT-5SF-2000RT	

THREADING
TOOLS



shaping your dreams

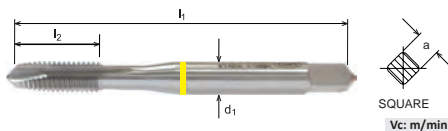
216

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Yellow Band Gun Nose Taps

For machine tapping of through holes
in soft materials eg. Aluminium.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	○	○																			●	●	●	●	○	○					
25	22	18	16	12	10																			40	35	20	15	30	30					

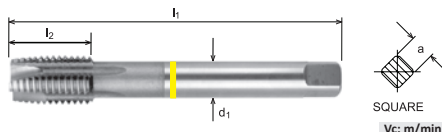
Size	Pitch	l ₁	l ₂	d ₁	a	No. of Flutes	Code	Price
M3	0.5	56	11	3.5	2.7	2	5380300	
M4	0.7	63	13	4.5	3.4	2	5380400	
M5	0.8	70	16	6	4.9	2	5380500	
M6	1	80	19	6	4.9	2	5380600	
M8	1.25	90	22	8	6.2	2	5380800	
M10	1.5	100	24	10	8	3	5381000	

Code
538

Properties		
M	DIN 371	HSSE
CBA	TYPE W	
ISO 2 6H	GUN NOSE SPIRAL POINT	
		BRIGHT FINISH

Yellow Band Gun Nose Taps

For machine tapping of through holes
in soft materials eg. Aluminium.



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	○	○																			●	●	●	●	○	○					
25	22	18	16	12	10																			40	35	20	15	30	30					

Size	Pitch	l ₁	l ₂	d ₁	a	No. of Flutes	Code	Price
M12	1.75	110	29	9	7	3	5481200	
M16	2	110	32	12	9	3	5481600	

Not available once current stock is depleted



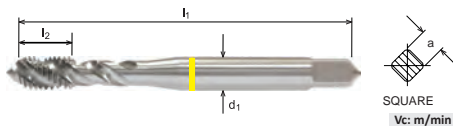
Code
548

Properties		
M	DIN 376	HSSE
CBA	TYPE W	
ISO 2 6H	GUN NOSE SPIRAL POINT	
		BRIGHT FINISH








Yellow Band Spiral Flute Taps

For machine tapping of blind holes in soft materials eg. Aluminium.



Code
558

P	M	K	Ti	Ni	Cu	N	Syn	H
1.1 1.2 1.3 1.4 1.5 1.6	2.1 2.2 2.3 2.4	3.1 3.2 3.3 3.4	4.1 4.2 4.3	5.1 5.2 5.3	6.1 6.2 6.3 6.4	7.1 7.2 7.3 7.4	8.1 8.2 8.3	9.1 9.2 9.3 9.4
25 22 18 16 12 10						40 35 20 15 30 30		

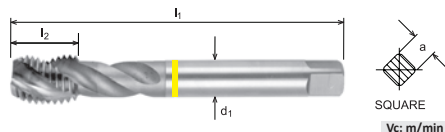
Properties		
M	DIN 371	HSSE
CBA	TYPE W	
ISO 2 6H		
		BRIGHT FINISH






Size	Pitch	l ₁	l ₂	d ₁	a	No. of Flutes	Code	Price
M3	0.5	56	5	3.5	2.7	2	5580300	
M4	0.7	63	7	4.5	3.4	2	5580400	
M5	0.8	70	8	6	4.9	2	5580500	
M6	1	80	10	6	4.9	2	5580600	
M8	1.25	90	12.5	8	6.2	2	5580800	
M10	1.5	100	15	10	8	3	5581000	

Code
569

Yellow Band Spiral Flute Taps

For machine tapping of blind holes in soft materials eg. Aluminium.



Properties		
M	DIN 376	HSSE
CBA	TYPE W	
ISO 2 6H		
		BRIGHT FINISH

P	M	K	Ti	Ni	Cu	N	Syn	H
1.1 1.2 1.3 1.4 1.5 1.6	2.1 2.2 2.3 2.4	3.1 3.2 3.3 3.4	4.1 4.2 4.3	5.1 5.2 5.3	6.1 6.2 6.3 6.4	7.1 7.2 7.3 7.4	8.1 8.2 8.3	9.1 9.2 9.3 9.4
25 22 18 16 12 10						40 35 20 15 30 30		

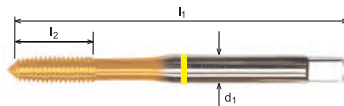
Size	Pitch	l ₁	l ₂	d ₁	a	No. of Flutes	Code	Price
M16	2	110	20	12	9	3	5691600	
M20	2.5	140	25	16	12	3	5692000	
M22	2.5	140	25	18	14.5	3	5692200	

Not available once current stock is depleted



Yellow Band Fluteless Taps

For cold forming threads in ductile materials.



SQUARE
Vc: m/min



OSG GROUP COMPANY

P				M				K				Ti				Ni				Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○																		○	○			●	●	●	●							
40	40	32																		20	20			25	20	20	20							

Size	Pitch	l ₁	l ₂	d ₁	a	Code	Price
M5	0.8	70	16	6	4.9	5120500	
M10	1.5	100	24	10	8	5121000	
M12	1.75	110	29	9	7	5121200	

Not available once current stock is depleted

Code
512

Properties		
M	DIN 371 M4 - M10	DIN 376 M12
HSSE	CBA	TYPE W
60°	6HX	FLUTELESS
TiN		

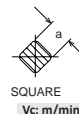
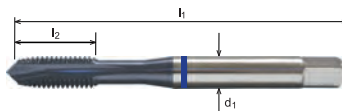




OSG GROUP COMPANY

**BEST
SELLER**

Blue Band Gun Nose Taps
For machine tapping of through holes
in tough materials eg. Stainless Steel.



Code
539

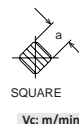
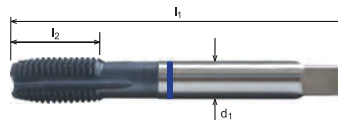
P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	○	○	●	●	●	●					○	○		○	○																
40	40	32	27	13	11	8	7	5						15	7		18	8																

Properties		
M	DIN 371	HSSE
CBA	TYPE VA	
ISO 2 6H	GUN NOSE SPIRAL POINT	
	RH	TIAIN

Size	Pitch	l ₁	l ₂	d ₁	a	No. of Flutes	Code	Price
M3	0.5	56	11	3.5	2.7	3	5390300	
M4	0.7	63	13	4.5	3.4	3	5390400	
M5	0.8	70	16	6	4.9	3	5390500	
M6	1	80	19	6	4.9	3	5390600	
M8	1.25	90	22	8	6.2	3	5390800	
M10	1.5	100	24	10	8	3	5391000	

Code
549

Blue Band Gun Nose Taps
For machine tapping of through holes
in tough materials eg. Stainless Steel.



Properties		
M	DIN 376	HSSE
CBA	TYPE VA	
ISO 2 6H	GUN NOSE SPIRAL POINT	
	RH	TIAIN

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	○	○	●	●	●	●					○	○		○	○																
40	40	32	27	13	11	8	7	5						15	7		18	8																

Size	Pitch	l ₁	l ₂	d ₁	a	No. of Flutes	Code	Price
M12	1.75	110	29	9	7	3	5491200	
M14	2	110	30	11	9	3	5491400	
M16	2	110	32	12	9	3	5491600	
M18	2.5	125	34	14	11	4	5491800	
M20	2.5	140	34	16	12	4	5492000	
M22	2.5	140	34	18	14.5	4	5492200	
M24	3	160	38	18	14.5	4	5492400	



THREADING
TOOLS



shaping your dreams

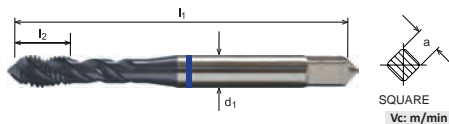
220

JUNE 2023 V3 SOMTA CATALOGUE

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Blue Band Spiral Flute Taps

For machine tapping of blind holes
in tough materials eg. Stainless Steel.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	○	○	●	●	●						○	○		○	○																
40	40	32	27	13	11	8	7	5						15	7		18	8																

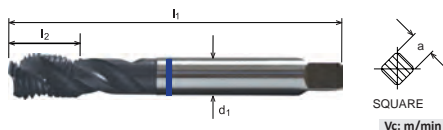
Size	Pitch	l ₁	l ₂	d ₁	a	No. of Flutes	Code	Price
M3	0.5	56	5	3.5	2.7	3	5590300	
M4	0.7	63	7	4.5	3.4	3	5590400	
M5	0.8	70	8	6	4.9	3	5590500	
M6	1	80	10	6	4.9	3	5590600	
M8	1.25	90	12.5	8	6.2	3	5590800	
M10	1.5	100	15	10	8	3	5591000	

Code
559

Properties		
M	DIN 371	HSSE
CBA	TYPE VA	
ISO 2 6H		
		TiAIN

Blue Band Spiral Flute Taps

For machine tapping of blind holes
in tough materials eg. Stainless Steel.



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	○	○	●	●	●	●					○	○		○	○																
40	40	32	27	13	11	8	7	5						15	7		18	8																

Size	Pitch	l ₁	l ₂	d ₁	a	No. of Flutes	Code	Price
M12	1.75	110	17.5	9	7	3	5701200	
M14	2	110	20	11	9	3	5701400	
M16	2	110	20	12	9	3	5701600	
M18	2.5	125	25	14	11	3	5701800	
M20	2.5	140	25	16	12	3	5702000	
M22	2.5	140	25	18	14.5	3	5702200	
M24	3	160	30	18	14.5	4	5702400	

Code
570

Properties		
M	DIN 376	HSSE
CBA	TYPE VA	
ISO 2 6H		
		TiAIN

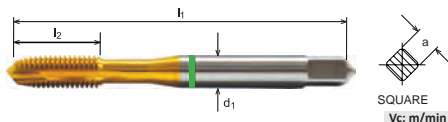




OSG GROUP COMPANY

Green Band Gun Nose Taps

For machine tapping of through holes in carbon steels.



Code
561

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
40	40	32	27	13	11	8	7	5		22	18	25	18							18	45	35		48	40	30	22							

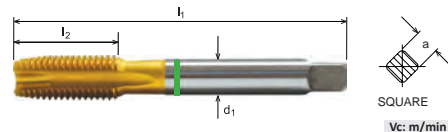
Properties		
M	DIN 371	HSSE
CBA	TYPE UNI	
ISO 2 6H	GUN NOSE SPIRAL POINT	
		TiN

Size	Pitch	l ₁	l ₂	d ₁	a	No. of Flutes	Code	Price
M3	0.5	56	11	3.5	2.7	3	5610300	
M4	0.7	63	13	4.5	3.4	3	5610400	
M5	0.8	70	16	6	4.9	3	5610500	
M6	1	80	19	6	4.9	3	5610600	
M7	1	80	19	7	5.5	3	5610700	
M8	1.25	90	22	8	6.2	3	5610800	
M10	1.5	100	24	10	8	3	5611000	

Code
566

Green Band Gun Nose Taps

For machine tapping of through holes in carbon steels.



Properties		
M	DIN 376	HSSE
CBA	TYPE UNI	
ISO 2 6H	GUN NOSE SPIRAL POINT	
		TiN

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
40	40	32	27	13	11	8	7	5		22	18	25	18							18	45	35		48	40	30	22							

Size	Pitch	l ₁	l ₂	d ₁	a	No. of Flutes	Code	Price
M3.5	0.6	56	13	2.5	2.1	3	5660350	
M4	0.7	63	13	2.8	2.1	3	5660400	
M5	0.8	70	16	3.5	2.7	3	5660500	
M6	1	80	19	4.5	3.4	3	5660600	
M8	1.25	90	22	6	4.9	3	5660800	
M10	1.5	100	24	7	5.5	3	5661000	
M12	1.75	110	29	9	7	3	5661200	
M14	2	110	30	11	9	3	5661400	
M16	2	110	32	12	9	4	5661600	
M18	2.5	125	34	14	11	4	5661800	
M20	2.5	140	34	16	12	4	5662000	
M22	2.5	140	34	18	14.5	4	5662200	
M24	3	160	38	18	14.5	4	5662400	



THREADING
TOOLS



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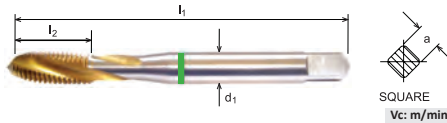
222

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Green Band Spiral Flute Taps

For machine tapping of blind holes
in carbon steels.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
																																		
40	40	32	27	13	11	8	7	5		22	18	25	18							18	45	35		48	40	30	22							

Size	Pitch	l ₁	l ₂	d ₁	a	No. of Flutes	Code	Price
M3	0.5	56	11	3.5	2.7	3	5620300	
M5	0.8	70	16	6	4.9	3	5620500	
M6	1	80	19	6	4.9	3	5620600	
M7	1	80	19	7	5.5	3	5620700	
M8	1.25	90	22	8	6.2	3	5620800	
M10	1.5	100	24	10	8	3	5621000	

Not available once current stock is depleted

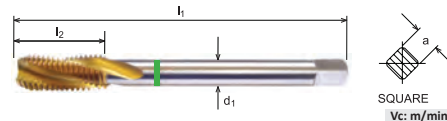


Code
562

Properties		
M	DIN 371	HSSE
CBA	TYPE UNI	60°
ISO 2 6H	15°	5-3
	RH	TiN

Green Band Spiral Flute Taps

For machine tapping of blind holes
in carbon steels.



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
40	40	32	27	13	11	8	7	5		22	18	25	18							18	45	35		48	40	30	22							

Size	Pitch	l ₁	l ₂	d ₁	a	No. of Flutes	Code	Price
M4	0.7	63	13	2.8	2.1	3	5670400	
M8	1.25	90	22	6	4.9	3	5670800	

Not available once current stock is depleted



Code
567

Properties		
M	DIN 376	HSSE
CBA	TYPE UNI	60°
ISO 2 6H	15°	5-3
	RH	TiN

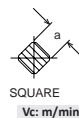
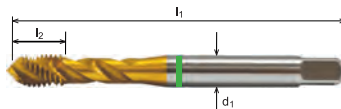




OSG GROUP COMPANY

Green Band Spiral Flute Taps

For machine tapping of blind holes in carbon steels.



SQUARE
Vc: m/min

Code
563

P	M	K	Ti	Ni	Cu	N	Syn	H
1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 2.3 2.4 3.1 3.2 3.3 3.4 4.1 4.2 4.3 5.1 5.2 5.3 6.1 6.2 6.3 6.4 7.1 7.2 7.3 7.4 8.1 8.2 8.3 9.1 9.2 9.3 9.4	1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 2.3 2.4 3.1 3.2 3.3 3.4 4.1 4.2 4.3 5.1 5.2 5.3 6.1 6.2 6.3 6.4 7.1 7.2 7.3 7.4 8.1 8.2 8.3 9.1 9.2 9.3 9.4	1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 2.3 2.4 3.1 3.2 3.3 3.4 4.1 4.2 4.3 5.1 5.2 5.3 6.1 6.2 6.3 6.4 7.1 7.2 7.3 7.4 8.1 8.2 8.3 9.1 9.2 9.3 9.4	1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 2.3 2.4 3.1 3.2 3.3 3.4 4.1 4.2 4.3 5.1 5.2 5.3 6.1 6.2 6.3 6.4 7.1 7.2 7.3 7.4 8.1 8.2 8.3 9.1 9.2 9.3 9.4	1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 2.3 2.4 3.1 3.2 3.3 3.4 4.1 4.2 4.3 5.1 5.2 5.3 6.1 6.2 6.3 6.4 7.1 7.2 7.3 7.4 8.1 8.2 8.3 9.1 9.2 9.3 9.4	1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 2.3 2.4 3.1 3.2 3.3 3.4 4.1 4.2 4.3 5.1 5.2 5.3 6.1 6.2 6.3 6.4 7.1 7.2 7.3 7.4 8.1 8.2 8.3 9.1 9.2 9.3 9.4	1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 2.3 2.4 3.1 3.2 3.3 3.4 4.1 4.2 4.3 5.1 5.2 5.3 6.1 6.2 6.3 6.4 7.1 7.2 7.3 7.4 8.1 8.2 8.3 9.1 9.2 9.3 9.4	1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 2.3 2.4 3.1 3.2 3.3 3.4 4.1 4.2 4.3 5.1 5.2 5.3 6.1 6.2 6.3 6.4 7.1 7.2 7.3 7.4 8.1 8.2 8.3 9.1 9.2 9.3 9.4	1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 2.3 2.4 3.1 3.2 3.3 3.4 4.1 4.2 4.3 5.1 5.2 5.3 6.1 6.2 6.3 6.4 7.1 7.2 7.3 7.4 8.1 8.2 8.3 9.1 9.2 9.3 9.4
40 40 32 27 13 11 8 7 5 22 18 25 18 18 45 35 48 40 30 22	40 40 32 27 13 11 8 7 5 22 18 25 18 18 45 35 48 40 30 22	40 40 32 27 13 11 8 7 5 22 18 25 18 18 45 35 48 40 30 22	40 40 32 27 13 11 8 7 5 22 18 25 18 18 45 35 48 40 30 22	40 40 32 27 13 11 8 7 5 22 18 25 18 18 45 35 48 40 30 22	40 40 32 27 13 11 8 7 5 22 18 25 18 18 45 35 48 40 30 22	40 40 32 27 13 11 8 7 5 22 18 25 18 18 45 35 48 40 30 22	40 40 32 27 13 11 8 7 5 22 18 25 18 18 45 35 48 40 30 22	40 40 32 27 13 11 8 7 5 22 18 25 18 18 45 35 48 40 30 22

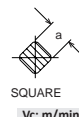
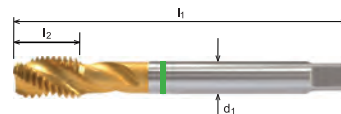
Properties		
M	DIN 371	HSSE
CBA	TYPE UNI	
ISO 2 6H		
	RH	TiN

Size	Pitch	l ₁	l ₂	d ₁	a	No. of Flutes	Code	Price
M3	0.5	56	5	3.5	2.7	3	5630300	
M4	0.7	63	7	4.5	3.4	3	5630400	
M5	0.8	70	8	6	4.9	3	5630500	
M6	1	80	10	6	4.9	3	5630600	
M7	1	80	10	7	5.5	3	5630700	
M8	1.25	90	12.5	8	6.2	3	5630800	
M10	1.5	100	15	10	8	3	5631000	

Code
568

Green Band Spiral Flute Taps

For machine tapping of blind holes in carbon steels.



SQUARE
Vc: m/min

Properties		
M	DIN 376	HSSE
CBA	TYPE UNI	
ISO 2 6H		
	RH	TiN

P	M	K	Ti	Ni	Cu	N	Syn	H
1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 2.3 2.4 3.1 3.2 3.3 3.4 4.1 4.2 4.3 5.1 5.2 5.3 6.1 6.2 6.3 6.4 7.1 7.2 7.3 7.4 8.1 8.2 8.3 9.1 9.2 9.3 9.4	1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 2.3 2.4 3.1 3.2 3.3 3.4 4.1 4.2 4.3 5.1 5.2 5.3 6.1 6.2 6.3 6.4 7.1 7.2 7.3 7.4 8.1 8.2 8.3 9.1 9.2 9.3 9.4	1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 2.3 2.4 3.1 3.2 3.3 3.4 4.1 4.2 4.3 5.1 5.2 5.3 6.1 6.2 6.3 6.4 7.1 7.2 7.3 7.4 8.1 8.2 8.3 9.1 9.2 9.3 9.4	1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 2.3 2.4 3.1 3.2 3.3 3.4 4.1 4.2 4.3 5.1 5.2 5.3 6.1 6.2 6.3 6.4 7.1 7.2 7.3 7.4 8.1 8.2 8.3 9.1 9.2 9.3 9.4	1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 2.3 2.4 3.1 3.2 3.3 3.4 4.1 4.2 4.3 5.1 5.2 5.3 6.1 6.2 6.3 6.4 7.1 7.2 7.3 7.4 8.1 8.2 8.3 9.1 9.2 9.3 9.4	1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 2.3 2.4 3.1 3.2 3.3 3.4 4.1 4.2 4.3 5.1 5.2 5.3 6.1 6.2 6.3 6.4 7.1 7.2 7.3 7.4 8.1 8.2 8.3 9.1 9.2 9.3 9.4	1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 2.3 2.4 3.1 3.2 3.3 3.4 4.1 4.2 4.3 5.1 5.2 5.3 6.1 6.2 6.3 6.4 7.1 7.2 7.3 7.4 8.1 8.2 8.3 9.1 9.2 9.3 9.4	1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 2.3 2.4 3.1 3.2 3.3 3.4 4.1 4.2 4.3 5.1 5.2 5.3 6.1 6.2 6.3 6.4 7.1 7.2 7.3 7.4 8.1 8.2 8.3 9.1 9.2 9.3 9.4	1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 2.3 2.4 3.1 3.2 3.3 3.4 4.1 4.2 4.3 5.1 5.2 5.3 6.1 6.2 6.3 6.4 7.1 7.2 7.3 7.4 8.1 8.2 8.3 9.1 9.2 9.3 9.4
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Size	Pitch	l ₁	l ₂	d ₁	a	No. of Flutes	Code	Price
M3.5	0.6	56	6	2.5	2.1	3	5680350	
M4	0.7	63	7	2.8	2.1	3	5680400	
M5	0.8	70	8	3.5	2.7	3	5680500	
M6	1	80	10	4.5	3.4	3	5680600	
M8	1.25	90	12.5	6	4.9	3	5680800	
M10	1.5	100	15	7	5.5	3	5681000	
M12	1.75	110	17.5	9	7	3	5681200	
M14	2	110	20	11	9	3	5681400	
M16	2	110	20	12	9	3	5681600	
M18	2.5	125	25	14	11	4	5681800	
M20	2.5	140	25	16	12	4	5682000	
M22	2.5	140	25	18	14.5	4	5682200	
M24	3	160	30	18	14.5	4	5682400	



THREADING
TOOLS



shaping your dreams

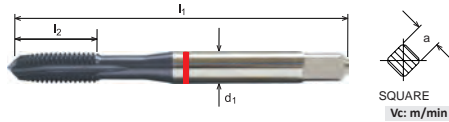
224

JUNE 2023 V3 SOMTA CATALOGUE

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Red Band Gun Nose Taps

For machine tapping of through holes in high tensile materials eg. Tool Steel.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	●	●												○	○																
40	40	32	27	13	11												18	8																

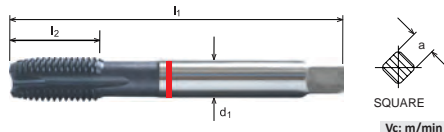
Size	Pitch	l ₁	l ₂	d ₁	a	No. of Flutes	Code	Price
M3	0.5	56	11	3.5	2.7	3	5400300	
M4	0.7	63	13	4.5	3.4	3	5400400	
M5	0.8	70	16	6	4.9	3	5400500	
M6	1	80	19	6	4.9	3	5400600	
M8	1.25	90	22	8	6.2	3	5400800	
M10	1.5	100	24	10	8	4	5401000	

Code
540

Properties		
M	DIN 371	HSSE
CBA	TYPE H	
ISO 2 6H	GUN NOSE SPIRAL POINT	
		TiAIN

Red Band Gun Nose Taps

For machine tapping of through holes in high tensile materials eg. Tool Steel.



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	●	●												○	○																
40	40	32	27	13	11												18	8																

Size	Pitch	l ₁	l ₂	d ₁	a	No. of Flutes	Code	Price
M12	1.75	110	29	9	7	4	5501200	
M14	2	110	30	11	9	4	5501400	
M16	2	110	32	12	9	4	5501600	
M18	2.5	125	34	14	11	4	5501800	
M20	2.5	140	34	16	12	4	5502000	
M22	2.5	140	34	18	14.5	4	5502200	
M24	3	160	38	18	14.5	4	5502400	

Code
550

Properties		
M	DIN 376	HSSE
CBA	TYPE H	
ISO 2 6H	GUN NOSE SPIRAL POINT	
		TiAIN

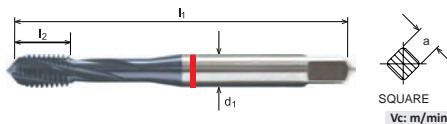




OSG GROUP COMPANY

Red Band Spiral Flute Taps

For machine tapping of blind holes
in high tensile materials eg. Tool Steel.



P				M				K				Ti				Ni				Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	○	●												○	○																
40	40	32	27	13	11												18	8																

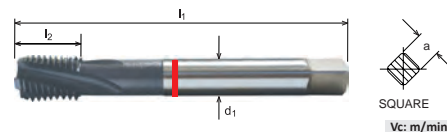
Size	Pitch	l ₁	l ₂	d ₁	a	No. of Flutes	Code	Price
M3	0.5	56	5	3.5	2.7	3	5640300	
M4	0.7	63	7	4.5	3.4	3	5640400	
M5	0.8	70	8	6	4.9	3	5640500	
M6	1	80	10	6	4.9	3	5640600	
M8	1.25	90	12.5	8	6.2	3	5640800	
M10	1.5	100	15	10	8	4	5641000	

Code
564

Properties		
M	DIN 371	HSSE
CBA	TYPE H	
ISO 2 6H		
		TAIIN

Red Band Spiral Flute Taps

For machine tapping of blind holes
in high tensile materials eg. Tool Steel.



P				M				K				Ti				Ni				Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	○	●												○	○																
40	40	32	27	13	11												18	8																

Size	Pitch	l ₁	l ₂	d ₁	a	No. of Flutes	Code	Price
M12	1.75	110	17.5	9	7	4	5761200	
M14	2	110	20	11	9	4	5761400	
M16	2	110	20	12	9	4	5761600	
M18	2.5	125	25	14	11	4	5761800	
M20	2.5	140	25	16	12	4	5762000	
M22	2.5	140	25	18	14.5	4	5762200	
M24	3	160	30	18	14.5	4	5762400	

Code
576

Properties		
M	DIN 376	HSSE
CBA	TYPE H	
ISO 2 6H		
		TAIIN



THREADING
TOOLS



shaping your dreams

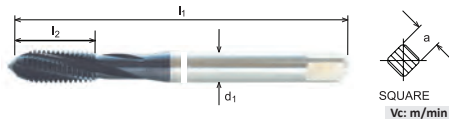
226

JUNE 2023 V3 SOMTA CATALOGUE

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White Band Spiral Flute Taps

For machine tapping of blind holes or through holes in Cast Iron.



OSG GROUP COMPANY

P					M				K				Ti			Ni				Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
										45	35	25	20																					

Size	Pitch	l ₁	l ₂	d ₁	a	No. of Flutes	Code	Price
M3	0.5	56	11	3.5	2.7	3	5780300	
M5	0.8	70	16	6	4.9	3	5780500	
M8	1.25	90	22	8	6.2	3	5780800	
M10	1.5	100	24	10	8	4	5781000	

Not available once current stock is depleted

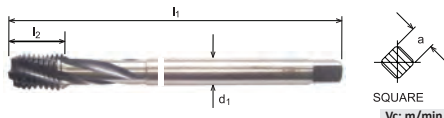


Code
578

Properties		
M	DIN 371	HSSE
CBA	TYPE GG	60°
ISO 2 6H	15°	C-3
		RH
TiAIN		

White Band Spiral Flute Taps

For machine tapping of blind holes or through holes in Cast Iron.



P					M				K				Ti			Ni				Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
										45	35	25	20																					

Size	Pitch	l ₁	l ₂	d ₁	a	No. of Flutes	Code	Price
M14	2	110	20	11	9	4	5791400	
M18	2.5	125	20	14	11	4	5791800	
M20	2.5	140	20	16	12	4	5792000	
M22	2.5	140	20	18	14.5	4	5792200	

Not available once current stock is depleted



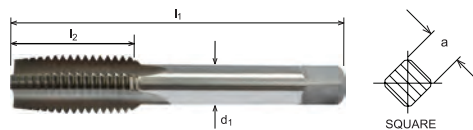
Code
579

Properties		
M	DIN 376	HSSE
CBA	TYPE GG	60°
ISO 2 6H	15°	C-3
		RH
TiAIN		










Short Hand Taps

For general hand tapping.



Code
511

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	○						○	○	○								○	○			○	○									

Properties		
MF	ISO 529	HSS
		
		
		

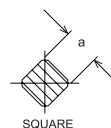
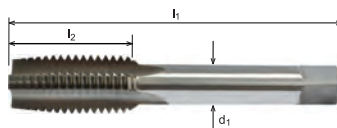
Size	Pitch	l ₁	l ₂	d ₁	a	No. of Flutes	Tap Set		Code		Price
							Code	Price	Taper	Bottom	
MF3	0.35	48	11	3.15	2.5	3	5110300		5110301	5110303	
MF4	0.5	53	13	4	3.15	3	5110400		5110401	5110403	
MF4.5	0.5	53	13	4.5	3.55	3	5110450		5110451	5110453	
MF5	0.5	58	16	5	4	3	5110500		5110501	5110503	
MF5	0.75	58	16	5	4	3	5110510		5110511	5110513	
MF5.5	0.5	62	17	5.6	4.5	3	5110550		5110551	5110553	
MF6	0.75	66	19	6.3	5	3	5110600		5110601	5110603	
MF7	0.75	66	19	7.1	5.6	4	5110700		5110701	5110703	
MF8	0.75	69	19	8	6.3	4	5110790		5110791	5110793	
MF8	1	69	19	8	6.3	4	5110800		5110801	5110803	
MF9	0.75	69	19	9	7.1	4	5110890		5110891	5110893	
MF9	1	69	19	9	7.1	4	5110900		5110901	5110903	
MF10	0.75	76	20	10	8	4	5110990		5110991	5110993	
#MF10	1	76	20	10	8	4	5111000		5111001	5111003	
MF10	1.25	76	20	10	8	4	5111010		5111011	5111013	
MF11	1	82	22	8	6.3	4	5111110		5111111	5111113	
MF11	1.25	82	22	8	6.3	4	5111120		5111121	5111123	
MF12	1	84	24	9	7.1	4	5111190		5111191	5111193	
*MF12	1.25	84	24	9	7.1	4	5111200		5111201	5111203	
MF12	1.5	89	29	9	7.1	4	5111210		5111211	5111213	
MF14	1	90	25	11.2	9	4	5111390		5111391	5111393	
*MF14	1.25	90	25	11.2	9	4	5111400		5111401	5111403	
MF14	1.5	95	30	11.2	9	4	5111410		5111411	5111413	
MF15	1	95	30	11.2	9	4	5111490		5111491	5111493	
MF15	1.5	95	30	11.2	9	4	5111500		5111501	5111503	
MF16	1	95	25	12.5	10	4	5111590		5111591	5111593	
#MF16	1.5	102	32	12.5	10	4	5111600		5111601	5111603	
MF17	1.5	102	32	12.5	10	4	5111700		5111701	5111703	
MF18	1	104	29	14	11.2	4	5111780		5111781	5111783	
MF18	1.25	104	29	14	11.2	4	5111790		5111791	5111793	
*MF18	1.5	104	29	14	11.2	4	5111800		5111801	5111803	
MF18	2	112	37	14	11.2	4	5111810		5111811	5111813	
MF20	1	104	29	14	11.2	4	5111990		5111991	5111993	
#MF20	1.5	104	29	14	11.2	4	5112000		5112001	5112003	
MF20	2	112	37	14	11.2	4	5112010		5112011	5112013	
MF22	1	113	33	16	12.5	4	5112190		5112191	5112193	
MF22	1.5	113	33	16	12.5	4	5112200		5112201	5112203	
MF22	2	118	38	16	12.5	4	5112210		5112211	5112213	
MF24	1	120	35	18	14	4	5112390		5112391	5112393	
MF24	1.5	120	35	18	14	4	5112400		5112401	5112403	
MF24	2	120	35	18	14	4	5112410		5112411	5112413	
MF25	1	120	35	18	14	4	5112490		5112491	5112493	
#MF25	1.5	120	35	18	14	4	5112500		5112501	5112503	
MF25	2	120	35	18	14	4	5112510		5112511	5112513	
MF27	1.5	127	37	20	16	4	5112700		5112701	5112703	
MF27	2	127	37	20	16	4	5112710		5112711	5112713	
MF28	1.5	127	37	20	16	4	5112800		5112801	5112803	
MF28	2	127	37	20	16	4	5112810		5112811	5112813	
MF30	1	127	37	20	16	4	5112990		5112991	5112993	

Continued on next page...



Short Hand Taps

For general hand tapping.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	○						○	○	○								○	○			○	○									

Size	Pitch	l ₁	l ₂	d ₁	a	No. of Flutes	Tap Set		Code		Price
							Code	Price	Taper	Bottom	
... from previous page											
MF30	1.5	127	37	20	16	4	5113000		5113001	5113003	
MF30	2	127	37	20	16	4	5113010		5113011	5113013	
MF30	3	138	48	20	16	4	5113020		5113021	5113023	
#MF32	1.5	137	37	22.4	18	4	5113200		5113201	5113203	
MF32	2	137	37	22.4	18	4	5113210		5113211	5113213	
MF33	1.5	137	37	22.4	18	4	5113300		5113301	5113303	
MF33	2	137	37	22.4	18	4	5113310		5113311	5113313	
MF33	3	151	51	22.4	18	4	5113320		5113321	5113323	
MF35	1.5	144	39	25	20	4	5113500		5113501	5113503	
MF36	1.5	144	39	25	20	4	5113600		5113601	5113603	
MF36	2	144	39	25	20	4	5113610		5113611	5113613	
MF36	3	162	57	25	20	4	5113620		5113621	5113623	
MF38	1.5	149	39	28	22.4	6	5113810		5113811	5113813	
MF38	2	149	39	28	22.4	6	5113820		5113821	5113823	
MF39	1.5	149	39	28	22.4	6	5113900		5113901	5113903	
MF39	2	149	39	28	22.4	6	5113910		5113911	5113913	
MF39	3	170	60	28	22.4	6	5113920		5113921	5113923	
MF40	2	149	39	28	22.4	6	5114010		5114011	5114013	
MF40	3	170	60	28	22.4	6	5114020		5114021	5114023	
MF42	1.5	149	39	28	22.4	6	5114200		5114201	5114203	
MF42	2	149	39	28	22.4	6	5114210		5114211	5114213	
MF42	3	170	60	28	22.4	6	5114220		5114221	5114223	
MF42	4	170	60	28	22.4	6	5114230		5114231	5114233	
MF45	1.5	165	45	31.5	25	6	5114500		5114501	5114503	
MF45	2	165	45	31.5	25	6	5114510		5114511	5114513	
MF45	3	187	67	31.5	25	6	5114520		5114521	5114523	
MF48	1.5	165	45	31.5	25	6	5114800		5114801	5114803	
MF48	2	165	45	31.5	25	6	5114810		5114811	5114813	
MF48	3	187	67	31.5	25	6	5114820		5114821	5114823	
MF48	4	187	67	31.5	25	6	5114830		5114831	5114833	
MF50	3	187	67	31.5	25	6	5115020		5115021	5115023	
MF52	2	175	45	35.5	28	6	5115210		5115211	5115213	
MF52	3	200	70	35.5	28	6	5115220		5115221	5115223	
MF52	4	200	70	35.5	28	6	5115230		5115231	5115233	

* Spark Plug
Conduit



Code
511

Properties		
MF	ISO 529	HSS
	ISO 2 6H	STRAIGHT FLUTE

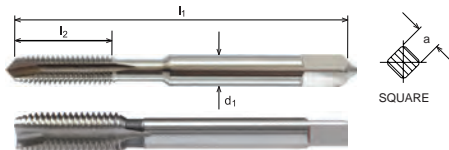




OSG GROUP COMPANY

Gun Nose Short Machine Taps



































For machine tapping of through holes.



Vc: m/min

Code

515

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
																																		
25	22	18	16	10	5	6	5			15	8	15	8	10	5		12	5		12	30	20		40	35	20	15	30						

Properties

MF

ISO 529

HSSE



ISO 2 6H

GUN NOSE SPIRAL POINT



Size	Pitch	l ₁	l ₂	d ₁	a	No. of Flutes	Code	Price
MF4	0.5	53	13	4	3.15	3	5150400	
MF5	0.75	58	16	5	4	3	5150500	
MF6	0.75	66	19	6.3	5	3	5150600	
MF8	1	69	19	8	6.3	3	5150800	
MF9	1	69	19	9	7.1	3	5150900	
MF10	1	76	20	10	8	3	5151000	
MF10	1.25	76	20	10	8	3	5151010	
MF12	1	84	24	9	7.1	3	5151190	
MF12	1.25	84	24	9	7.1	3	5151200	
MF12	1.5	89	29	9	7.1	3	5151210	
MF14	1	90	25	11.2	9	3	5151390	
MF14	1.25	90	25	11.2	9	3	5151400	
MF14	1.5	95	30	11.2	9	3	5151410	
MF16	1.5	102	32	12.5	10	4	5151600	
MF18	1.5	104	29	14	11.2	4	5151800	
MF20	1.5	104	29	14	11.2	4	5152000	
MF22	1.5	113	33	16	12.5	4	5152200	
MF24	1.5	120	35	18	14	4	5152400	



THREADING
TOOLS



shaping your dreams

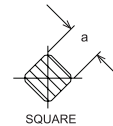
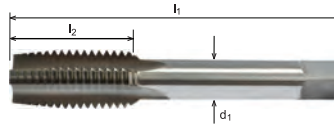
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Short Hand Taps

For general hand tapping.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	○						○	○	○									○	○			○	○								

Code

521

Size	TPI	l ₁	l ₂	d ₁	a	No. of Flutes	Tap Set		Code			Price
							Code	Price	Taper	Second	Bottom	
1/16	60	41	8	2.5	2	3	5210160		5210161	5210162	5210163	
3/32	48	44.5	9.5	2.8	2.24	3	5210240		5210241	5210242	5210243	
1/8	40	48	11	3.15	2.5	3	5210320		5210321	5210322	5210323	
5/32	32	53	13	4	3.15	3	5210400		5210401	5210402	5210403	
3/16	24	58	16	5	4	3	5210480		5210481	5210482	5210483	
1/4	20	66	19	6.3	5	3	5210640		5210641	5210642	5210643	
5/16	18	72	22	8	6.3	4	5210790		5210791	5210792	5210793	
3/8	16	80	24	10	8	4	5210950		5210951	5210952	5210953	
7/16	14	85	25	8	6.3	4	5211110		5211111	5211112	5211113	
1/2	12	89	29	9	7.1	4	5211270		5211271	5211272	5211273	
9/16	12	95	30	11.2	9	4	5211430		5211431	5211432	5211433	
5/8	11	102	32	12.5	10	4	5211590		5211591	5211592	5211593	
3/4	10	112	37	14	11.2	4	5211910		5211911	5211912	5211913	
7/8	9	118	38	16	12.5	4	5212220		5212221	5212222	5212223	
1"	8	130	45	18	14	4	5212540		5212541	5212542	5212543	
1.1/8	7	138	48	20	16	4	5212860		5212861	5212862	5212863	
1.1/4	7	151	51	22.4	18	4	5213170		5213171	5213172	5213173	
1.1/2	6	170	60	28	22.4	6	5213810		5213811	5213812	5213813	
1.3/4	5	187	67	31.5	25	6	5214450		5214451	5214452	5214453	
2"	4.5	200	70	35.5	28	6	5215080		5215081	5215082	5215083	



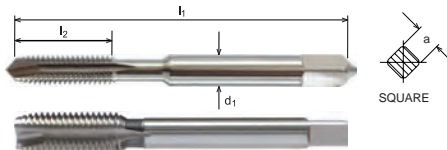
Properties

BSW	ISO 529	HSS
	CLASS 2	STRAIGHT FLUTE



Gun Nose Short Machine Taps

For machine tapping of through holes.



SQUARE

Vc: m/min

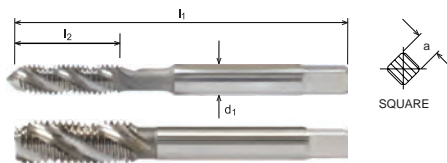
P				M				K				Ti				Ni				Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
25	22	18	16	10	5	6	5			15	8	15	8	10	5		12	5		12	30	20		40	35	20	15	30						

Size	TPI	l ₁	l ₂	d ₁	a	No. of Flutes	Code	Price
1/8	40	48	11	3.15	2.5	3	5260320	
5/32	32	53	13	4	3.15	3	5260400	
3/16	24	58	16	5	4	3	5260480	
1/4	20	66	19	6.3	5	3	5260640	
5/16	18	72	22	8	6.3	3	5260790	
3/8	16	80	24	10	8	3	5260950	
7/16	14	85	25	8	6.3	3	5261110	
1/2	12	89	29	9	7.1	3	5261270	
9/16	12	95	30	11.2	9	3	5261430	
5/8	11	102	32	12.5	10	4	5261590	
3/4	10	112	37	14	11.2	4	5261910	
7/8	9	118	38	16	12.5	4	5262220	
1"	8	130	45	18	14	4	5262540	



Spiral Flute Short Machine Taps

For machine tapping of blind holes.



SQUARE

Vc: m/min

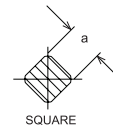
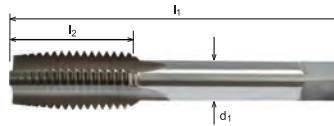
P				M				K				Ti				Ni				Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
25	22	18	16	10	5	6	5			15	8	15	8	10	5		12	5		12	30	20		40	35	20	15	30						

Size	TPI	l ₁	l ₂	d ₁	a	No. of Flutes	Code	Price
1/8	40	48	11	3.15	2.5	3	5280320	
5/32	32	53	13	4	3.15	3	5280400	
3/16	24	58	16	5	4	3	5280480	
1/4	20	66	19	6.3	5	3	5280640	
5/16	18	72	22	8	6.3	3	5280790	
3/8	16	80	24	10	8	3	5280950	
7/16	14	85	25	8	6.3	3	5281110	
1/2	12	89	29	9	7.1	3	5281270	
9/16	12	95	30	11.2	9	3	5281430	
5/8	11	102	32	12.5	10	3	5281590	
3/4	10	112	37	14	11.2	4	5281910	
7/8	9	118	38	16	12.5	4	5282220	
1"	8	130	45	18	14	4	5282540	



Short Hand Taps

For general hand tapping.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	○						○	○	○								○	○			○	○									

Code

531

Size	TPI	l ₁	l ₂	d ₁	a	No. of Flutes	Tap Set		Code			Price
							Code	Price	Taper	Second	Bottom	
3/16	32	58	16	5	4	3	5310480		5310481	5310482	5310483	
1/4	26	66	19	6.3	5	3	5310640		5310641	5310642	5310643	
5/16	22	72	22	8	6.3	4	5310790		5310791	5310792	5310793	
3/8	20	80	24	10	8	4	5310950		5310951	5310952	5310953	
7/16	18	85	25	8	6.3	4	5311110		5311111	5311112	5311113	
1/2	16	89	29	9	7.1	4	5311270		5311271	5311272	5311273	
9/16	16	95	30	11.2	9	4	5311430		5311431	5311432	5311433	
5/8	14	102	32	12.5	10	4	5311590		5311591	5311592	5311593	
3/4	12	112	37	14	11.2	4	5311910		5311911	5311912	5311913	
7/8	11	118	38	16	12.5	4	5312220		5312221	5312222	5312223	
1"	10	130	45	18	14	4	5312540		5312541	5312542	5312543	
1.1/8	9	138	48	20	16	4	5312860		5312861	5312862	5312863	
1.1/4	9	151	51	22.4	18	4	5313180		5313181	5313182	5313183	
1.3/8	8	162	57	25	20	4	5313490		5313491	5313492	5313493	
1.1/2	8	170	60	28	22.4	6	5313810		5313811	5313812	5313813	
1.5/8	8	170	60	28	22.4	6	5314120		5314121	5314122	5314123	
1.3/4	7	187	67	31.5	25	6	5314450		5314451	5314452	5314453	
2"	7	200	70	35.5	28	6	5315080		5315081	5315082	5315083	



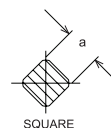
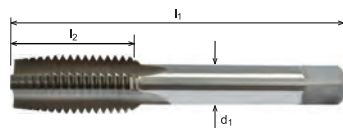
Properties

BSF	ISO 529	HSS
55°	CLASS 2	STRAIGHT FLUTE




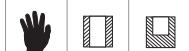
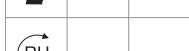


Short Hand Taps

For general hand tapping.



Code
541

P						M				K				Ti			Ni			Cu				N				Syn				H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4	
○	○									○	○	○								○	○			○	○										

Properties		
UNC	ISO 529	HSS
	ISO 2 2B	STRAIGHT FLUTE
		
		





Size	Nom. Dia.	TPI	l ₁	l ₂	d ₁	a	No. of Flutes	Tap Set		Code				Price
No.4	2.84	40	48	11	3.15	2.5	3	5410280		5410281	5410282	5410283		
No.5	3.18	40	48	11	3.15	2.5	3	5410320		5410321	5410322	5410323		
No.6	3.51	32	50	13	3.55	2.8	3	5410350		5410351	5410352	5410353		
No.8	4.17	32	53	13	4.5	3.55	3	5410420		5410421	5410422	5410423		
No.10	4.83	24	58	16	5	4	3	5410480		5410481	5410482	5410483		
No.12	5.49	24	62	17	5.6	4.5	3	5410550		5410551	5410552	5410553		
1/4	20	66	19	6.3	5	3	3	5410640		5410641	5410642	5410643		
5/16	18	72	22	8	6.3	4	4	5410790		5410791	5410792	5410793		
3/8	16	80	24	10	8	4	4	5410950		5410951	5410952	5410953		
7/16	14	85	25	8	6.3	4	4	5411110		5411111	5411112	5411113		
1/2	13	89	29	9	7.1	4	4	5411270		5411271	5411272	5411273		
9/16	12	95	30	11.2	9	4	4	5411430		5411431	5411432	5411433		
5/8	11	102	32	12.5	10	4	4	5411590		5411591	5411592	5411593		
3/4	10	112	37	14	11.2	4	4	5411910		5411911	5411912	5411913		
7/8	9	118	38	16	12.5	4	4	5412220		5412221	5412222	5412223		
1"	8	130	45	18	14	4	4	5412540		5412541	5412542	5412543		
1.1/8	7	138	48	20	16	4	4	5412860		5412861	5412862	5412863		
1.1/4	7	151	51	22.4	18	4	4	5413180		5413181	5413182	5413183		
1.3/8	6	162	57	25	20	4	4	5413490		5413491	5413492	5413493		
1.1/2	6	170	60	28	22.4	6	4	5413810		5413811	5413812	5413813		
1.3/4	5	187	67	31.5	25	6	4	5414450		5414451	5414452	5414453		
2"	4.5	200	70	35.5	28	6	4	5415080		5415081	5415082	5415083		



OSG GROUP COMPANY

Size	Nom. Dia.	TPI	I ₁	I ₂	d ₁	a	No. of Flutes	Code	Price
No.6	3.51	32	50	13	3.55	2.8	3	5450350	
No.8	4.17	32	53	13	4.5	3.55	3	5450420	
No.10	4.83	24	58	16	5	4	3	5450480	
No.12	5.49	24	62	17	5.6	4.5	3	5450550	
1/4		20	66	19	6.3	5	3	5450640	
5/16		18	72	22	8	6.3	3	5450790	
3/8		16	80	24	10	8	3	5450950	
7/16		14	85	25	8	6.3	3	5451110	
1/2		13	89	29	9	7.1	3	5451270	
9/16		12	95	30	11.2	9	3	5451430	
5/8		11	102	32	12.5	10	4	5451590	
3/4		10	112	37	14	11.2	4	5451910	
7/8		9	118	38	16	12.5	4	5452220	
1"		8	130	45	18	14	4	5452540	



Code		
545		
Properties		
UNC	ISO 529	HSSE
	ISO 2 2B	GUN NOSE SPIRAL POINT
		

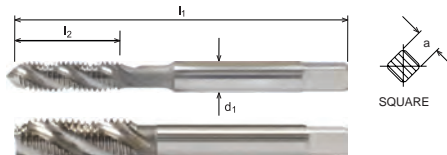
THREADING TOOLS



OSG GROUP COMPANY

Spiral Flute Short Machine Taps

































For machine tapping of blind holes.



Vc: m/min

Code

546

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
																																		
25	22	18	16	10	5	6	5			15	8	15	8	10	5		12	5		12	30	20		40	35	20	15	30						

Properties

UNC **ISO 529** **HSSE**



Size	Nom. Dia.	TPI	l ₁	l ₂	d ₁	a	No. of Flutes	Code	Price
No.6	3.51	32	50	13	3.55	2.8	3	5460350	
No.8	4.17	32	53	13	4.5	3.55	3	5460420	
No.10	4.83	24	58	16	5	4	3	5460480	
No.12	5.49	24	62	17	5.6	4.5	3	5460550	
1/4		20	66	19	6.3	5	3	5460640	
5/16		18	72	22	8	6.3	3	5460790	
3/8		16	80	24	10	8	3	5460950	
7/16		14	85	25	8	6.3	3	5461110	
1/2		13	89	29	9	7.1	3	5461270	
9/16		12	95	30	11.2	9	3	5461430	
5/8		11	102	32	12.5	10	3	5461590	
3/4		10	112	37	14	11.2	4	5461910	
7/8		9	118	38	16	12.5	4	5462220	
1"		8	130	45	18	14	4	5462540	



THREADING
TOOLS



shaping your dreams

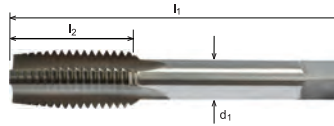
236

JUNE 2023 V3 SOMTA CATALOGUE

www.somta.co.za

Short Hand Taps

For general hand tapping.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	○						○	○	○								○	○			○	○									

Code

551

Size	Nom. Dia.	TPI	l ₁	l ₂	d ₁	a	No. of Flutes	Tap Set		Code			Price
								Code	Price	Taper	Second	Bottom	
No.4	2.85	48	48	11	3.15	2.5	3	5510280		5510281	5510282	5510283	
No.5	3.18	44	48	11	3.15	2.5	3	5510320		5510321	5510322	5510323	
No.6	3.51	40	50	13	3.55	2.8	3	5510350		5510351	5510352	5510353	
No.8	4.17	36	53	13	4.5	3.55	3	5510420		5510421	5510422	5510423	
No.10	4.83	32	58	16	5	4	3	5510480		5510481	5510482	5510483	
No.12	5.49	28	62	17	5.6	4.5	3	5510550		5510551	5510552	5510553	
1/4		28	66	19	6.3	5	3	5510640		5510641	5510642	5510643	
5/16		24	69	19	8	6.3	4	5510790		5510791	5510792	5510793	
3/8		24	76	20	10	8	4	5510950		5510951	5510952	5510953	
7/16		20	82	22	8	6.3	4	5511110		5511111	5511112	5511113	
1/2		20	84	24	9	7.1	4	5511270		5511271	5511272	5511273	
9/16		18	90	25	11.2	9	4	5511430		5511431	5511432	5511433	
5/8		18	95	25	12.5	10	4	5511590		5511591	5511592	5511593	
3/4		16	104	29	14	11.2	4	5511910		5511911	5511912	5511913	
7/8		14	113	33	16	12.5	4	5512220		5512221	5512222	5512223	
1"		12	120	35	18	14	4	5512540		5512541	5512542	5512543	
1.1/8		12	127	37	20	16	4	5512860		5512861	5512862	5512863	
1.1/4		12	137	37	22.4	18	4	5513180		5513181	5513182	5513183	
1.3/8		12	144	39	25	20	4	5513490		5513491	5513492	5513493	
1.1/2		12	149	39	28	22.4	6	5513810		5513811	5513812	5513813	



Properties		
UNF	ISO 529	HSS
	ISO 2 2B	STRAIGHT FLUTE

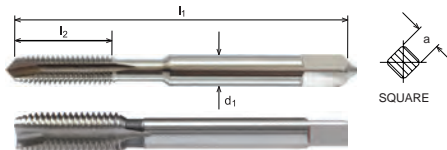






























OSG GROUP COMPANY

Gun Nose Short Machine Taps

For machine tapping of through holes.



Vc: m/min

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
																																		
25	22	18	16	10	5	6	5			15	8	15	8	10	5		12	5		12	30	20		40	35	20	15	30						

Size	Nom. Dia.	TPI	l ₁	l ₂	d ₁	a	No. of Flutes	Code	Price
No.4	2.85	48	48	11	3.15	2.5	3	5550280	
No.5	3.18	44	48	11	3.15	2.5	3	5550320	
No.6	3.51	40	50	13	3.55	2.8	3	5550350	
No.8	4.17	36	53	13	4.5	3.55	3	5550420	
No.10	4.83	32	58	16	5	4	3	5550480	
No.12	5.49	28	62	17	5.6	4.5	3	5550550	
1/4		28	66	19	6.3	5	3	5550640	
5/16		24	69	19	8	6.3	3	5550790	
3/8		24	76	20	10	8	3	5550950	
7/16		20	82	22	8	6.3	3	5551110	
1/2		20	84	24	9	7.1	3	5551270	
9/16		18	90	25	11.2	9	3	5551430	
5/8		18	95	25	12.5	10	4	5551590	
3/4		16	104	29	14	11.2	4	5551910	
7/8		14	113	33	16	12.5	4	5552220	
1"		12	120	35	18	14	4	5552540	



THREADING
TOOLS



shaping your dreams

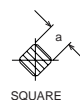
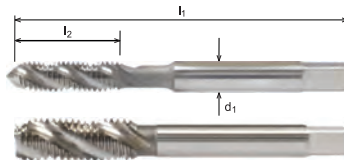
238

JUNE 2023 V3 SOMTA CATALOGUE

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Spiral Flute Short Machine Taps

For machine tapping of blind holes.



OSG GROUP COMPANY

Vc: m/min

P					M				K				Ti			Ni			Cu				N				Syn			H				
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
25	22	18	16	10	5	6	5			15	8	15	8	10	5		12	5		12	30	20		40	35	20	15	30						

Size	Nom. Dia.	TPI	l ₁	l ₂	d ₁	a	No. of Flutes	Code	Price
No.4	2.85	48	48	11	3.15	2.5	3	5560280	
No.5	3.18	44	48	11	3.15	2.5	3	5560320	
No.6	3.51	40	50	13	3.55	2.8	3	5560350	
No.8	4.17	36	53	13	4.5	3.55	3	5560420	
No.10	4.83	32	58	16	5	4	3	5560480	
No.12	5.49	28	62	17	5.6	4.5	3	5560550	
1/4		28	66	19	6.3	5	3	5560640	
5/16		24	69	19	8	6.3	3	5560790	
3/8		24	76	20	10	8	3	5560950	
7/16		20	82	22	8	6.3	3	5561110	
1/2		20	84	24	9	7.1	3	5561270	
9/16		18	90	25	11.2	9	3	5561430	
5/8		18	95	25	12.5	10	3	5561590	
3/4		16	104	29	14	11.2	4	5561910	
7/8		14	113	33	16	12.5	4	5562220	
1"		12	120	35	18	14	4	5562540	

Not available once current stock is depleted



Properties		
UNF	ISO 529	HSSE
	ISO 2 2B	

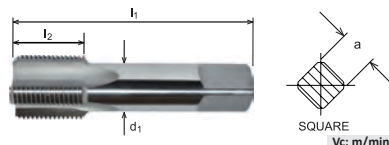




OSG GROUP COMPANY

Parallel Pipe Taps

For hand or machine tapping of through or blind holes.



Code
571

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
22	20	16	12	7						12	7	10								12	30			20	35									

Properties		
BSP	ISO 2284	HSS
	BS 949 1982 PART 3	STRAIGHT FLUTE

Size	Nom. Dia.	TPI	l ₁	l ₂	d ₁	a	No. of Flutes	Tap Set		Code		Price
								Code	Price	Taper	Bottom	Price
1/8	9.728	28	59	15	8	6.3	4	5710320		5710321	5710323	
1/4	13.157	19	67	19	10	8	4	5710640		5710641	5710643	
3/8	16.662	19	75	21	12.5	10	4	5710950		5710951	5710953	
1/2	20.955	14	87	26	16	12.5	4	5711270		5711271	5711273	
5/8	22.911	14	91	26	18	14	4	5711590		5711591	5711593	
3/4	26.441	14	96	28	20	16	4	5711910		5711911	5711913	
7/8	30.201	14	102	29	22.4	18	4	5712220		5712221	5712223	
1"	33.249	11	109	33	25	20	6	5712540		5712541	5712543	
1.1/4	41.910	11	119	36	31.5	25	6	5713170		5713171	5713173	
1.1/2	47.803	11	125	37	35.5	28	6	5713810		5713811	5713813	
1.3/4	53.746	11	132	39	35.5	28	6	5714450		5714451	5714453	
2"	59.614	11	140	41	40	31.5	6	5715080		5715081	5715083	
2.1/4	65.710	11	142	42	40	31.5	6	5715720		5715721	5715723	
2.1/2	75.184	11	153	45	45	35.5	6	5716350		5716351	5716353	
3"	87.884	11	164	48	50	40	6	5717620		5717621	5717623	

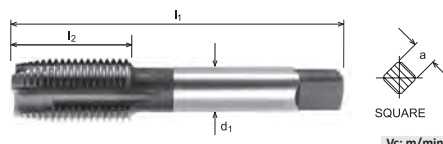


Code
573

Properties		
BSP	ISO 2284	HSSE
	BS 949 1982 PART 3	GUN NOSE SPIRAL POINT

Gun Nose Short Machine Pipe Taps

For machine tapping of through holes.



P						M				K				Ti			Ni				Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4	
●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	
25	22	18	16	10	5	6	5			15	8	15	8	10	5		12	5		12	30	20		40	35	20	15	30							

Size	Nom. Dia.	TPI	l ₁	l ₂	d ₁	a	No. of Flutes	Code	Price
1/8	9.728	28	59	15	8	6.3	3	5730320	
1/4	13.157	19	67	19	10	8	3	5730640	
3/8	16.662	19	75	21	12.5	10	4	5730950	
1/2	20.955	14	87	26	16	12.5	4	5731270	
3/4	26.441	14	96	28	20	16	4	5731910	



THREADING TOOLS



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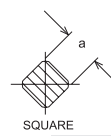
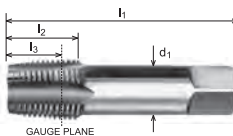
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JUNE 2023 V3 SOMTA CATALOGUE

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Taper Pipe Hand Taps

For hand or machine tapping of through or blind holes.



OSG GROUP COMPANY

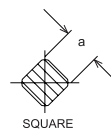
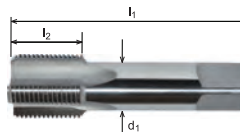
P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	○						○	○	○								○	○	○	○	○	○	○	○							
7	6	5	4	3						12	7	10								4	10			18	12									

Size	Nom. Dia. at Gauge Plane	TPI	l ₁	l ₂	l ₃	d ₁	a	No. of Flutes	Tap Set		Code		Price
									Code	Price	Taper	Bottom	
1/8	9.728	28	59	15	10.1	8	6.3	3	5750320		5750321	5750323	
1/4	13.157	19	67	19	15	10	8	5	5750640		5750641	5750643	
3/8	16.662	19	75	21	15.4	12.5	10	5	5750950		5750951	5750953	
1/2	20.955	14	87	26	20.5	16	12.5	5	5751270		5751271	5751273	
3/4	26.441	14	96	28	21.8	20	16	5	5751910		5751911	5751913	
1"	33.249	11	109	33	26	25	20	5	5752540		5752541	5752543	
1.1/4	41.910	11	119	36	28.3	31.5	25	7	5753170		5753171	5753173	
1.1/2	47.803	11	125	37	28.3	35.5	28	7	5753810		5753811	5753813	
2"	59.614	11	140	41	32.7	40	31.5	7	5755080		5755081	5755083	



Parallel Pipe Taps

For hand or machine tapping of through or blind holes.



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	○	○					○	○	○	○							○	○	○	○	○	○	○	○							
22	20	16	12	7						12	7	10								12	30			20	35									

Size	Nom. Dia.	TPI	l ₁	l ₂	d ₁	a	No. of Flutes	Tap Set		Code		Price
								Code	Price	Taper	Bottom	
1/8	10.272	27	59	15	8	6.3	4	5810320		5810321	5810323	
1/4	13.571	18	67	19	10	8	4	5810640		5810641	5810643	
3/8	17.054	18	75	21	12.5	10	4	5810950		5810951	5810953	
1/2	21.224	14	87	26	16	12.5	4	5811270		5811271	5811273	
3/4	26.568	14	96	28	20	16	4	5811910		5811911	5811913	
1"	33.228	11.5	109	33	25	20	6	5812540		5812541	5812543	
1.1/4	41.986	11.5	119	36	31.5	25	6	5813170		5813171	5813173	
1.1/2	48.054	11.5	125	37	35.5	28	6	5813810		5813811	5813813	
2"	60.091	11.5	140	41	40	31.5	6	5815080		5815081	5815083	



Code		
581		

Properties		
BSPT	ISO 2284	HSS
55°	BS 949 1982 PART 3	STRAIGHT FLUTE
Hand		
Left Hand		

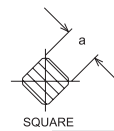
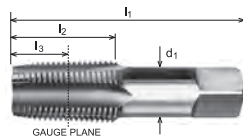




OSG GROUP COMPANY

Taper Pipe Taps

For hand or machine tapping of through or blind holes.



Code
585

P	M	K	Ti	Ni	Cu	N	Syn	H
1.1 1.2 1.3 1.4 1.5 1.6	2.1 2.2 2.3 2.4	3.1 3.2 3.3 3.4	4.1 4.2 4.3	5.1 5.2 5.3	6.1 6.2 6.3 6.4	7.1 7.2 7.3 7.4	8.1 8.2 8.3	9.1 9.2 9.3 9.4
○ ○ ○ ○ ○ ○		○ ○ ○			○ ○ ○	○ ○		
7 6 5 4 3		12 7 10			4 10	18 12		

Properties		
NPT	ISO 2284	HSS
	ANSI B94.9 1979	STRAIGHT FLUTE

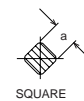
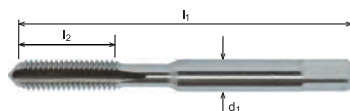
Size	Nom. Dia. at Gauge Plane	TPI	l1	l2	l3	d1	a	No. of Flutes	Tap Set		Code		Price
									Code	Price	Taper	Bottom	
1/8	10.272	27	59	15	7.9	8	6.3	3	5850320		5850321	5850323	
1/4	13.571	18	67	19	11.7	10	8	5	5850640		5850641	5850643	
3/8	17.054	18	75	21	11.5	12.5	10	5	5850950		5850951	5850953	
1/2	21.224	14	87	26	14.7	16	12.5	5	5851270		5851271	5851273	
3/4	26.568	14	96	28	14.4	20	16	5	5851910		5851911	5851913	
1"	33.228	11.5	109	33	17.2	25	20	5	5852540		5852541	5852543	
1.1/4	41.986	11.5	119	36	17.4	31.5	25	7	5853170		5853171	5853173	
1.1/2	48.054	11.5	125	37	17.8	35.5	28	7	5853810		5853811	5853813	
2"	60.091	11.5	140	41	16.9	40	31.5	7	5855080		5855081	5855083	



Code
591

Short Hand Taps

For general hand tapping.



Properties		
BA	ISO 529	HSS
	MEDIUM	STRAIGHT FLUTE

P	M	K	Ti	Ni	Cu	N	Syn	H
1.1 1.2 1.3 1.4 1.5 1.6	2.1 2.2 2.3 2.4	3.1 3.2 3.3 3.4	4.1 4.2 4.3	5.1 5.2 5.3	6.1 6.2 6.3 6.4	7.1 7.2 7.3 7.4	8.1 8.2 8.3	9.1 9.2 9.3 9.4
○ ○ ○ ○ ○ ○		○ ○ ○			○ ○ ○	○ ○		
No.9	1.9 65.1 41 8 2.5 2	3	-	-	5910191	-	-	
No.6	2.8 47.9 44.5 9.5 2.8 2.24	3	5910280	5910281	5910282	5910283		
No.5	3.2 43.1 48 11 3.15 2.5	3	-	5910321	5910322	-		
No.3	4.1 34.8 53 13 4.5 3.55	3	5910410	-	-	5910413		
No.1	5.3 28.2 62 17 5.6 4.5	3	-	5910531	5910532	-		
No.0	6.0 25.4 66 19 6.3 5	3	-	5910601	-	5910603		

Not available once current stock is depleted



THREADING TOOLS



shaping your dreams

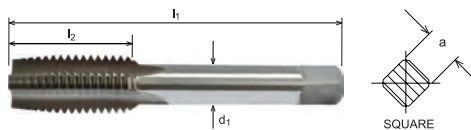
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Short Hand Taps

For general hand tapping.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	○						○	○	○												○	○									

Size	TPI	l ₁	l ₂	d ₁	a	No. of Flutes	Tap Set		Code		Price
							Code	Price	Taper	Bottom	
1/4	26	66	19	6.3	5	3	-	-	-	5950643	
7/16	26	85	25	8	6.3	4	-	-	5951111	-	
5/8	26	102	32	12.5	10	4	5951590	-	-	-	
1"	26	130	45	18	14	4	-	-	5952541	5952543	

Not available once current stock is depleted



Code
595

Properties		
BSB	ISO 529	HSS
	MEDIUM	STRAIGHT FLUTE

Circular Solid Dies

For production of components 3 x D in length.



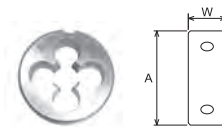
P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	○	○					○	○	○												○	○									

Size	Pitch	A	W	Code	Price	Size	Pitch	A	W	Code	Price
M1	0.25	16	5	5800100		M8	1.25	25	9	5800800	
M1.1	0.25	16	5	5800110		M9	1.25	25	9	5800900	
M1.2	0.25	16	5	5800120		M10	1.5	30	11	5801000	
M1.4	0.3	16	5	5800140		M11	1.5	30	11	5801100	
M1.6	0.35	16	5	5800160		M12	1.75	38	14	5801200	
M1.7	0.35	16	5	5800170		M14	2	38	14	5801400	
M1.8	0.35	16	5	5800180		M16	2	45	18	5801600	
M2	0.4	16	5	5800200		M18	2.5	45	18	5801800	
M2.2	0.45	16	5	5800220		M20	2.5	45	18	5802000	
M2.3	0.45	16	5	5800230		M22	2.5	55	22	5802200	
M2.5	0.45	16	5	5800250		M24	3	55	22	5802400	
M2.6	0.45	16	5	5800260		M27	3	65	25	5802700	
M3	0.5	20	5	5800300		M30	3.5	65	25	5803000	
M3.5	0.6	20	5	5800350		M33	3.5	65	25	5803300	
M4	0.7	20	5	5800400		M36	4	65	25	5803600	
M4.5	0.75	20	7	5800450		M39	4	75	30	5803900	
M5	0.8	20	7	5800500		M42	4.5	75	30	5804200	
M6	1	20	7	5800600		M45	4.5	90	36	5804500	
M7	1	20	7	5800700		M48	5	90	36	5804800	





Circular Solid Dies

For production of components 3 x D in length.



Code
582

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	○	○					○	○	○								○	○	○	○	○	○	○	○							

Properties		
MF	DIN 223	HSS
	DIN 13	6G
		

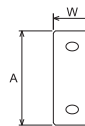
Size	Pitch	A	W	Code	Price
MF2.2	0.25	16	5	5820220	
MF2.3	0.25	16	5	5820230	
MF2.5	0.25	16	5	5820250	
MF2.6	0.25	16	5	5820259	
MF2.6	0.35	16	5	5820260	
MF3	0.35	20	5	5820300	
MF3.5	0.35	20	5	5820350	
MF4	0.35	20	5	5820390	
MF4	0.5	20	5	5820400	
MF5	0.5	20	5	5820500	
MF5	0.75	20	7	5820510	
MF6	0.5	20	5	5820600	
MF6	0.75	20	7	5820610	
MF7	0.75	25	9	5820700	
MF8	0.5	25	9	5820789	
MF8	0.75	25	9	5820790	
MF8	1	25	9	5820800	
MF9	0.75	25	9	5820890	
MF9	1	25	9	5820900	
MF10	0.5	30	11	5820989	
MF10	0.75	30	11	5820990	
MF10	1	30	11	5821000	
MF10	1.25	30	11	5821010	
MF11	1	30	11	5821110	
MF12	0.75	38	10	5821189	
MF12	1	38	10	5821190	
MF12	1.25	38	10	5821200	
MF12	1.5	38	10	5821210	
MF13	1	38	10	5821290	
MF13	1.5	38	10	5821300	
MF14	0.75	38	10	5821389	
MF14	1	38	10	5821390	
MF14	1.25	38	10	5821400	
MF14	1.5	38	10	5821410	
MF15	1	38	10	5821490	
MF15	1.5	38	10	5821500	
MF16	1	45	14	5821590	
MF16	1.5	45	14	5821600	
MF18	1	45	14	5821780	
MF18	1.5	45	14	5821800	
MF18	2	45	14	5821810	
MF20	1	45	14	5821990	
MF20	1.5	45	14	5822000	
MF20	2	45	14	5822010	
MF22	1	55	16	5822190	
MF22	1.5	55	16	5822200	

Size	Pitch	A	W	Code	Price
MF22	2	55	16	5822220	
MF24	1	55	16	5822390	
MF24	1.5	55	16	5822400	
MF24	2	55	16	5822410	
MF25	1	55	16	5822490	
MF25	1.5	55	16	5822500	
MF26	1.5	55	16	5822600	
MF27	1.5	65	18	5822700	
MF27	2	65	18	5822710	
MF28	1	65	18	5822790	
MF28	1.5	65	18	5822800	
MF28	2	65	18	5822810	
MF30	1	65	18	5822990	
MF30	1.5	65	18	5823000	
MF30	2	65	18	5823010	
MF32	1.5	65	18	5823190	
MF32	2	65	18	5823200	
MF33	1.5	65	18	5823290	
MF33	2	65	18	5823300	
MF34	1.5	65	18	5823400	
MF35	1.5	65	18	5823500	
MF36	1.5	65	18	5823590	
MF36	2	65	18	5823600	
MF36	3	65	25	5823610	
MF38	1.5	75	20	5823800	
MF39	1.5	75	20	5823890	
MF39	2	75	20	5823900	
MF39	3	75	20	5823910	
MF40	1.5	75	20	5823990	
MF40	2	75	20	5824000	
MF40	3	75	20	5824010	
MF42	1.5	75	20	5824190	
MF42	2	75	20	5824200	
MF42	3	75	20	5824210	
MF44	1.5	90	22	5824400	
MF45	1.5	90	22	5824490	
MF45	3	90	22	5824510	
MF48	1.5	90	22	5824790	
MF48	3	90	22	5824810	
MF50	1.5	90	22	5824990	
MF50	2	90	22	5825000	
MF50	3	90	22	5825010	
MF52	1.5	90	22	5825190	
MF52	2	90	22	5825200	
MF52	3	90	22	5825210	



Circular Solid Dies

For production of components 3 x D in length.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	○	○					○	○	○								○	○			○	○									

Size	TPI	A	W	Code	Price	Size	TPI	A	W	Code	Price
3/8	19	45	14	5870950		1.1/4	11	75	20	5873170	
5/8	14	55	16	5871590		1.3/8	11	90	22	5873493	
7/8	14	65	18	5872220		1.1/2	11	90	22	5873810	
1.1/8	11	75	20	5872858		1.3/4	11	90	22	5874445	

Not available once current stock is depleted



Code

587

Properties

BSP

DIN 223

HSS



ISO 228

MEDIUM CLASS BOLT



BEST SELLER

Die Nuts

For general purpose repairing or cleaning of threads.



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	○	○					○	○									○	○			○	○									

Size	Pitch	A	W	Code	Price	Size	Pitch	A	W	Code	Price
*M3	0.5	19	5	5070300		M14	2	36	14	5071400	
*M4	0.7	19	5	5070400		M16	2	41	18	5071600	
*M5	0.8	19	7	5070500		M18	2.5	41	18	5071800	
*M6	1	19	7	5070600		M20	2.5	41	18	5072000	
*M7	1	22	9	5070700		M22	2.5	50	22	5072200	
*M8	1.25	22	9	5070800		M24	3	50	22	5072400	
*M9	1.25	22	9	5070900		M27	3	60	25	5072700	
M10	1.5	27	11	5071000		M30	3.5	60	25	5073000	
M11	1.5	27	11	5071100		M33	3.5	60	25	5073300	
M12	1.75	36	14	5071200		M36	4	60	25	5073600	

* Not to DIN 382

Code

507

Properties

M

DIN 382

HSS



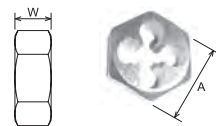
DIN 13

6G





Die Nuts

For general purpose repairing or cleaning of threads.



Code
577

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	○	○					○	○	○								○	○			○	○									

Properties		
MF	DIN 382	HSS
	DIN 13	6G
		

Size	Pitch	A	W	Code	Price	Size	Pitch	A	W	Code	Price
*MF3	0.35	19	5	5770300		MF18	1	41	14	5771780	
*MF4	0.5	19	5	5770400		MF18	1.5	41	14	5771800	
*MF6	0.75	19	7	5770610		MF18	2	41	14	5771810	
*MF8	0.75	22	9	5770790		MF20	1	41	14	5771990	
*MF8	1	22	9	5770800		MF20	1.5	41	14	5772000	
MF10	0.75	27	11	5770990		MF20	2	41	14	5772010	
MF10	1	27	11	5771000		MF22	1	50	16	5772190	
MF10	1.25	27	11	5771010		MF22	1.5	50	16	5772200	
MF12	1	36	10	5771190		MF24	1.5	50	16	5772400	
MF12	1.25	36	10	5771200		MF24	2	50	16	5772410	
MF12	1.5	36	10	5771210		MF25	1.5	50	16	5772500	
MF14	1	36	10	5771390		MF27	1.5	60	18	5772700	
MF14	1.25	36	10	5771400		MF30	1.5	60	18	5773000	
MF14	1.5	36	10	5771410		MF32	1.5	60	18	5773300	
MF16	1	41	14	5771590		MF33	1.5	60	18	5773310	
MF16	1.5	41	14	5771600		MF36	1.5	60	18	5773600	



* Not to DIN 382

Code
527

Die Nuts

For general purpose repairing or cleaning of threads.



Properties		
BSW	DIN 382	HSS
	BS 84	MEDIUM CLASS BOLT
		

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	○	○					○	○	○								○	○			○	○									

Size	TPI	A	W	Code	Price	Size	TPI	A	W	Code	Price
*1/8	40	19	5	5270320		3/4	10	41	18	5271910	
*3/16	24	19	7	5270480		7/8	9	50	22	5272220	
*1/4	20	19	7	5270640		1"	8	50	22	5272540	
*5/16	18	22	9	5270790		1.1/8	7	60	25	5272860	
3/8	16	27	11	5270950		1.1/4	7	60	25	5273170	
7/16	14	27	11	5271110		1.3/8	6	60	25	5273493	
1/2	12	36	14	5271270		1.1/2	6	70	30	5273810	
9/16	12	36	14	5271430		1.3/4	5	85	36	5274450	
5/8	11	41	18	5271590		2"	4.5	85	36	5275080	

* Not to DIN 382





OSG GROUP COMPANY

Die Nuts

For general purpose repairing or cleaning of threads.

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	○	○					○	○	○	○							○	○	○	○	○	○	○	○							

Size	TPI	A	W	Code	Price	Size	TPI	A	W	Code	Price
*1/4	26	19	7	5370640		3/4	12	41	18	5371910	
*5/16	22	22	9	5370790		7/8	11	50	22	5372220	
3/8	20	27	11	5370950		1"	10	50	22	5372540	
7/16	18	27	11	5371110		1.1/8	9	60	25	5372860	
1/2	16	36	14	5371270		1.1/4	9	60	25	5373180	
9/16	16	36	14	5371430		1.1/2	8	70	30	5373810	
5/8	14	41	18	5371590		2"	7	85	36	5375080	

* Not to DIN 382

Code

537

Properties

BSF

DIN 382

HSS



BS 84

MEDIUM CLASS BOLT



Die Nuts

For general purpose repairing or cleaning of threads.

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	○	○					○	○	○	○							○	○	○	○	○	○	○	○							

Size	TPI	A	W	Code	Price	Size	TPI	A	W	Code	Price
*1/4	20	19	7	5470640		3/4	10	41	18	5471910	
*5/16	18	22	9	5470790		7/8	9	50	22	5472220	
3/8	16	27	11	5470950		1"	8	50	22	5472540	
7/16	14	27	11	5471110		1.1/8	7	60	25	5472860	
1/2	13	36	14	5471270		1.1/4	7	60	25	5473180	
9/16	12	36	14	5471430		1.1/2	6	70	30	5473810	
5/8	11	41	18	5471590							

* Not to DIN 382

Code

547

Properties

UNC

DIN 382

HSS



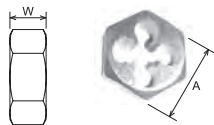
ANSI B1.1 1982

2A BOLT



Die Nuts

For general purpose repairing or cleaning of threads.





Code
557

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	○						○	○	○								○	○			○	○									

Size	TPI	A	W	Code	Price	Size	TPI	A	W	Code	Price
*1/4	28	19	7	5570640		3/4	16	41	14	5571910	
*5/16	24	22	9	5570790		7/8	14	50	16	5572220	
3/8	24	27	11	5570950		1"	12	50	16	5572540	
7/16	20	27	11	5571110		1.1/8	12	60	18	5572860	
1/2	20	36	10	5571270		1.1/4	12	60	18	5573180	
9/16	18	36	10	5571430		1.1/2	12	70	20	5573810	
5/8	18	41	14	5571590							

* Not to DIN 382

Properties		
UNF	DIN 382	HSS
	ANSI B1.1 1982	2A BOLT
		

Code
574



Die Nuts

For general purpose repairing or cleaning of threads.



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	○						○	○	○								○	○			○	○									

Size	On Nominal Diameter	TPI	A	W	Code	Price	Size	On Nominal Diameter	TPI	A	W	Code	Price
1/8	9.73	28	36	10	5740320		1"	33.25	11	60	18	5742540	
1/4	13.16	19	36	10	5740640		1.1/8	37.90	11	70	20	5742860	
3/8	16.66	19	41	14	5740950		1.1/4	41.91	11	70	20	5743170	
1/2	20.96	14	41	14	5741270		1.3/8	44.32	11	85	22	5743493	
5/8	22.91	14	50	16	5741590		1.1/2	47.80	11	85	22	5743810	
3/4	26.44	14	60	18	5741910		1.3/4	53.75	11	100	22	5744445	
7/8	30.20	14	60	18	5742220		2"	59.61	11	100	22	5745080	

Properties		
BSP	DIN 382	HSS
	ISO 228	MEDIUM CLASS BOLT
		



Adjustable Tap Wrenches

For direct application of hand taps.



Reference	Range			Code	Price
	mm	inch	Pipe		
Bar Type					
TW1 - No.0	2 - 6	1/16 - 1/4	-	5880001	
TW2 - No.1.5	3 - 12	1/8 - 1/2	1/8 - 1/2	5880002	
TW3 - No.2	3 - 12	1/8 - 1/2	1/8 - 1/4	5880007	
TW4 - No.3	6 - 20	1/4 - 3/4	1/8 - 3/8	5880008	
TW5 - No.4	12 - 27	1/2 - 1"	1/4 - 5/8	5880009	
TW6 - No.5	20 - 32	3/4 - 1.1/4	3/8 - 1"	5880010	
T-Type					
T1 - No.1 S	3 - 6	1/8 - 1/4	-	5880003	
T2 - No.2 S	8 - 12	5/16 - 1/2	1/8 - 1/4	5880004	
T-Type Long Reach					
TL3 - No.10 L	2 - 6	1/16 - 1/4	-	5880005	
TL4 - No.20 L	8 - 12	5/16 - 1/2	1/8 - 1/4	5880006	

Code

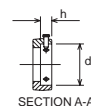
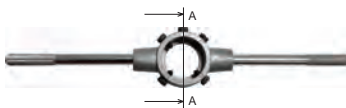
588

Properties

**DIN
1814**

Die Stocks

For direct application of circular solid dies - DIN 223 without capsule.



Reference	d	h	Code	Price	Reference	d	h	Code	Price
0	16	5	5890000		6A	45	14	5890060	
1	20	5	5890010		6	45	18	5890065	
2	20	7	5890020		7A	55	16	5890070	
3	25	9	5890030		7	55	22	5890075	
4	30	11	5890040		8A	65	18	5890080	
5A	38	10	5890050		8	65	25	5890085	
5	38	14	5890055		9A	75	20	5890090	

Code

589

Properties

**DIN
225**

Somta Tapping, Reaming and Drilling Fluid

For improving tool life and reducing tool wear.



Description	Code	Price
300ml	5AU0010	

Code

5AU





OSG GROUP COMPANY

NEW

MultiForce HSS-Co5 Jobber Drill and Tap Sets

For precision drilling and machine tapping in multiple materials.



Codes
MFS

Properties		
RAINBOW COATED	SEE APPROPRIATE CATALOGUE PAGE	

Description	Code	Price
Gun Nose Rainbow Coated Set	MFS-1J5SPR	
THIS SET CONTAINS: 4.2mm - MFD-1J-0420RA, 5.0mm - MFD-1J-0500RA, 6.8mm - MFD-1J-0680RA, 8.5mm - MFD-1J-0850RA, 10.2mm - MFD-1J-1020RA & M5 - MFT-5SP-0500RT, M6 - MFT-5SP-0600RT, M8 - MFT-5SP-0800RT, M10 - MFT-5SP-1000RT, M12 - MFT-5SP-1200RT		
Spiral Flute Rainbow Coated Set	MFS-1J5SFR	
THIS SET CONTAINS: 4.2mm - MFD-1J-0420RA, 5.0mm - MFD-1J-0500RA, 6.8mm - MFD-1J-0680RA, 8.5mm - MFD-1J-0850RA, 10.2mm - MFD-1J-1020RA & M5 - MFT-5SF-0500RT, M6 - MFT-5SF-0600RT, M8 - MFT-5SF-0800RT, M10 - MFT-5SF-1000RT, M12 - MFT-5SF-1200RT		

Codes
5BB 5G7 5R5

Properties		
CBA	SEE APPROPRIATE CATALOGUE PAGE	

Colour Band Jobber Drill and Gun Nose Tap Sets


For machine tapping of through holes in tough materials eg. Stainless Steel, carbon steels or high tensile materials eg. Tool Steel.



Description	Code	Price
Blue Band Drill and Tap Set	5BB0000	
THIS SET CONTAINS: 4.2mm - 1BB0420, 5.0mm - 1BB0500, 6.8mm - 1BB0680, 8.5mm - 1BB0850, 10.2mm - 1BB1020 & M5 - 5390500, M6 - 5390600, M8 - 5390800, M10 - 5391000, M12 - 5491200		
Green Band Drill and Tap Set	5G70000	
THIS SET CONTAINS: 4.2mm - 1G70420, 5.0mm - 1G70500, 6.8mm - 1G70680, 8.5mm - 1G70850, 10.2mm - 1G71020 & M5 - 5610500, M6 - 5610600, M8 - 5610800, M10 - 5611000, M12 - 5661200		
Red Band Drill and Tap Set	5R50000	
THIS SET CONTAINS: 4.2mm - 1R50420, 5.0mm - 1R50500, 6.8mm - 1R50680, 8.5mm - 1R50850, 10.2mm - 1R51020 & M5 - 5400500, M6 - 5400600, M8 - 5400800, M10 - 5401000, M12 - 5501200		

Not available once current stock is depleted

Code
598

Properties		
M	HSS	
SEE APPROPRIATE CATALOGUE PAGE		

Drill and Tap Sets in Metal Index Cases

For general hand tapping or machine tapping of through or blind holes.



Description	Code	Price
M3 - M12 Second Short Hand Taps	5980501	
M3 - M12 Gun Nose Machine Taps	5980503	
M3 - M12 Spiral Flute Machine Taps	5980504	
M3 - M12 Short Hand Tap Sets	5980506	
M3 - M12 Short Hand Tap Sets & 2.5, 3.3, 4.2, 5.0, 6.8, 8.5 and 10.2 mm Straight Shank Drills	5980511	

The above sets contain tap sizes M3, M4, M5, M6, M8, M10 and M12.



THREADING
TOOLS



shaping your dreams

250

JUNE 2023 V3 SOMTA CATALOGUE

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Tap & Die Cased Sets For general hand tapping.




OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

Description	Code	Price
1/8 - 1/2 BSW	5A10003	
THIS SET CONTAINS:		
Taps (Taper, Bottom): 1/8, 3/16, 1/4, 5/16, 3/8, 7/16, 1/2		
Dies: 1/8 x 13/16 O/D, 3/16 x 13/16 O/D, 1/4 x 13/16 O/D, 5/16 x 1" O/D, 3/8 x 1" O/D, 7/16 x 1" O/D, 1/2 x 1" O/D		
Tap Wrench: TW2, Die Stock: DS1, DS2		
3/16 - 1/2 BSF	5A10007	
THIS SET CONTAINS:		
Taps (Taper, Bottom): 3/16, 1/4, 5/16, 3/8, 7/16, 1/2		
Dies: 3/16 x 13/16 O/D, 1/4 x 13/16 O/D, 5/16 x 1" O/D, 3/8 x 1" O/D, 7/16 x 1" O/D, 1/2 x 1" O/D		
Tap Wrench: TW2, Die Stock: DS1, DS2		
1/4 - 1/2 UNC	5A10010	
THIS SET CONTAINS:		
Taps (Taper, Bottom): 1/4, 5/16, 3/8, 7/16, 1/2		
Dies: 1/4 x 1" O/D, 5/16 x 1" O/D, 3/8 x 1" O/D, 7/16 x 1" O/D, 1/2 x 1" O/D		
Tap Wrench: TW2, Die Stock: DS2		
1/4 - 1/2 UNF	5A10013	
THIS SET CONTAINS:		
Taps (Taper, Bottom): 1/4, 5/16, 3/8, 7/16, 1/2		
Dies: 1/4 x 1" O/D, 5/16 x 1" O/D, 3/8 x 1" O/D, 7/16 x 1" O/D, 1/2 x 1" O/D		
Tap Wrench: TW2, Die Stock: DS2		
M2 - M6	5A10016	
THIS SET CONTAINS:		
Taps (Taper, Bottom): 2 x 0.4, 3 x 0.5, 4 x 0.7, 5 x 0.8, 6 x 1		
Dies: 2 x 13/16 O/D, 3 x 13/16 O/D, 4 x 13/16 O/D, 5 x 13/16 O/D, 6 x 13/16 O/D		
Tap Wrench: TW1, Die Stock: DS1		
M2 - M12	5A10017	
THIS SET CONTAINS:		
Taps (Taper, Bottom): 2 x 0.4, 3 x 0.5, 4 x 0.7, 5 x 0.8, 6 x 1, 7 x 1, 8 x 1.25, 9 x 1.25, 10 x 1.5, 11 x 1.5, 12 x 1.75		
Dies: 2 x 13/16 O/D, 3 x 13/16 O/D, 4 x 13/16 O/D, 5 x 13/16 O/D, 6 x 13/16 O/D, 7 x 1" O/D, 8 x 1" O/D, 9 x 1" O/D, 10 x 1" O/D, 11 x 1" O/D, 12 x 1" O/D		
Tap Wrench: TW2, Die Stock: DS1, DS2		
M6 - M12	5A10019	
THIS SET CONTAINS:		
Taps (Taper, Bottom): 6 x 1, 7 x 1, 8 x 1.25, 9 x 1.25, 10 x 1.5, 11 x 1.5, 12 x 1.75		
Dies: 6 x 1" O/D, 7 x 1" O/D, 8 x 1" O/D, 9 x 1" O/D, 10 x 1" O/D, 11 x 1" O/D, 12 x 1" O/D		
Tap Wrench: TW2, Die Stock: DS2		
M6 - M24	5A10021	
THIS SET CONTAINS:		
Taps (Taper, Bottom): 6 x 1, 7 x 1, 8 x 1.25, 9 x 1.25, 10 x 1.5, 11 x 1.5, 12 x 1.75, 14 x 2, 16 x 2, 18 x 2.5, 20 x 2.5, 22 x 2.5, 24 x 3		
Dies: 6 x 1" O/D, 7 x 1" O/D, 8 x 1" O/D, 9 x 1" O/D, 10 x 1" O/D, 11 x 1.1/12 O/D, 12 x 1.1/12 O/D, 14 x 1.1/12 O/D, 16 x 1.1/12 O/D, 18 x 2" O/D, 20 x 2" O/D, 22 x 2" O/D, 24 x 2" O/D		
Tap Wrench: TW2, TW5, Die Stock: DS2, DS4, DS5		

Hexagonal Die Nut Case Sets available on request.

Code
5A1
Properties
HSS 

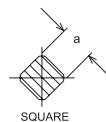
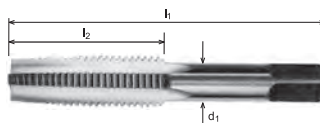




OSG GROUP COMPANY

Hi-Cut

Carbon Steel Short Hand Tap Sets
For general hand tapping (cleaning threads).



Code
901

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○									○	○													○	○									

Properties		
M	BS 949: 1951	CARBON STEEL TO ZONE 5
	STRAIGHT FLUTE	

Size	Pitch	l ₁	l ₂	d ₁	a	Code	Price
M2	0.4	42.9	9.5	3.3	2.7	9010200	
M3	0.5	47.6	14.3	3.3	2.7	9010300	
M4	0.7	54	19.1	4.2	3.4	9010400	
M5	0.8	60.3	22.2	5.4	4.2	9010500	
M6	1	63.5	25.4	6.1	4.8	9010600	
M7	1	63.5	25.4	7.2	5.6	9010700	
M8	1.25	69.9	28.6	8.2	6.3	9010800	
M9	1.25	74.6	31.8	9.1	7	9010900	
M10	1.5	74.6	31.8	10.3	7.8	9011000	
M11	1.5	80.2	36.5	8.2	6.1	9011100	
M12	1.75	85.7	42.1	9.3	7	9011200	
M14	2	91.3	42.1	10.9	8.2	9011400	
M16	2	96.8	46	12.2	9.1	9011600	
M18	2.5	102.4	46	13.8	10.3	9011800	
M20	2.5	108	50.8	15	11.2	9012000	
M22	2.5	119.1	56.4	17.7	13.3	9012200	
M24	3	124.6	56.4	19.3	14.5	9012400	
M27	3	130.2	63.5	20.3	15.2	9012700	
M30	3.5	138.1	65.1	22.8	17.1	9013000	
M33	3.5	146.1	65.1	25.9	19.5	9013300	
M36	4	154	76.2	28.1	21.1	9013600	



THREADING
TOOLS



shaping your dreams

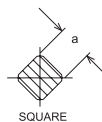
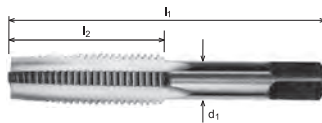
252

JUNE 2023 V3 SOMTA CATALOGUE

www.somta.co.za

Carbon Steel Short Hand Tap Sets

For general hand tapping (cleaning threads).



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○									○	○													○	○									

Size	Pitch	l ₁	l ₂	d ₁	a	Code	Price
MF4	0.5	54	19.1	4.2	3.4	9020390	
MF4	0.75	54	19.1	4.2	3.4	9020400	
MF5	0.9	60.3	22.2	5.4	4.2	9020500	
MF8	1	69.9	28.6	8.2	6.3	9020800	
*MF10	1	74.6	31.8	10.3	7.8	9021000	
MF10	1.25	74.6	31.8	10.3	7.8	9021010	
MF12	1	76.2	31.8	9.3	7	9021200	
*MF12	1.25	76.2	31.8	9.3	7	9021210	
MF12	1.5	76.2	31.8	9.3	7	9021220	
*MF14	1.25	76.2	31.8	10.9	8.2	9021400	
MF14	1.5	76.2	31.8	10.9	8.2	9021410	
#MF16	1.5	76.2	31.8	12.2	9.1	9021600	
*MF18	1.5	76.2	31.8	13.8	10.3	9021800	
#MF20	1.5	82.6	38.1	15	11.2	9022000	
*MF22	1.5	82.6	38.1	17.7	13.3	9022200	
MF24	1.5	82.6	38.1	19.3	14.5	9022400	

* Spark Plug
Conduit



Code

902

Properties

MF

BS 949: 1951
CARBON STEEL TO ZONE 5

60°

STRAIGHT FLUTE

□

□

□

□

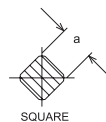
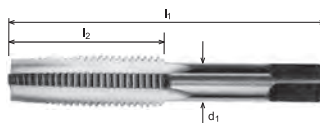




OSG GROUP COMPANY

Hi-Cut

Carbon Steel Short Hand Tap Sets
For general hand tapping (cleaning threads).



Code
903

P	M	K	Ti	Ni	Cu	N	Syn	H
1.1 1.2 1.3 1.4 1.5 1.6	2.1 2.2 2.3 2.4	3.1 3.2 3.3 3.4	4.1 4.2 4.3	5.1 5.2 5.3	6.1 6.2 6.3 6.4	7.1 7.2 7.3 7.4	8.1 8.2 8.3	9.1 9.2 9.3 9.4
○ ○		○ ○				○ ○		

Properties		
BSW	BS 949: 1951	CARBON STEEL TO ZONE 5
	STRAIGHT FLUTE	

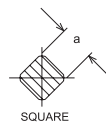
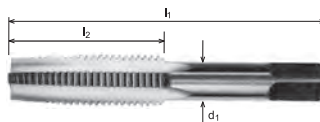
Size	TPI	l ₁	l ₂	d ₁	a	Code	Price
1/8	40	49.2	15.9	3.3	2.7	9030320	
5/32	32	54	19.1	4	3.1	9030400	
7/32	24	60.3	22.2	5.6	4.4	9030560	
1/4	20	63.5	25.4	6.4	5	9030640	
5/16	18	69.9	28.6	8	6.1	9030790	
3/8	16	74.6	31.8	9.6	7.5	9030950	
7/16	14	80.2	36.5	12.2	9.1	9031110	
1/2	12	85.7	42.1	15.2	11.2	9031270	
9/16	12	91.3	42.1	17.7	13.3	9031430	
5/8	11	96.8	46	20.3	15.2	9031590	
3/4	10	108	50.8	25.9	19.5	9031910	
7/8	9	119.1	56.4			9032220	
1"	8	130.2	63.5			9032540	
1.1/4	7	146.1	65.1			9033170	



Code
904

Hi-Cut

Carbon Steel Short Hand Tap Sets
For general hand tapping (cleaning threads).



Properties		
BSF	BS 949: 1951	CARBON STEEL TO ZONE 5
	STRAIGHT FLUTE	

P	M	K	Ti	Ni	Cu	N	Syn	H
1.1 1.2 1.3 1.4 1.5 1.6	2.1 2.2 2.3 2.4	3.1 3.2 3.3 3.4	4.1 4.2 4.3	5.1 5.2 5.3	6.1 6.2 6.3 6.4	7.1 7.2 7.3 7.4	8.1 8.2 8.3	9.1 9.2 9.3 9.4
○ ○		○ ○				○ ○		

Size	TPI	l ₁	l ₂	d ₁	a	Code	Price
5/16	22	69.9	28.6	8	6.1	9040790	

Not available once current stock is depleted



THREADING
TOOLS



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254

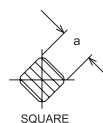
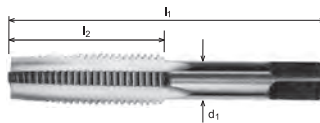
JUNE 2023 V3 SOMTA CATALOGUE

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Carbon Steel Short Hand Tap Sets

For general hand tapping (cleaning threads).



OSG GROUP COMPANY

P	M	K	Ti	Ni	Cu	N	Syn	H
1.1 1.2 1.3 1.4 1.5 1.6	2.1 2.2 2.3 2.4	3.1 3.2 3.3 3.4	4.1 4.2 4.3	5.1 5.2 5.3	6.1 6.2 6.3 6.4	7.1 7.2 7.3 7.4	8.1 8.2 8.3	9.1 9.2 9.3 9.4
○ ○		○ ○				○ ○		

Size	TPI	l ₁	l ₂	d ₁	a	Code	Price
1/4	20	63.5	25.4	6.5	4.9	9050640	
5/16	18	69.1	28.6	8.1	6	9050790	
3/8	16	74.6	31.8	9.7	7.3	9050950	
7/16	14	80.2	36.5	8.2	6.1	9051110	
1/2	13	85.7	42.1	9.3	7	9051270	
9/16	12	91.3	42.1	10.9	8.2	9051430	
5/8	11	96.8	46	12.2	9.1	9051590	
3/4	10	108	50.8	15	11.2	9051910	
7/8	9	119.1	56.4	17.7	13.3	9052220	
1"	8	130.2	63.5	20.3	15.2	9052540	



Code

905

Properties

UNC

BS 949: 1951

CARBON STEEL TO ZONE 5

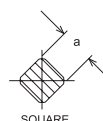
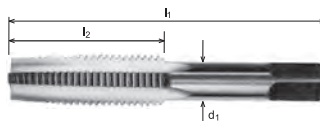


STRAIGHT FLUTE



Carbon Steel Short Hand Tap Sets

For general hand tapping (cleaning threads).



P	M	K	Ti	Ni	Cu	N	Syn	H
1.1 1.2 1.3 1.4 1.5 1.6	2.1 2.2 2.3 2.4	3.1 3.2 3.3 3.4	4.1 4.2 4.3	5.1 5.2 5.3	6.1 6.2 6.3 6.4	7.1 7.2 7.3 7.4	8.1 8.2 8.3	9.1 9.2 9.3 9.4
○ ○		○ ○				○ ○		

Size	TPI	l ₁	l ₂	d ₁	a	Code	Price
1/4	28	63.5	25.4	6.5	4.9	9060640	
5/16	24	69.1	28.6	8.1	6	9060790	
3/8	24	74.6	31.8	9.7	7.3	9060950	
7/16	20	80.2	36.5	8.2	6.1	9061110	
1/2	20	85.7	42.1	9.3	7	9061270	
9/16	18	91.3	42.1	10.9	8.2	9061430	
5/8	18	96.8	46	12.2	9.1	9061590	
3/4	16	108	50.8	15	11.2	9061910	
7/8	14	119.1	56.4	17.7	13.3	9062220	
1"	12	130.2	63.5	20.3	15.2	9062540	



Code

906

Properties

UNF

BS 949: 1951

CARBON STEEL TO ZONE 5



STRAIGHT FLUTE



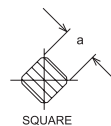
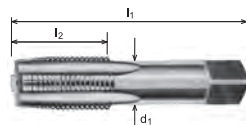


OSG GROUP COMPANY

Hi-Cut

Carbon Steel Parallel Pipe Tap Sets

For hand tapping of through or blind holes (cleaning threads).



P				M				K				Ti				Ni				Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○									○	○													○	○									

Size	Nominal Diameter	TPI	l ₁	l ₂	d ₁	a	Code	Price
1/8	9.728	28	54	19.1	8.1	6	9070320	
1/4	13.157	19	61.9	27	10.9	8.2	9070640	
3/8	16.662	19	65.1	27	13.8	10.3	9070950	
1/2	20.955	14	79.4	34.9	17.4	13.1	9071270	
5/8	22.911	14	81	34.9	20.3	15.2	9071590	
3/4	26.441	14	82.6	34.9	23	17.2	9071910	
1"	33.249	11	88.9	44.5	28.6	21.4	9072540	
1.1/2	47.803	11	108	44.5	38.1	28.6	9073810	
2"	59.614	11	114.3	44.5	47.6	35.7	9075080	

Code
907

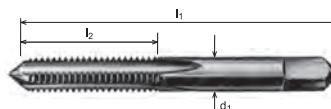
Properties		
BSP	BS 949: 1951	CARBON STEEL TO ZONE 5
	STRAIGHT FLUTE	



Hi-Cut

Carbon Steel Short Hand Tap Sets

For general hand tapping (cleaning threads).



P				M				K				Ti				Ni				Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○									○	○													○	○									

Size	Nominal Diameter	TPI	l ₁	l ₂	d ₁	a	Code	Price
No.5	3.2	43.1	49.2	15.9	3.3	2.7	9080500	
No.4	3.6	38.3	50.8	17.5	3.7	2.9	9080400	
No.3	4.1	34.8	54	19.1	4.2	3.4	9080300	
No.1	5.3	28.2	60.3	22.2	5.4	4.2	9080100	

Not available once current stock is depleted



THREADING TOOLS



shaping your dreams

256

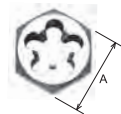
JUNE 2023 V3 SOMTA CATALOGUE

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Carbon Steel Die Nuts

For general purpose cleaning of threads.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○									○	○													○	○									

Size	Pitch	A	W	Code	Price	Size	Pitch	A	W	Code	Price
M4	0.7	18	5	9110400		M16	2	33	18	9111600	
M5	0.8	18	7	9110500		M18	2.5	37.6	18	9111800	
M6	1	18	7	9110600		M20	2.5	37.6	18	9112000	
M7	1	20.8	9	9110700		M22	2.5	42.4	22	9112200	
M8	1.25	20.8	9	9110800		M24	3	52.1	22	9112400	
M9	1.25	23.4	9	9110900		M27	3	56.4	25	9112700	
M10	1.5	23.4	11	9111000		M30	3.5	56.4	25	9113000	
M11	1.5	25.7	11	9111100		M33	3.5	65.5	25	9113300	
M12	1.75	27.9	14	9111200		M36	4	70.1	25	9113600	
M14	2	33	14	9111400		M39	4	70.1	30	9113900	

Code

911

Properties

M

BS
1127:
1974

CARBON
STEEL
CUT
THREAD



DIN
13

6G



Code

912

Properties

MF

BS
1127:
1974

CARBON
STEEL
CUT
THREAD



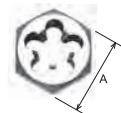
DIN
13

6G



Carbon Steel Die Nuts

For general purpose cleaning of threads.



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○									○	○													○	○									

Size	Pitch	A	W	Code	Price	Size	Pitch	A	W	Code	Price
MF8	1	20.8	9	9120800		MF14	1.5	33	10	9121410	
MF10	1	23.4	11	9121000		MF16	1.5	33	14	9121600	
MF10	1.25	23.4	11	9121010		MF18	1.5	37.6	14	9121800	
MF12	1.25	27.9	10	9121210		MF20	1.5	37.6	14	9122000	
MF12	1.5	27.9	10	9121220		MF22	1.5	42.4	16	9122200	
MF14	1.25	33	10	9121400		MF24	1.5	52.1	16	9122400	

Code

913

Properties

BSW

BS
1127:
1974

CARBON
STEEL
CUT
THREAD



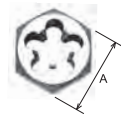
BS
84

MEDIUM
CLASS
BOLT



Carbon Steel Die Nuts

For general purpose cleaning of threads.



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○									○	○													○	○									

Size	TPI	A	W	Code	Price	Size	TPI	A	W	Code	Price
1/4	20	18	7	9130640		1.1/8	7	56.4	25	9132860	

Not available once current stock is depleted





OSG GROUP COMPANY

Hi-Cut

Carbon Steel Die Nuts

For general purpose cleaning of threads.



Code
914

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○									○	○													○	○									

Size	TPI	A	W	Code	Price	Size	TPI	A	W	Code	Price
1/2	16	27.9	11	9141270		1.1/8	9	56.4	25	9142860	

Not available once current stock is depleted

Properties		
BSF	BS 1127: 1974	CARBON STEEL CUT THREAD
	BS 84	MEDIUM CLASS BOLT

Code
915

Hi-Cut

Carbon Steel Die Nuts

For general purpose cleaning of threads.



Properties		
UNC	BS 1127: 1974	CARBON STEEL CUT THREAD
	ANSI B1.1 1982	2A BOLT

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○									○	○													○	○									

Size	TPI	A	W	Code	Price	Size	TPI	A	W	Code	Price
1.1/4	7	56.4	25	9153170		1.3/8	6	65.5	25	9153490	

Not available once current stock is depleted

Code
918

Hi-Cut

Carbon Steel Die Nuts

For general purpose cleaning of threads.



Properties		
BA	BS 1127: 1974	CARBON STEEL CUT THREAD
MEDIUM CLASS BOLT		

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○									○	○													○	○									

Size	TPI	A	W	Code	Price	Size	TPI	A	W	Code	Price
No. 0	25.4	18	6.4	9180000		No. 4	38.3	18	6.4	9180400	
No. 1	28.2	18	6.4	9180100		No. 6	47.9	18	6.4	9180600	
No. 3	34.8	18	6.4	9180300							

Not available once current stock is depleted



THREADING
TOOLS



shaping your dreams

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JUNE 2023 V3 SOMTA CATALOGUE

www.somta.co.za



Carbon Steel Tap & Die Cased Sets

For general hand tapping (cleaning threads).



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○									○	○													○	○									

Description	Ref. No.	Code	Price
M2 - M6	C111	9700111	
THIS SET CONTAINS:			
Taps (Taper, Bottom): 2 x 0.4, 3 x 0.5, 4 x 0.7, 5 x 0.8, 6 x 1			
Dies: 2 x 13/16 O/D, 3 x 13/16 O/D, 4 x 13/16 O/D, 5 x 13/16 O/D, 6 x 13/16 O/D			
Tap Wrench: TW1, Die Stock: DS1			
M2 - M12	C114	9700114	
THIS SET CONTAINS:			
Taps (Taper, Bottom): 2 x 0.4, 3 x 0.5, 4 x 0.7, 5 x 0.8, 6 x 1, 7 x 1, 8 x 1.25, 9 x 1.25, 10 x 1.5, 11 x 1.5, 12 x 1.75			
Dies: 2 x 13/16 O/D, 3 x 13/16 O/D, 4 x 13/16 O/D, 5 x 13/16 O/D, 6 x 13/16 O/D, 7 x 1" O/D, 8 x 1" O/D, 9 x 1" O/D, 10 x 1" O/D, 11 x 1" O/D, 12 x 1" O/D			
Tap Wrench: TW2, Die Stock: DS1, DS2			
M6 - M12	C118	9700118	
THIS SET CONTAINS:			
Taps (Taper, Bottom): 6 x 1, 7 x 1, 8 x 1.25, 9 x 1.25, 10 x 1.5, 11 x 1.5, 12 x 1.75			
Dies: 6 x 1" O/D, 7 x 1" O/D, 8 x 1" O/D, 9 x 1" O/D, 10 x 1" O/D, 11 x 1" O/D, 12 x 1" O/D			
Tap Wrench: TW2, Die Stock: DS2			
M6 - M24	C120	9700120	
THIS SET CONTAINS:			
Taps (Taper, Bottom): 6 x 1, 7 x 1, 8 x 1.25, 9 x 1.25, 10 x 1.5, 11 x 1.5, 12 x 1.75, 14 x 2, 16 x 2, 18 x 2.5, 20 x 2.5, 22 x 2.5, 24 x 3			
Dies: 6 x 1" O/D, 7 x 1" O/D, 8 x 1" O/D, 9 x 1" O/D, 10 x 1" O/D, 11 x 1.1/12 O/D, 12 x 1.1/12 O/D, 14 x 1.1/12 O/D, 16 x 1.1/12 O/D, 18 x 2" O/D, 20 x 2" O/D, 22 x 2" O/D, 24 x 2" O/D			
Tap Wrench: TW2, TW5, Die Stock: DS2, DS4, DS5			
MF6 - MF24	CT101F	9701011	
THIS SET CONTAINS:			
Taps (Taper, Bottom): 6 x 0.75, 8 x 1, 10 x 1.25, 12 x 1.5, 14 x 1.5, 16 x 1.5, 18 x 1.5, 20 x 1.5, 22 x 1.5, 24 x 1.5			
Dies: 6 x 1.5/16 O/D, 8 x 1.5/16 O/D, 10 x 1.5/16 O/D, 12 x 1.5/16 O/D, 14 x 1.5/16 O/D, 16 x 2" O/D, 18 x 2" O/D, 20 x 2" O/D, 22 x 2" O/D, 24 x 2" O/D			
Tap Wrench: TW3, TW5, Die Stock: DS3, DS5			
1/8 - 1/2 BSW	C31	9710031	
THIS SET CONTAINS:			
Taps (Taper, Bottom): 1/8, 3/16, 1/4, 5/16, 3/8, 7/16, 1/2			
Dies: 1/8 x 13/16 O/D, 3/16 x 13/16 O/D, 1/4 x 13/16 O/D, 5/16 x 1" O/D, 3/8 x 1" O/D, 7/16 x 1" O/D, 1/2 x 1" O/D			
Tap Wrench: TW2, Die Stock: DS1, DS2			
1/4 - 3/4 BSW	C37	9710037	
THIS SET CONTAINS:			
Taps (Taper, Bottom): 1/4, 5/16, 3/8, 7/16, 1/2, 5/8, 3/4			
Dies: 1/4 x 1" O/D, 5/16 x 1" O/D, 3/8 x 1" O/D, 7/16 x 1.1/2 O/D, 1/2 x 1.1/2 O/D, 5/8 x 1.1/2 O/D, 3/4 x 1.1/2 O/D			
Tap Wrench: TW4, Die Stock: DS2, DS4			

Continued on next page...

Codes
970 - 974

Properties
CARBON STEEL





Hi-Cut

Carbon Steel Tap & Die Cased Sets For general hand tapping (cleaning threads).

Codes

970 - 974

Properties

CARBON
STEEL


P				M				K				Ti				Ni				Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○									○	○													○	○									

Description	Ref. No.	Code	Price
... from previous page			
1/4 - 1" BSW	C39	9710039	
THIS SET CONTAINS:			
Taps (Taper, Bottom): 1/4, 5/16, 3/8, 7/16, 1/2, 5/8, 3/4, 7/8, 1"			
Dies: 1/4 x 1" O/D, 5/16 x 1" O/D, 3/8 x 1" O/D, 7/16 x 1.1/2 O/D, 1/2 x 1.1/2 O/D, 5/8 x 1.1/2 O/D, 3/4 x 2" O/D, 7/8 x 2" O/D, 1" x 2" O/D			
Tap Wrench: TW2, TW5, Die Stock: DS2, DS4, DS5			
1/4 - 1" UNC	C85	9730085	
THIS SET CONTAINS:			
Taps (Taper, Bottom): 1/4, 5/16, 3/8, 7/16, 1/2, 5/8, 3/4, 7/8, 1"			
Dies: 1/4 x 1" O/D, 5/16 x 1" O/D, 3/8 x 1" O/D, 7/16 x 1.1/2 O/D, 1/2 x 1.1/2 O/D, 5/8 x 1.1/2 O/D, 3/4 x 2" O/D, 7/8 x 2" O/D, 1" x 2" O/D			
Tap Wrench: TW2, TW5, Die Stock: DS2, DS4, DS5			
1/4 - 1" UNF	C95	9740095	
THIS SET CONTAINS:			
Taps (Taper, Bottom): 1/4, 5/16, 3/8, 7/16, 1/2, 5/8, 3/4, 7/8, 1"			
Dies: 1/4 x 1" O/D, 5/16 x 1" O/D, 3/8 x 1" O/D, 7/16 x 1.1/2 O/D, 1/2 x 1.1/2 O/D, 5/8 x 1.1/2 O/D, 3/4 x 2" O/D, 7/8 x 2" O/D, 1" x 2" O/D			
Tap Wrench: TW2, TW5, Die Stock: DS2, DS4, DS5			

Not available once current stock is depleted


THREADING
TOOLS


shaping your dreams

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JUNE 2023 V3 SOMTA CATALOGUE

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OSG GROUP COMPANY



shaping your dreams

H I G H P E R F O R M A N C E T H R E A D I N G

M-NRT

Threading | Forming taps | Metric

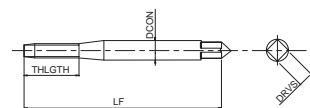


- Powder metal forming tap for through & blind holes
- TiN coating
- For general steel, stainless steels and aluminum

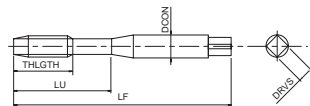
P	P	P	P	M	N	N	
C<0.2%	0.25<C<0.4	C>0.45%	SCM	INOX	AI	AC/DC	
20-30	20-30	15-30	10-20	6-12	10-25	15-40	m/min

M	PM	TiN	ISO 2 6HX	C/2,5			DIN 2174	DIN 2174
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Type 1



Type 2



Type 3



* Tolerance 4HX

EDP	TD	TP	LF	THLGTH	LU	DCON	DRVS	NOF	PHD	Type	DIN	Price
*OSG-11-EP0203111	1	0,25	40	5,5	-	2,5	2,1	3	0,89	1	DIN2174	
*OSG-11-EP0203115	1,4	0,3	40	7	-	2,5	2,1	3	1,27	1	DIN2174	
OSG-11-EP0203118	1,6	0,35	40	8	-	2,5	2,1	3	1,44	1	DIN2174	
OSG-11-EP0203125	2	0,4	45	9	-	2,8	2,1	3	1,82	1	DIN2174	
OSG-11-EP0203133	2,5	0,45	50	9	14	2,8	2,1	4	2,3	2	DIN2174	
OSG-11-EP0203138	3	0,5	56	10	18	3,5	2,7	4	2,8	2	DIN2174	
OSG-11-EP0203142	3,5	0,6	56	11	20	4	3	4	3,25	2	DIN2174	
OSG-11-EP0203144	4	0,7	63	12	21	4,5	3,4	4	3,7	2	DIN2174	
OSG-11-EP0203147	4,5	0,75	70	14	25	6	4,9	4	4,15	2	DIN2174	
OSG-11-EP0203149	5	0,8	70	14	25	6	4,9	5	4,65	2	DIN2174	
OSG-11-EP0203152	5,5	0,9	80	14	30	6	4,9	5	5,1	2	DIN2174	
OSG-11-EP0203155	6	1	80	16	30	6	4,9	5	5,55	2	DIN2174	
OSG-11-EP0203158	7	1	80	16	30	7	5,5	5	6,55	2	DIN2174	
OSG-11-EP0203161	8	1,25	90	18	35	8	6,2	5	7,45	2	DIN2174	
OSG-11-EP0203165	9	1,25	90	18	35	9	7	5	8,45	2	DIN2174	
OSG-11-EP0203169	10	1,5	100	20	39	10	8	5	9,35	2	DIN2174	
OSG-11-EP0203175	11	1,5	100	22	-	8	6,2	5	10,35	3	DIN2174	
OSG-11-EP0203179	12	1,75	110	24	-	9	7	5	11,2	3	DIN2174	
OSG-11-EP0203191	14	2	110	25	-	11	9	6	13,1	3	DIN2174	
OSG-11-EP0203202	16	2	110	27	-	12	9	6	15,1	3	DIN2174	
OSG-11-EP0203214	18	2,5	125	32	-	14	11	7	16,8	3	DIN2174	
OSG-11-EP0203228	20	2,5	140	32	-	16	12	7	18,8	3	DIN2174	
OSG-11-EP0203238	22	2,5	140	32	-	18	14,5	7	20,8	3	DIN2174	
OSG-11-EP0203247	24	3	160	36	-	18	14,5	7	22,6	3	DIN2174	

Available on request

HY-PRO SERIES & HYP-HP-SC / HYP-HPO-SC page 88-92



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JUNE 2023 V3 SOMTA CATALOGUE

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shaping your dreams

OSG GROUP COMPANY

High Performance Threading | Forming taps

M-NRT Metric

M-OIL-NRT

Threading | Forming taps | Metric



- Powder metal forming tap for through & blind holes
- TiN coating
- For general steel, stainless steels and aluminum
- With side through coolant

P	P	P	P	M	N	N
C < 0.2%	0.25 < C < 0.4	C > 0.45%	SCM	INOX	AI	AC/ADC
20-30	20-30	15-30	10-20	6-12	10-25	15-40

m/min

M	PM	TiN	ISO 2 6HX	C/2,5					DIN 2174	DIN 2174
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EDP	TD	TP	LF	THLGTH	LU	DCON	DRVS	NOF	PHD	Type	DIN	Price
OSG-11-EP0206149	5	0,8	70	14	25	6	4,9	5	4,65	1	DIN2174	
OSG-11-EP0206155	6	1	80	16	30	6	4,9	5	5,55	1	DIN2174	
OSG-11-EP0206161	8	1,25	90	18	35	8	6,2	5	7,45	1	DIN2174	
OSG-11-EP0206169	10	1,5	100	20	39	10	8	5	9,35	1	DIN2174	
OSG-11-EP0206179	12	1,75	110	24	-	9	7	5	11,2	2	DIN2174	
OSG-11-EP0206191	14	2	110	25	-	11	9	6	13,1	2	DIN2174	
OSG-11-EP0206202	16	2	110	27	-	12	9	6	15,1	2	DIN2174	
OSG-11-EP0206214	18	2,5	125	32	-	14	11	7	16,8	2	DIN2174	
OSG-11-EP0206228	20	2,5	140	32	-	16	12	7	18,8	2	DIN2174	
OSG-11-EP0206238	22	2,5	140	32	-	18	14,5	7	20,8	2	DIN2174	
OSG-11-EP0206247	24	3	160	36	-	18	14,5	7	22,6	2	DIN2174	

Available on request

M-NRT 6GX

Threading | Forming taps | Metric



- Powder metal forming tap for through & blind holes
- TiN coating
- For general steel, stainless steels and aluminum
- For 6G internal thread tolerance

P	P	P	P	M	N	N
C < 0.2%	0.25 < C < 0.4	C > 0.45%	SCM	INOX	AI	AC/ADC
20-30	20-30	15-30	10-20	6-12	10-25	15-40

m/min

M	PM	TiN	ISO 3 6GX	C/2,5				DIN 2174
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EDP	TD	TP	oversize	LF	THLGTH	LU	DCON	DRVS	NOF	PHD	Type	DIN	Price
OSG-11-EP0204125	2	0,4	0,019	45	9	-	2,8	2,1	3	1,82	1	DIN2174	
OSG-11-EP0204133	2,5	0,45	0,020	50	9	14	2,8	2,1	4	2,3	2	DIN2174	
OSG-11-EP0204138	3	0,5	0,020	56	10	18	3,5	2,7	4	2,8	2	DIN2174	
OSG-11-EP0204142	3,5	0,6	0,021	56	11	20	4	3	4	3,25	2	DIN2174	
OSG-11-EP0204144	4	0,7	0,022	63	12	21	4,5	3,4	4	3,7	2	DIN2174	
OSG-11-EP0204149	5	0,8	0,024	70	14	25	6	4,9	5	4,65	2	DIN2174	
OSG-11-EP0204155	6	1	0,026	80	16	30	6	4,9	5	5,55	2	DIN2174	
OSG-11-EP0204161	8	1,25	0,028	90	18	35	8	6,2	5	7,45	2	DIN2174	
OSG-11-EP0204169	10	1,5	0,032	100	20	39	10	8	5	9,35	2	DIN2174	
OSG-11-EP0204179	12	1,75	0,034	110	24	-	9	7	5	11,2	3	DIN2174	
OSG-11-EP0204191	14	2	0,038	110	25	-	11	9	6	13,1	3	DIN2174	
OSG-11-EP0204202	16	2	0,038	110	27	-	12	9	6	15,1	3	DIN2174	

Available on request

High Performance Threading | Forming taps

M-OIL-NRT / M-NRT 6GX Metric

M-NRT FORM E

Threading | Forming taps | Metric



- Powder metal forming tap for through & blind holes
- TiN coating
- For general steel, stainless steels and aluminum
- Chamfer Form E

P	P	P	P	M	N	N	
C<0,2%	0,25<C<0,4	C>0,45%	SCM	INOX	Al	ACADC	
20-30	20-30	15-30	10-20	6-12	10-25	15-40	m/min
M	PM	TiN	ISO 2 6HX	E/1,5			
					DIN 2174	DIN 2174	

EDP	TD	TP	LF	THLGTH	LU	DCON	DRVS	NOF	PHD	Type	DIN	Price
OSG-11-EP0205125	2	0,4	45	9	-	2,8	2,1	3	1,82	1	DIN2174	
OSG-11-EP0205133	2,5	0,45	50	9	14	2,8	2,1	4	2,3	2	DIN2174	
OSG-11-EP0205138	3	0,5	56	10	18	3,5	2,7	4	2,8	2	DIN2174	
OSG-11-EP0205142	3,5	0,6	56	11	20	4	3	4	3,25	2	DIN2174	
OSG-11-EP0205144	4	0,7	63	12	21	4,5	3,4	4	3,7	2	DIN2174	
OSG-11-EP0205149	5	0,8	70	14	25	6	4,9	5	4,65	2	DIN2174	
OSG-11-EP0205155	6	1	80	16	30	6	4,9	5	5,55	2	DIN2174	
OSG-11-EP0205161	8	1,25	90	18	35	8	6,2	5	7,45	2	DIN2174	
OSG-11-EP0205169	10	1,5	100	20	39	10	8	5	9,35	2	DIN2174	
OSG-11-EP0205179	12	1,75	110	24	-	9	7	5	11,2	3	DIN2174	
OSG-11-EP0205191	14	2	110	25	-	11	9	6	13,1	3	DIN2174	
OSG-11-EP0205202	16	2	110	27	-	12	9	6	15,1	3	DIN2174	

Available on request

M-OIL-NRT FORM E

Threading | Forming taps | Metric



- Powder metal forming tap for blind holes
- TiN coating
- For general steel, stainless steels and aluminum
- Chamfer Form E, center through coolant

P	P	P	P	M	N	N	
C<0,2%	0,25<C<0,4	C>0,45%	SCM	INOX	Al	ACADC	
20-30	20-30	15-30	10-20	6-12	10-25	15-40	m/min
M	PM	TiN	ISO 2 6HX	E/1,5			
					DIN 2174	DIN 2174	

EDP	TD	TP	LF	THLGTH	LU	DCON	DRVS	NOF	PHD	Type	DIN	Price
OSG-11-EP0207149	5	0,8	70	14	25	6	4,9	5	4,65	1	DIN2174	
OSG-11-EP0207155	6	1	80	16	30	6	4,9	5	5,55	1	DIN2174	
OSG-11-EP0207161	8	1,25	90	18	35	8	6,2	5	7,45	1	DIN2174	
OSG-11-EP0207169	10	1,5	100	20	39	10	8	5	9,35	1	DIN2174	
OSG-11-EP0207179	12	1,75	110	24	-	9	7	5	11,2	2	DIN2174	
OSG-11-EP0207191	14	2	110	25	-	11	9	6	13,1	2	DIN2174	
OSG-11-EP0207202	16	2	110	27	-	12	9	6	15,1	2	DIN2174	

Available on request



M-NRT

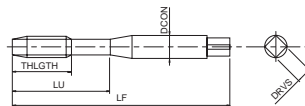
Threading | Forming taps | Metric Fine



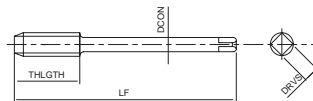
- Powder metal forming tap for through & blind holes
- TiN coating
- For general steel, stainless steels and aluminum

P	P	P	P	M	N	N	
C < 0.2%	0.25 < C < 0.4	C > 0.45%	SCM	INOX	AI	AC/ADC	
20-30	20-30	15-30	10-20	6-12	10-25	15-40	m/min
MF	PM	TiN	ISO 2 6HX	C/2,5			DIN 2174

Type 1



Type 2



EDP	TD	TP	LF	THLGTH	LU	DCON	DRVS	NOF	PHD	Type	DIN	Price
OSG-11-EP0203145	4	0,5	63	8	21	4,5	3,4	4	3,8	1	DIN2174	
OSG-11-EP0203151	5	0,5	70	9	25	6	4,9	5	4,8	1	DIN2174	
OSG-11-EP0203157	6	0,5	80	10	30	6	4,9	5	5,8	1	DIN2174	
OSG-11-EP0203156	6	0,75	80	14	30	6	4,9	5	5,65	1	DIN2174	
OSG-11-EP0203160	7	0,75	80	14	30	7	5,5	5	6,65	1	DIN2174	
OSG-11-EP0203164	8	0,5	80	10	35	8	6,2	5	7,775	1	DIN2174	
OSG-11-EP0203163	8	0,75	80	14	35	8	6,2	5	7,65	1	DIN2174	
OSG-11-EP0203162	8	1	90	18	35	8	6,2	5	7,55	1	DIN2174	
OSG-11-EP0203171	10	1	90	18	39	10	8	5	9,55	1	DIN2174	
OSG-11-EP0203170	10	1,25	100	20	39	10	8	5	9,45	1	DIN2174	
OSG-11-EP0203182	12	1	100	22	-	9	7	5	11,55	2	DIN2174	
OSG-11-EP0203181	12	1,25	100	22	-	9	7	5	11,45	2	DIN2174	
OSG-11-EP0203180	12	1,5	100	22	-	9	7	5	11,35	2	DIN2174	
OSG-11-EP0203194	14	1	100	22	-	11	9	6	13,55	2	DIN2174	
OSG-11-EP0203193	14	1,25	100	22	-	11	9	6	13,45	2	DIN2174	
OSG-11-EP0203192	14	1,5	100	22	-	11	9	6	13,35	2	DIN2174	
OSG-11-EP0203204	16	1	100	20	-	12	9	6	15,55	2	DIN2174	
OSG-11-EP0203203	16	1,5	100	20	-	12	9	6	15,35	2	DIN2174	
OSG-11-EP0203218	18	1	110	25	-	14	11	7	17,55	2	DIN2174	
OSG-11-EP0203216	18	1,5	110	25	-	14	11	7	17,35	2	DIN2174	
OSG-11-EP0203232	20	1	125	25	-	16	12	7	19,55	2	DIN2174	
OSG-11-EP0203230	20	1,5	125	25	-	16	12	7	19,35	2	DIN2174	
OSG-11-EP0203240	22	1,5	125	25	-	18	14,5	7	21,35	2	DIN2174	
OSG-11-EP0203250	24	1,5	140	28	-	18	14,5	7	23,35	2	DIN2174	

Available on request

M-NRT

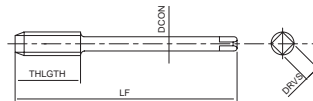
Threading | Forming taps | G (BSP)



- Powder metal forming tap for through & blind holes
- TiN coating
- For general steel, stainless steels and aluminum

P	P	P	P	M	N	N	
C < 0.2%	0.25 < C < 0.4	C > 0.45%	SCM	INOX	AI	AC/ADC	
20-30	20-30	15-30	10-20	6-12	10-25	15-40	m/min
G	PM	TiN	C/2,5				DIN 2189

Type 1



EDP	TD	TP	LF	THLGTH	DCON	DRVS	NOF	PHD	Type	DIN	Price
OSG-11-EP0203838	1/8	28	90	18	7	5,5	5	9,25	1	DIN2189	
OSG-11-EP0203839	1/4	19	100	22	11	9	6	12,5	1	DIN2189	
OSG-11-EP0203840	3/8	19	100	22	12	9	6	16	1	DIN2189	
OSG-11-EP0203841	1/2	14	125	25	16	12	7	20	1	DIN2189	
OSG-11-EP0203842	5/8	14	125	25	18	14,5	7	22	1	DIN2189	
OSG-11-EP0203843	3/4	14	140	28	20	16	8	25,5	1	DIN2189	

Available on request

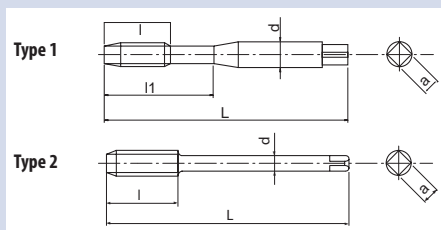
A-XPF

Threading | Forming taps | Metric



- First choice in quality and performance
- Powder metal forming tap for through & blind holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels
- Powder metal for long tool life

P	P	P	P	M	N	N	H
C<0,2%	0,25<C<0,4	C>0,45%	SCM	INOX	AI	AC,ADC	25-35 HRC
15-40	15-40	15-30	15-30	8-20	20-50	20-40	5-20



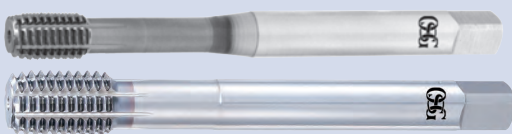
A	M	PM	V	ISO 2 6HX	C/2,5	DIN 2174	DIN 2174
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EDP	M	P	L	I	l1	d	a	Z	Ø	Type	DIN	Price
OSG-11-48133138	3	0,5	56	-	18	3,5	2,7	4	2,77~2,82	1	DIN2174	
OSG-11-48133144	4	0,7	63	-	21	4,5	3,4	4	3,66~3,72	1	DIN2174	
OSG-11-48133149	5	0,8	70	-	25	6	4,9	5	4,62~4,68	1	DIN2174	
OSG-11-48133155	6	1	80	-	30	6	4,9	5	5,51~5,59	1	DIN2174	
OSG-11-48133161	8	1,25	90	-	35	8	6,2	5	7,37~7,45	1	DIN2174	
OSG-11-48133169	10	1,5	100	-	39	10	8	8	9,24~9,33	1	DIN2174	
OSG-11-48133179	12	1,75	110	17	-	9	7	8	11,10~11,20	2	DIN2174	
OSG-11-48133191	14	2	110	20	-	11	9	8	12,96~13,08	2	DIN2174	
OSG-11-48133202	16	2	110	20	-	12	9	8	14,96~15,08	2	DIN2174	
OSG-11-48133214	18	2,5	125	20	-	14	11	8	16,66~16,81	2	DIN2174	
OSG-11-48133228	20	2,5	140	20	-	16	12	8	18,66~18,81	2	DIN2174	
OSG-11-48133238	22	2,5	140	20	-	18	14,5	8	20,66~20,81	2	DIN2174	
OSG-11-48133247	24	3	160	24	-	18	14,5	8	22,39~22,56	2	DIN2174	
OSG-11-48133262	27	3	160	18	-	20	16	8	25,39~25,56	2	DIN2174	
OSG-11-48133271	30	3,5	180	21	-	22	18	8	28,09~28,68	2	DIN2174	

Available on request

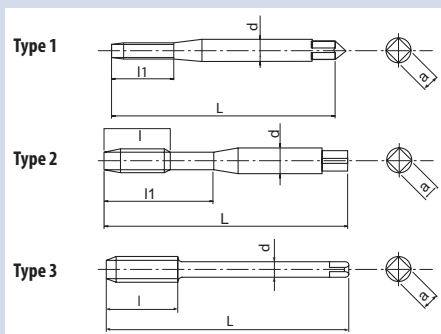
S-XPF

Threading | Forming taps | Metric



- First choice in quality and performance
- HSSE forming tap for through & blind holes
- Multilayer TiCN coating
- For general steels, stainless steels, aluminium

P	P	P	P	M	N	N	H
C<0,2%	0,25<C<0,4	C>0,45%	SCM	INOX	AI	AC,ADC	25-35 HRC
15-40	15-40	15-30	15-30	8-20	20-50	20-40	5-20



A	M	HSS-Co	V	ISO 2 6HX	C/2,5	DIN 2174	DIN 2174
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* Tolerance 4HX

EDP	M	P	L	I	l1	d	a	Z	Ø	Type	DIN	Price
*OSG-11-48030111	1	0,25	40	-	5,5	2,5	2,1	4	0,89 ~ 0,90	1	DIN2174	
*OSG-11-48030112	1,1	0,25	40	-	5,5	2,5	2,1	4	0,99 ~ 1,00	1	DIN2174	
*OSG-11-48030113	1,2	0,25	40	-	5,5	2,5	2,1	4	1,09 ~ 1,10	1	DIN2174	
*OSG-11-48030115	1,4	0,3	40	-	7	2,5	2,1	4	1,26 ~ 1,28	1	DIN2174	

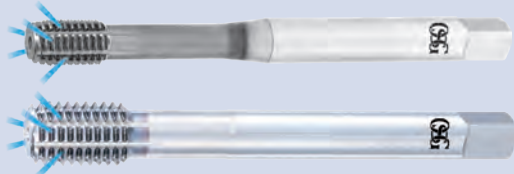


EDP	M	P	L	I	l1	d	a	Z	ϕ	Type	DIN	Price
OSG-11-48030118	1,6	0,35	40	-	8	2,5	2,1	4	1,45 ~ 1,48	1	DIN2174	
OSG-11-48030119	1,7	0,35	40	-	8	2,5	2,1	4	1,55 ~ 1,58	1	DIN2174	
OSG-11-48030120	1,8	0,35	40	-	8	2,5	2,1	4	1,65 ~ 1,68	1	DIN2174	
OSG-11-48030125	2	0,4	45	-	8	2,8	2,1	4	1,82 ~ 1,85	1	DIN2174	
OSG-11-48030127	2,2	0,45	45	-	9	2,8	2,1	4	2,00 ~ 2,04	1	DIN2174	
OSG-11-48030128	2,3	0,4	45	-	9	2,8	2,1	4	2,12 ~ 2,15	1	DIN2174	
OSG-11-48030133	2,5	0,45	50	-	9	2,8	2,1	4	2,30 ~ 2,34	1	DIN2174	
OSG-11-48030136	2,6	0,45	50	-	9	2,8	2,1	4	2,40 ~ 2,44	1	DIN2174	
OSG-11-48030138	3	0,5	56	-	18	3,5	2,7	4	2,77 ~ 2,82	2	DIN2174	
OSG-11-48030142	3,5	0,6	56	-	20	4	3	4	3,23 ~ 3,28	2	DIN2174	
OSG-11-48030144	4	0,7	63	-	21	4,5	3,4	4	3,67 ~ 3,72	2	DIN2174	
OSG-11-48030147	4,5	0,75	70	-	25	6	4,9	5	4,14 ~ 4,20	2	DIN2174	
OSG-11-48030149	5	0,8	70	-	25	6	4,9	5	4,62 ~ 4,68	2	DIN2174	
OSG-11-48030152	5,5	0,9	80	-	30	6	4,9	5	5,06 ~ 5,13	2	DIN2174	
OSG-11-48030155	6	1	80	-	30	6	4,9	5	5,51 ~ 5,59	2	DIN2174	
OSG-11-48030158	7	1	80	-	30	7	5,5	5	6,51 ~ 6,59	2	DIN2174	
OSG-11-48030161	8	1,25	90	-	35	8	6,2	5	7,37 ~ 7,45	2	DIN2174	
OSG-11-48030165	9	1,25	90	12	35	9	7	8	8,37 ~ 8,45	2	DIN2174	
OSG-11-48030169	10	1,5	100	-	39	10	8	8	9,24 ~ 9,33	2	DIN2174	
OSG-11-48030175	11	1,5	100	15	-	8	6,2	8	10,24 ~ 10,33	2	DIN2174	
OSG-11-48030179	12	1,75	110	17	-	9	7	8	11,10 ~ 11,20	3	DIN2174	
OSG-11-48030191	14	2	110	20	-	11	9	8	12,96 ~ 13,08	3	DIN2174	
OSG-11-48030202	16	2	110	20	-	12	9	8	14,96 ~ 15,08	3	DIN2174	
OSG-11-48069214	18	2,5	125	20	-	14	11	8	16,66 ~ 16,81	3	DIN2174	
OSG-11-48069228	20	2,5	140	20	-	16	12	8	18,66 ~ 18,81	3	DIN2174	
OSG-11-48069238	22	2,5	140	20	-	18	14,5	8	20,66 ~ 20,81	3	DIN2174	
OSG-11-48069247	24	3	160	24	-	18	14,5	8	22,39 ~ 22,56	3	DIN2174	
OSG-11-48069262	27	3	160	18	-	20	16	8	25,39 ~ 25,56	3	DIN2174	
OSG-11-48069271	30	3,5	180	21	-	22	18	8	28,09 ~ 28,28	3	DIN2174	

Available on request

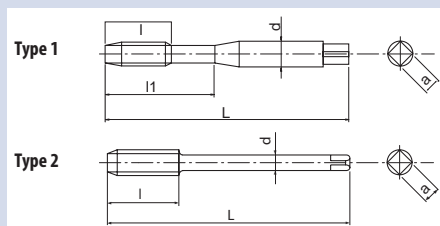
A-OIL-XPF

Threading | Forming taps | Metric



- First choice in quality and performance
- Powder metal forming tap for through & blind holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels
- Side through coolant

P	P	P	P	M	N	N	H
C<0,2%	0,25<C<0,4	C<0,45%	SCM	INOX	Al	AC,ADC	25-35 HRC
15-40	15-40	15-30	15-30	8-20	20-50	20-40	5-20



A	M	PM	V	ISO 2 6HX	C/2,5	DIN 2174	DIN 2174
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EDP	M	P	L	I	l1	d	a	Z	ϕ	Type	DIN	Price
OSG-11-48225149	5	0,8	70	-	25	6	4,9	5	4,62 ~ 4,68	1	DIN2174	
OSG-11-48225155	6	1	80	-	30	6	4,9	5	5,51 ~ 5,59	1	DIN2174	
OSG-11-48225161	8	1,25	90	-	35	8	6,2	5	7,37 ~ 7,45	1	DIN2174	
OSG-11-48225169	10	1,5	100	-	39	10	8	8	9,24 ~ 9,33	1	DIN2174	
OSG-11-48225179	12	1,75	110	17	-	9	7	8	11,10 ~ 11,20	2	DIN2174	
OSG-11-48225191	14	2	110	20	-	11	9	8	12,96 ~ 13,08	2	DIN2174	
OSG-11-48225202	16	2	110	20	-	12	9	8	14,96 ~ 15,08	2	DIN2174	
OSG-11-48225214	18	2,5	125	20	-	14	11	8	16,66 ~ 16,81	2	DIN2174	
OSG-11-48225228	20	2,5	140	20	-	16	12	8	18,66 ~ 18,81	2	DIN2174	
OSG-11-48225238	22	2,5	140	20	-	18	14,5	8	20,66 ~ 20,81	2	DIN2174	
OSG-11-48225247	24	3	160	24	-	18	14,5	8	22,39 ~ 22,56	2	DIN2174	
OSG-11-48225262	27	3	160	18	-	20	16	8	25,39 ~ 25,56	2	DIN2174	
OSG-11-48225271	30	3,5	180	21	-	22	18	8	28,09 ~ 28,28	2	DIN2174	
OSG-11-48225281	33	3,5	180	21	-	25	20	8	31,09 ~ 31,28	2	DIN2174	
OSG-11-48225294	36	4	200	32	-	28	22	8	33,80 ~ 34,01	2	DIN2174	
OSG-11-48225304	39	4	200	32	-	32	24	9	36,80 ~ 37,01	2	DIN2174	
OSG-11-48225314	42	4,5	200	36	-	32	24	9	39,52 ~ 39,73	2	DIN2174	
OSG-11-48225319	45	4,5	220	36	-	36	29	9	42,52 ~ 42,73	2	DIN2174	

Available on request

S-OIL-XPF

Threading | Forming taps | Metric



- First choice in quality and performance
- HSSE forming tap for through & blind holes
- Multilayer TiCN coating
- For general steels, stainless steels, aluminium
- Side through coolant

P	P	P	P	M	N	N	H
C<0,2%	0,25<C<0,4	C>0,45%	SCM	INOX	Al	AC,ADC	25-35 HRC

15-40 15-40 15-30 15-30 8-20 20-50 20-40 5-20 m/min

A	M	HSS-Co	V	ISO 2 6HX	C/2,5	DIN 2174	DIN 2174
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EDP	M	P	L	I	l1	d	a	Z	Ø	Type	DIN	Price
OSG-11-48042149	5	0,8	70	-	25	6	4,9	5	4,62 ~ 4,68	1	DIN2174	
OSG-11-48042155	6	1	80	-	30	6	4,9	5	5,51 ~ 5,59	1	DIN2174	
OSG-11-48042161	8	1,25	90	-	35	8	6,2	5	7,37 ~ 7,45	1	DIN2174	
OSG-11-48042169	10	1,5	100	-	39	10	8	8	9,24 ~ 9,33	1	DIN2174	
OSG-11-48042179	12	1,75	110	17	-	9	7	8	11,10 ~ 11,20	2	DIN2174	
OSG-11-48042191	14	2	110	20	-	11	9	8	12,96 ~ 13,08	2	DIN2174	
OSG-11-48042202	16	2	110	20	-	12	9	8	14,96 ~ 15,08	2	DIN2174	
OSG-11-48071214	18	2,5	125	20	-	14	11	8	16,66 ~ 16,81	2	DIN2174	
OSG-11-48071228	20	2,5	140	20	-	16	12	8	18,66 ~ 18,81	2	DIN2174	
OSG-11-48071238	22	2,5	140	20	-	18	14,5	8	20,66 ~ 20,81	2	DIN2174	
OSG-11-48071247	24	3	160	24	-	18	14,5	8	22,39 ~ 22,56	2	DIN2174	
OSG-11-48071262	27	3	160	18	-	20	16	8	25,39 ~ 25,56	2	DIN2174	
OSG-11-48071271	30	3,5	180	21	-	22	18	8	28,09 ~ 28,28	2	DIN2174	
OSG-11-48071281	33	3,5	180	21	-	25	20	8	31,09 ~ 31,28	2	DIN2174	
OSG-11-48071294	36	4	200	24	-	28	22	8	33,80 ~ 34,01	2	DIN2174	
OSG-11-48071304	39	4	200	24	-	32	24	9	36,80 ~ 37,01	2	DIN2174	
OSG-11-48071314	42	4,5	200	27	-	32	24	9	39,52 ~ 39,73	2	DIN2174	
OSG-11-48071319	45	4,5	220	27	-	36	29	9	42,52 ~ 42,73	2	DIN2174	

Available on request

A-XPF

Threading | Forming taps | Metric Fine



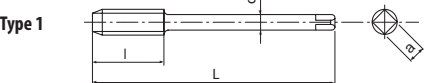
- First choice in quality and performance
- Powder metal forming tap for through & blind holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels
- Powder metal for long tool life

P	P	P	P	M	N	N	H
C<0,2%	0,25<C<0,4	C>0,45%	SCM	INOX	Al	AC,ADC	25-35 HRC

15-40 15-40 15-30 15-30 8-20 20-50 20-40 5-20 m/min

A	MF	PM	V	ISO 2 6HX	C/2,5	DIN 2174
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EDP	MF	P	L	I	d	a	Z	Ø	Type	DIN	Price
OSG-11-48133162	8	1	90	10	6	4,9	5	7,51 ~ 7,59	1	DIN2174	



EDP	MF	P	L	I	d	a	Z	\varnothing	Type	DIN	Price
OSG-11-48133171	10	1	90	12	7	5,5	8	9,51 ~ 9,59	1	DIN2174	
OSG-11-48133170	10	1,25	100	12	7	5,5	8	9,37 ~ 9,45	1	DIN2174	
OSG-11-48133182	12	1	100	15	9	7	8	11,52 ~ 11,60	1	DIN2174	
OSG-11-48133181	12	1,25	100	15	9	7	8	11,39 ~ 11,46	1	DIN2174	
OSG-11-48133180	12	1,5	100	15	9	7	8	11,25 ~ 11,34	1	DIN2174	
OSG-11-48133193	14	1,25	100	12	11	9	8	13,39 ~ 13,46	1	DIN2174	
OSG-11-48133192	14	1,5	100	15	11	9	8	13,25 ~ 13,34	1	DIN2174	
OSG-11-48133203	16	1,5	100	15	12	9	8	15,25 ~ 15,34	1	DIN2174	
OSG-11-48133216	18	1,5	110	15	14	11	8	17,25 ~ 17,34	1	DIN2174	
OSG-11-48133230	20	1,5	125	15	16	12	8	19,25 ~ 19,34	1	DIN2174	
OSG-11-48133240	22	1,5	125	15	18	14,5	8	21,25 ~ 21,34	1	DIN2174	
OSG-11-48133250	24	1,5	140	15	18	14,5	8	23,25 ~ 23,34	1	DIN2174	

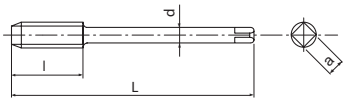
Available on request

S-XPF

Threading | Forming taps | Metric Fine



Type 1



- First choice in quality and performance
- HSSE forming tap for through & blind holes
- Multilayer TiCN coating
- For general steels, stainless steels, aluminium

P	P	P	P	M	N	N	H		
C < 0,2%	0,25 < C < 0,4	C > 0,45%	SM	INOX	AI	AC, ADC	25-35 HRC		
15-40	15-40	15-30	15-30	8-20	20-50	20-40	5-20	m/min	
A	MF	HSS-Co	V	ISO 2 6HX	C/2,5				DIN 2174

EDP	MF	P	L	I	d	a	Z	\varnothing	Type	DIN	Price
OSG-11-48030145	4	0,5	63	8	4,5	3,4	4	3,77 ~ 3,82	1	DIN2174	
OSG-11-48030151	5	0,5	70	8	6	4,9	5	4,77 ~ 4,82	1	DIN2174	
OSG-11-48030157	6	0,5	80	8	6	4,9	5	5,79 ~ 5,83	1	DIN2174	
OSG-11-48030156	6	0,75	80	8	6	4,9	5	5,65 ~ 5,71	1	DIN2174	
OSG-11-48030160	7	0,75	80	8	7	5,5	5	6,65 ~ 6,71	1	DIN2174	
OSG-11-48030164	8	0,5	80	10	6	4,9	5	7,79 ~ 7,83	1	DIN2174	
OSG-11-48030163	8	0,75	80	10	6	4,9	5	7,65 ~ 7,71	1	DIN2174	
OSG-11-48030162	8	1	90	10	6	4,9	5	7,51 ~ 7,59	1	DIN2174	
OSG-11-48030171	10	1	90	12	7	5,5	8	9,51 ~ 9,59	1	DIN2174	
OSG-11-48030170	10	1,25	100	12	7	5,5	8	9,37 ~ 9,45	1	DIN2174	
OSG-11-48030182	12	1	100	15	9	7	8	11,52 ~ 11,60	1	DIN2174	
OSG-11-48030181	12	1,25	100	15	9	7	8	11,39 ~ 11,46	1	DIN2174	
OSG-11-48030180	12	1,5	100	15	9	7	8	11,25 ~ 11,34	1	DIN2174	
OSG-11-48030194	14	1	100	15	11	9	8	13,52 ~ 13,60	1	DIN2174	
OSG-11-48030193	14	1,25	100	15	11	9	8	13,39 ~ 13,46	1	DIN2174	
OSG-11-48030192	14	1,5	100	15	11	9	8	13,25 ~ 13,34	1	DIN2174	
OSG-11-48030204	16	1	100	15	12	9	8	15,52 ~ 15,60	1	DIN2174	
OSG-11-48030203	16	1,5	100	15	12	9	8	15,25 ~ 15,34	1	DIN2174	
OSG-11-48030218	18	1	110	15	14	11	8	17,52 ~ 17,60	1	DIN2174	
OSG-11-48030216	18	1,5	110	15	14	11	8	17,25 ~ 17,34	1	DIN2174	
OSG-11-48030232	20	1	125	15	16	12	8	19,52 ~ 19,60	1	DIN2174	
OSG-11-48030230	20	1,5	125	15	16	12	8	19,25 ~ 19,34	1	DIN2174	
OSG-11-48030240	22	1,5	125	15	18	14,5	8	21,25 ~ 21,34	1	DIN2174	
OSG-11-48030250	24	1,5	140	15	18	14,5	8	23,25 ~ 23,34	1	DIN2174	

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ADO-MICRO SERIES page 92-95

High Performance Threading | Forming taps

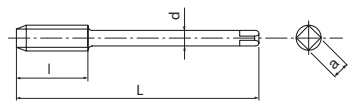
A-XPF / S-XPF Metric Fine

A-OIL-XPf

Threading | Forming taps | Metric Fine



Type 1



- First choice in quality and performance
- Powder metal forming tap for through & blind holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels
- Side through coolant

P	P	P	P	M	N	N	H	
C <0,2%	0,25 <C <0,4	C >0,45%	SCM	INOX	Al	AC,ADC	25-35 HRC	
15-40	15-40	15-30	15-30	8-20	20-50	20-40	5-20	m/min



EDP	MF	P	L	I	d	a	Z	ϕ	Type	DIN	Price
OSG-11-48225162	8	1	90	10	6	4,9	5	7,51 ~ 7,59	1	DIN2174	
OSG-11-48225171	10	1	90	12	7	5,5	8	9,51 ~ 9,59	1	DIN2174	
OSG-11-48225170	10	1,25	100	12	7	5,5	8	9,37 ~ 9,45	1	DIN2174	
OSG-11-48225182	12	1	100	15	9	7	8	11,52 ~ 11,60	1	DIN2174	
OSG-11-48225181	12	1,25	100	15	9	7	8	11,39 ~ 11,46	1	DIN2174	
OSG-11-48225180	12	1,5	100	15	9	7	8	11,25 ~ 11,34	1	DIN2174	
OSG-11-48225193	14	1,25	100	12	11	9	8	13,39 ~ 13,46	1	DIN2174	
OSG-11-48225192	14	1,5	100	15	11	9	8	13,25 ~ 13,34	1	DIN2174	
OSG-11-48225203	16	1,5	100	15	12	9	8	15,25 ~ 15,34	1	DIN2174	
OSG-11-48225216	18	1,5	110	15	14	11	8	17,25 ~ 17,34	1	DIN2174	
OSG-11-48225230	20	1,5	125	15	16	12	8	19,25 ~ 19,34	1	DIN2174	
OSG-11-48225240	22	1,5	125	15	18	14,5	8	21,25 ~ 21,34	1	DIN2174	
OSG-11-48225250	24	1,5	140	15	18	14,5	8	23,25 ~ 23,34	1	DIN2174	

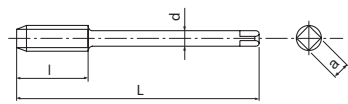
Available on request

S-OIL-XPf

Threading | Forming taps | Metric Fine



Type 1



- First choice in quality and performance
- HSSE forming tap for through & blind holes
- Multilayer TiCN coating
- For general steels, stainless steels, aluminium
- Side through coolant

P	P	P	P	M	N	N	H	
C <0,2%	0,25 <C <0,4	C >0,45%	SCM	INOX	Al	AC,ADC	25-35 HRC	
15-40	15-40	15-30	15-30	8-20	20-50	20-40	5-20	m/min



EDP	MF	P	L	I	d	a	Z	ϕ	Type	DIN	Price
OSG-11-48042162	8	1	90	10	6	4,9	5	7,51 ~ 7,59	1	DIN2174	
OSG-11-48042171	10	1	90	12	7	5,5	8	9,51 ~ 9,59	1	DIN2174	
OSG-11-48042170	10	1,25	100	12	7	5,5	8	9,37 ~ 9,45	1	DIN2174	
OSG-11-48042182	12	1	100	15	9	7	8	11,52 ~ 11,60	1	DIN2174	
OSG-11-48042181	12	1,25	100	15	9	7	8	11,39 ~ 11,46	1	DIN2174	
OSG-11-48042180	12	1,5	100	15	9	7	8	11,25 ~ 11,34	1	DIN2174	
OSG-11-48042194	14	1	100	15	11	9	8	13,52 ~ 13,60	1	DIN2174	
OSG-11-48042193	14	1,25	100	12	11	9	8	13,39 ~ 13,46	1	DIN2174	



EDP	MF	P	L	I	d	a	Z	\varnothing	Type	DIN	Price
OSG-11-48042192	14	1,5	100	15	11	9	8	13,25 ~ 13,34	1	DIN2174	
OSG-11-48042204	16	1	100	15	12	9	8	15,52 ~ 15,60	1	DIN2174	
OSG-11-48042203	16	1,5	100	15	12	9	8	15,25 ~ 15,34	1	DIN2174	
OSG-11-48042218	18	1	110	15	14	11	8	17,52 ~ 17,60	1	DIN2174	
OSG-11-48042216	18	1,5	110	15	14	11	8	17,25 ~ 17,34	1	DIN2174	
OSG-11-48042232	20	1	125	15	16	12	8	19,52 ~ 19,60	1	DIN2174	
OSG-11-48071230	20	1,5	125	15	16	12	8	19,25 ~ 19,34	1	DIN2174	
OSG-11-48071240	22	1,5	125	15	18	14,5	8	21,25 ~ 21,34	1	DIN2174	
OSG-11-48071250	24	1,5	140	15	18	14,5	8	23,25 ~ 23,34	1	DIN2174	

Available on request

S-XPf

Threading | Forming taps | UNF



- First choice in quality and performance
- HSSE forming tap for through & blind holes
- Multilayer TiCN coating
- For general steels, stainless steels, aluminium

P	P	P	P	M	N	N	H	
C<0,2%	0,25<C<0,4	C>0,45%	SCM	INOX	Al	AC,ADC	25-35 HRC	
15-40	15-40	15-30	15-30	8-20	20-50	20-40	5-20	m/min
A	UNF	HSS-Co	V	ANSI 2BX				
					C/2,5		DIN 2184-1	DIN 2184-1

EDP	UNF	P	L	I	I1	d	a	Z	\varnothing	Type	DIN	Price
OSG-11-48091462	No. 6	40	56	-	20	4	3	4	3,19 ~ 3,26	1	DIN2184-1	
OSG-11-48091467	No. 10	32	70	-	25	6	4,9	5	4,41 ~ 4,47	1	DIN2184-1	
OSG-11-48091472	1/4	28	80	-	30	7	5,5	5	5,87 ~ 5,94	1	DIN2184-1	
OSG-11-48091476	5/16	24	90	-	35	8	6,2	5	7,39 ~ 7,47	1	DIN2184-1	
OSG-11-48091481	3/8	24	90	-	35	9	7	8	8,98 ~ 9,06	1	DIN2184-1	
OSG-11-48091486	7/16	20	100	12,7	-	8	6,2	8	10,45 ~ 10,55	2	DIN2184-1	
OSG-11-48091491	1/2	20	100	12,7	-	9	7	8	12,04 ~ 12,14	2	DIN2184-1	
OSG-11-48091496	9/16	18	100	14,1	-	11	9	8	13,56 ~ 13,64	2	DIN2184-1	
OSG-11-48091504	5/8	18	100	14,1	-	12	9	8	15,15 ~ 15,23	2	DIN2184-1	
OSG-11-48091517	3/4	16	110	12,7	-	14	12	8	18,22 ~ 18,30	2	DIN2184-1	
OSG-11-48091528	7/8	14	125	14,5	-	18	14,5	8	21,27 ~ 21,38	2	DIN2184-1	
OSG-11-48091539	1"	12	125	16,9	-	18	14,5	8	24,26 ~ 24,37	2	DIN2184-1	

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M-NRT SERIES page 262-265



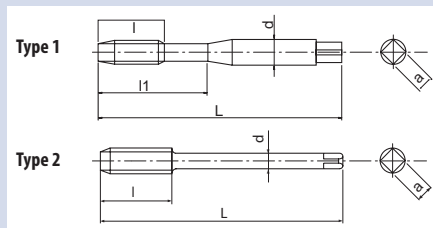
S-OIL-XPf

Threading | Forming taps | UNF



- First choice in quality and performance
- HSSE forming tap for through & blind holes
- Multilayer TiCN coating
- For general steels, stainless steels, aluminium
- Side through coolant

P 	P 	P 	P 	M 	N 	N 	H 
C<0,2%	0,25<C<0,4	C>0,45%	SCM	INOX	Al	AC,ADC	25-35 HRC
15-40	15-40	15-30	15-30	8-20	20-50	20-40	5-20



EDP	UNF	P	L	I	I1	d	a	Z	ϕ	Type	DIN	Price
OSG-11-48042472	1/4	28	80	9,1	30	7	5,5	5	5,87 ~ 5,94	1	DIN2184-1	
OSG-11-48042476	5/16	24	90	10,6	35	8	6,2	5	7,39 ~ 7,47	1	DIN2184-1	
OSG-11-48042481	3/8	24	90	10,6	35	10	8	8	8,98 ~ 9,06	1	DIN2184-1	
OSG-11-48042486	7/16	20	100	12,7	-	8	6,2	8	10,45 ~ 10,55	2	DIN2184-1	
OSG-11-48042491	1/2	20	100	12,7	-	9	7	8	12,04 ~ 12,14	2	DIN2184-1	
OSG-11-48042496	9/16	18	100	14,1	-	11	9	8	13,56 ~ 13,64	2	DIN2184-1	
OSG-11-48042504	5/8	18	100	14,1	-	12	9	8	15,15 ~ 15,23	2	DIN2184-1	
OSG-11-48042517	3/4	16	110	12,7	-	14	11	8	18,22 ~ 18,30	2	DIN2184-1	
OSG-11-48042528	7/8	14	125	14,5	-	18	14,5	8	21,27 ~ 21,38	2	DIN2184-1	
OSG-11-48042539	1"	12	140	16,9	-	18	14,5	8	24,26 ~ 24,37	2	DIN2184-1	

Available on request

M-SFT-DUPLEX

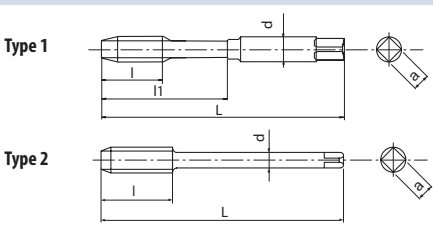
Threading | Cutting taps | Metric



- For difficult materials such as 304L, 316L, 15-5PH & 17-4PH, Super Duplex 1.4410, Inconel 625
- Powder metal spiral-fluted cutting tap for blind holes
- TiN-coating for higher heat resistance

P 	P 	P 	P 	M 	S 	S 
C<0,2%	0,25<C<0,4	C>0,45%	SCM	INOX	Inconel 625	Ti Gr.2
				3-15	2-3	3-6

Super Duplex 15-5 PH, 17-4 PH



EDP	M	P	L	I	I1	d	a	Z	Type	DIN	Price
OSG-11-48336125	2	0,4	45	10	3,2	2,8	2,1	2	1	DIN371	
OSG-11-48336138	3	0,5	56	18	4	3,5	2,7	3	1	DIN371	
OSG-11-48336144	4	0,7	63	21	5,6	4,5	3,4	3	1	DIN371	
OSG-11-48336149	5	0,8	70	25	6,4	6,0	4,9	3	1	DIN371	
OSG-11-48336155	6	1	80	8	30	6	4,9	3	1	DIN371	
OSG-11-48336161	8	1,25	90	10	35	8	6,2	3	1	DIN371	
OSG-11-48336169	10	1,5	100	12	39	10	8	4	1	DIN371	
OSG-11-48336179	12	1,75	110	14	-	9	7	4	2	DIN376	
OSG-11-48336191	14	2	110	16	-	11	9	4	2	DIN376	



EDP	M	P	L	I	I1	d	a	Z	Type	DIN	Price
OSG-11-48336202	16	2	110	16	-	12	9	4	2	DIN376	
OSG-11-48336214	18	2,5	125	25	-	14	11	4	2	DIN376	
OSG-11-48336228	20	2,5	140	25	-	16	12	4	2	DIN376	
OSG-11-48336238	22	2,5	140	25	-	18	14,5	4	2	DIN376	
OSG-11-48336247	24	3	160	30	-	18	14,5	4	2	DIN376	

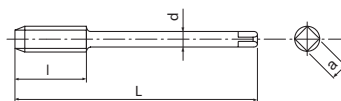
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M-SFT-DUPLEX

Threading | Cutting taps | G (BSP)



Type 1



- For difficult materials such as 304L, 316L, 15-5PH & 17-4PH, Super Duplex 1.4410, Inconel 625
- Powder metal spiral-fluted cutting tap for blind holes
- TiN-coating for higher heat resistance

P	P	P	P	M	S	S	
C < 0,2%	0,25 < C < 0,4	C > 0,45%	SCM	INOX	Inconel 625	Ti Gr.2	
				3-15	2-3	3-6	m/min
Super Duplex 15-5 PH, 17-4 PH							
G	PM	TiN	50°	C/2,5	DIN 5156		

EDP	G	P	L	I	d	a	Z	Type	DIN	Price
OSG-11-48336900	1/8	28	90	20	7	5,5	4	1	DIN5156	
OSG-11-48336000	1/4	19	100	22	11	9	4	1	DIN5156	
OSG-11-48336100	3/8	19	100	22	12	9	4	1	DIN5156	
OSG-11-48336200	1/2	14	125	25	16	12	4	1	DIN5156	
OSG-11-48336300	5/8	14	125	25	18	14,5	4	1	DIN5156	
OSG-11-48336400	3/4	14	140	28	20	16	4	1	DIN5156	
OSG-11-48336500	7/8	14	150	28	22	18	4	1	DIN5156	
OSG-11-48336600	1"	11	160	30	25	20	4	1	DIN5156	

Available on request

A-SFT

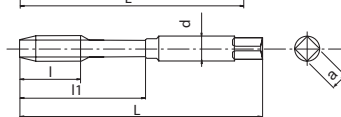
Threading | Cutting taps | Metric



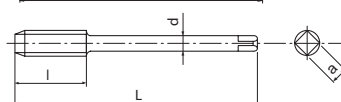
Type 1



Type 2



Type 3



- First choice in quality and performance
- Powder metal spiral-fluted cutting tap for blind holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels

P	P	P	P	M	N	N	S	H	
C < 0,2%	0,25 < C < 0,4	C > 0,45%	SCM	INOX	Al	AC/ADC	Ti	25-35 HRC	
15-60	15-60	10-60	8-30	8-20	15-35	15-35	5-10	8-20	m/min
A	M	PM	V	45°	ISO 2 6HX	C/2,5	DIN 371	DIN 376	

*Tolerance 5HX

EDP	M	P	L	I	I1	d	a	Z	Type	DIN	Price
*OSG-11-48139111	1	0,25	40	-	5	2,5	2,1	2	1	DIN371	

High Performance Threading | Cutting taps

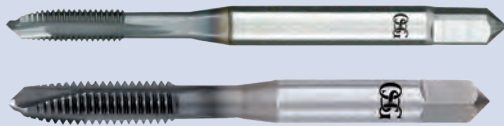
M-SFT-DUPLEX G (BSP) / A-SFT Metric

EDP	M	P	L	I	l1	d	a	Z	Type	DIN	Price
*OSG-11-48139112	1,1	0,25	40	-	5	2,5	2,1	2	1	DIN371	
*OSG-11-48139113	1,2	0,25	40	-	5	2,5	2,1	2	1	DIN371	
*OSG-11-48139115	1,4	0,3	40	-	6	2,5	2,1	2	1	DIN371	
OSG-11-48139118	1,6	0,35	40	-	7	2,5	2,1	2	1	DIN371	
OSG-11-48139119	1,7	0,35	40	-	8	2,5	2,1	2	1	DIN371	
OSG-11-48139120	1,8	0,35	40	-	8	2,5	2,1	2	1	DIN371	
OSG-11-48139125	2	0,4	45	3,2	10	2,8	2,1	2	2	DIN371	
OSG-11-48139127	2,2	0,45	45	3,6	11	2,8	2,1	2	2	DIN371	
OSG-11-48139128	2,3	0,4	45	3,6	12	2,8	2,1	2	2	DIN371	
OSG-11-48139133	2,5	0,45	50	3,6	13	2,8	2,1	2	2	DIN371	
OSG-11-48139136	2,6	0,45	50	3,6	13	2,8	2,1	2	2	DIN371	
OSG-11-48139138	3	0,5	56	4	18	3,5	2,7	3	2	DIN371	
OSG-11-48139142	3,5	0,6	56	4,8	20	4	3	3	2	DIN371	
OSG-11-48139144	4	0,7	63	5,6	21	4,5	3,4	3	2	DIN371	
OSG-11-48139147	4,5	0,75	70	6	25	6	4,9	3	2	DIN371	
OSG-11-48139149	5	0,8	70	6,4	25	6	4,9	3	2	DIN371	
OSG-11-48139152	5,5	0,9	80	7,2	30	6	4,9	3	2	DIN371	
OSG-11-48139155	6	1	80	8	30	6	4,9	3	2	DIN371	
OSG-11-48139158	7	1	80	8	30	7	5,5	3	2	DIN371	
OSG-11-48139161	8	1,25	90	10	35	8	6,2	3	2	DIN371	
OSG-11-48139165	9	1,25	90	10	35	9	7	3	2	DIN371	
OSG-11-48139169	10	1,5	100	12	39	10	8	3	2	DIN371	
OSG-11-48139139	3	0,5	56	4	-	2,2	-	3	3	DIN376	
OSG-11-48139185	4	0,7	63	5,6	-	2,8	2,1	3	3	DIN376	
OSG-11-48139150	5	0,8	70	6,4	-	3,5	2,7	3	3	DIN376	
OSG-11-48139187	6	1	80	8	-	4,5	3,4	3	3	DIN376	
OSG-11-48139159	7	1	80	8	-	5,5	4,3	3	3	DIN376	
OSG-11-48139188	8	1,25	90	10	-	6	4,9	3	3	DIN376	
OSG-11-48139166	9	1,25	90	10	-	7	5,5	3	3	DIN376	
OSG-11-48139189	10	1,5	100	12	-	7	5,5	3	3	DIN376	
OSG-11-48139175	11	1,5	100	12	-	8	6,2	3	3	DIN376	
OSG-11-48139179	12	1,75	110	14	-	9	7	3	3	DIN376	
OSG-11-48139191	14	2	110	16	-	11	9	3	3	DIN376	
OSG-11-48139202	16	2	110	16	-	12	9	3	3	DIN376	
OSG-11-48139214	18	2,5	125	25	-	14	11	4	3	DIN376	
OSG-11-48139228	20	2,5	140	25	-	16	12	4	3	DIN376	
OSG-11-48139238	22	2,5	140	25	-	18	14,5	4	3	DIN376	
OSG-11-48139247	24	3	160	30	-	18	14,5	4	3	DIN376	

Available on request

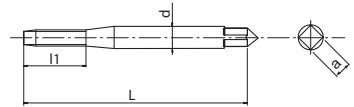
A-POT

Threading | Cutting taps | Metric

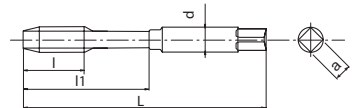


- First choice in quality and performance
- Powder metal spiral-point cutting tap for through holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels

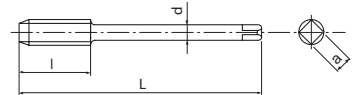
Type 1



Type 2



Type 3



15-60



15-60



10-60



8-30



8-20



15-35



15-35



5-10



8-20

m/min



* Tolerance 5Hx

EDP	M	P	L	I	l1	d	a	Z	Type	DIN	Price
*OSG-11-48145111	1	0,25	40	-	5	2,5	2,1	2	1	DIN371	
*OSG-11-48145112	1,1	0,25	40	-	5	2,5	2,1	2	1	DIN371	
*OSG-11-48145113	1,2	0,25	40	-	5	2,5	2,1	2	1	DIN371	
*OSG-11-48145115	1,4	0,3	40	-	7	2,5	2,1	2	1	DIN371	
OSG-11-48145118	1,6	0,35	40	-	8	2,5	2,1	2	1	DIN371	
OSG-11-48145119	1,7	0,35	40	-	8	2,5	2,1	2	1	DIN371	
OSG-11-48145120	1,8	0,35	40	-	8	2,5	2,1	2	1	DIN371	
OSG-11-48145125	2	0,4	45	-	8	2,8	2,1	2	1	DIN371	
OSG-11-48145127	2,2	0,45	45	-	9	2,8	2,1	2	1	DIN371	



EDP	M	P	L	I	I1	d	a	Z	Type	DIN	Price
OSG-11-48145128	2,3	0,4	45	-	9	2,8	2,1	2	1	DIN371	
OSG-11-48145133	2,5	0,45	50	-	9	2,8	2,1	2	1	DIN371	
OSG-11-48145136	2,6	0,45	50	-	9	2,8	2,1	2	1	DIN371	
OSG-11-48145138	3	0,5	56	11	18	3,5	2,7	3	2	DIN371	
OSG-11-48145142	3,5	0,6	56	12	20	4	3	3	2	DIN371	
OSG-11-48145144	4	0,7	63	13	21	4,5	3,4	3	2	DIN371	
OSG-11-48145147	4,5	0,75	70	16	25	6	4,9	3	2	DIN371	
OSG-11-48145149	5	0,8	70	16	25	6	4,9	3	2	DIN371	
OSG-11-48145152	5,5	0,9	80	17	30	6	4,9	3	2	DIN371	
OSG-11-48145155	6	1	80	19	30	6	4,9	3	2	DIN371	
OSG-11-48145158	7	1	80	19	30	7	5,5	3	2	DIN371	
OSG-11-48145161	8	1,25	90	22	35	8	6,2	3	2	DIN371	
OSG-11-48145165	9	1,25	90	22	35	9	7	3	2	DIN371	
OSG-11-48145169	10	1,5	100	24	39	10	8	3	2	DIN371	
OSG-11-48145139	3	0,5	56	11	-	2,2	-	3	3	DIN376	
OSG-11-48145185	4	0,7	63	13	-	2,8	2,1	3	3	DIN376	
OSG-11-48145150	5	0,8	70	16	-	3,5	2,7	3	3	DIN376	
OSG-11-48145187	6	1	80	19	-	4,5	3,4	3	3	DIN376	
OSG-11-48145159	7	1	80	19	-	5,5	4,3	3	3	DIN376	
OSG-11-48145188	8	1,25	90	22	-	6	4,9	3	3	DIN376	
OSG-11-48145166	9	1,25	90	22	-	7	5,5	3	3	DIN376	
OSG-11-48145189	10	1,5	100	24	-	7	5,5	3	3	DIN376	
OSG-11-48145175	11	1,5	100	24	-	8	6,2	3	3	DIN376	
OSG-11-48145179	12	1,75	110	28	-	9	7	3	3	DIN376	
OSG-11-48145191	14	2	110	30	-	11	9	3	3	DIN376	
OSG-11-48145202	16	2	110	32	-	12	9	3	3	DIN376	
OSG-11-48145214	18	2,5	125	34	-	14	11	3	3	DIN376	
OSG-11-48145228	20	2,5	140	34	-	16	12	3	3	DIN376	
OSG-11-48145238	22	2,5	140	34	-	18	14,5	3	3	DIN376	
OSG-11-48145247	24	3	160	38	-	18	14,5	3	3	DIN376	

Available on request

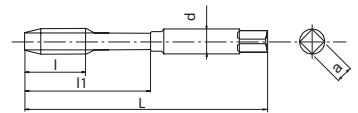
A-OIL-SFT

Threading | Cutting taps | Metric

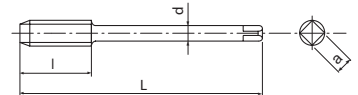


- First choice in quality and performance
- Powder metal spiral-fluted cutting tap for blind holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels
- Centre through coolant

Type 1



Type 2



P	P	P	P	M	N	N	S	H
C<0,2%	0,25<C<0,4	C>0,45%	SCM	INOX	Al	AC,ADC	Ti	25-35 HRC
15-60	15-60	10-60	8-30	8-20	15-35	15-35	5-10	8-20

m/min



M

PM

V

45°

ISO 2

6HX

C/2,5

DIN 371

DIN 376

EDP	M	P	L	I	I1	d	a	Z	Type	DIN	Price
OSG-11-48140155	6	1	80	8	30	6	4,9	3	1	DIN371	
OSG-11-48140161	8	1,25	90	10	35	8	6,2	3	1	DIN371	
OSG-11-48140169	10	1,5	100	12	39	10	8	3	1	DIN371	
OSG-11-48140179	12	1,75	110	14	-	9	7	3	2	DIN376	
OSG-11-48140191	14	2	110	16	-	11	9	3	2	DIN376	
OSG-11-48140202	16	2	110	16	-	12	9	3	2	DIN376	
OSG-11-48140214	18	2,5	125	25	-	14	11	4	2	DIN376	
OSG-11-48140228	20	2,5	140	25	-	16	12	4	2	DIN376	
OSG-11-48140238	22	2,5	140	25	-	18	14,5	4	2	DIN376	
OSG-11-48140247	24	3	160	30	-	18	14,5	4	2	DIN376	
OSG-11-48140262	27	3	160	36	-	20	16	4	2	DIN376	
OSG-11-48140271	30	3,5	180	42	-	22	18	4	2	DIN376	
OSG-11-48140281	33	3,5	180	42	-	25	20	4	2	DIN376	
OSG-11-48140294	36	4	200	48	-	28	22	4	2	DIN376	
OSG-11-48140304	39	4	200	48	-	32	24	4	2	DIN376	
OSG-11-48140314	42	4,5	200	54	-	32	24	4	2	DIN376	
OSG-11-48140319	45	4,5	220	54	-	36	29	4	2	DIN376	
OSG-11-48140325	48	5	250	60	-	36	29	4	2	DIN376	
OSG-11-48140337	52	5	250	60	-	40	32	4	2	DIN376	
OSG-11-48140347	56	5,5	250	66	-	40	32	4	2	DIN376	

Available on request

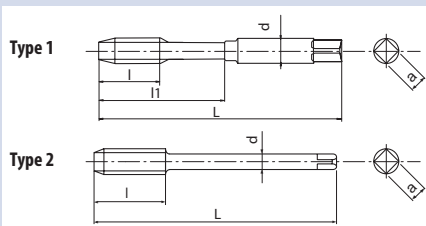
A-OIL-POT

Threading | Cutting taps | Metric



- First choice in quality and performance
- Powder metal spiral-point cutting tap for through holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels
- Side through coolant

P	P	P	P	M	N	N	S	H	
C<0,2%	0,25<C<0,4	C>0,45%	SCM	INOX	Al	AC/ADC	Ti	25-35 HRC	
15-60	15-60	10-60	8-30	8-20	15-35	15-35	5-10	8-20	m/min



EDP	M	P	L	I	l1	d	a	Z	Type	DIN	Price
OSG-11-48214155	6	1	80	19	30	6	4,9	3	1	DIN371	
OSG-11-48214161	8	1,25	90	22	35	8	6,2	3	1	DIN371	
OSG-11-48214169	10	1,5	100	24	39	10	8	3	1	DIN371	
OSG-11-48214179	12	1,75	110	28	-	9	7	3	2	DIN376	
OSG-11-48214191	14	2	110	30	-	11	9	3	2	DIN376	
OSG-11-48214202	16	2	110	32	-	12	9	3	2	DIN376	
OSG-11-48214214	18	2,5	125	34	-	14	11	3	2	DIN376	
OSG-11-48214228	20	2,5	140	34	-	16	12	3	2	DIN376	
OSG-11-48214238	22	2,5	140	34	-	18	14,5	3	2	DIN376	
OSG-11-48214247	24	3	160	38	-	18	14,5	3	2	DIN376	

Available on request

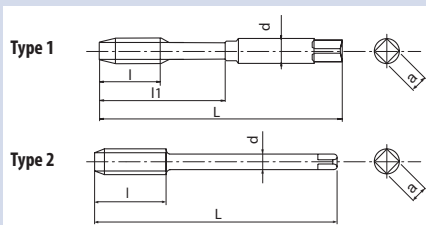
A-SFT 6GX

Threading | Cutting taps | Metric



- First choice in quality and performance
- Powder metal spiral-fluted cutting tap for blind holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels
- For 6G internal thread tolerance

P	P	P	P	M	N	N	S	H	
C<0,2%	0,25<C<0,4	C>0,45%	SCM	INOX	Al	AC/ADC	Ti	25-35 HRC	
15-60	15-60	10-60	8-30	8-20	15-35	15-35	5-10	8-20	m/min



EDP	M	P	oversize	L	I	l1	d	a	Z	Type	DIN	Price
OSG-11-48201125	2	0,4	+0,019	45	3,2	10	2,8	2,1	2	1	DIN371	
OSG-11-48201133	2,5	0,45	+0,020	50	3,6	13	2,8	2,1	2	1	DIN371	
OSG-11-48201138	3	0,5	+0,020	56	4	18	3,5	2,7	3	1	DIN371	
OSG-11-48201144	4	0,7	+0,022	63	5,6	21	4,5	3,4	3	1	DIN371	
OSG-11-48201149	5	0,8	+0,024	70	6,4	25	6	4,9	3	1	DIN371	
OSG-11-48201155	6	1	+0,026	80	8	30	6	4,9	3	1	DIN371	
OSG-11-48201161	8	1,25	+0,028	90	10	35	8	6,2	3	1	DIN371	
OSG-11-48201169	10	1,5	+0,032	100	12	39	10	8	3	1	DIN371	
OSG-11-48201179	12	1,75	+0,034	110	14	-	9	7	3	2	DIN376	
OSG-11-48201202	16	2	+0,038	110	16	-	12	9	3	2	DIN376	

Available on request



A-POT 6GX

Threading | Cutting taps | Metric



- First choice in quality and performance
- Powder metal spiral-point cutting tap for through holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels
- For 6G internal thread tolerance

P C<0,2%	P 0,25<C<0,4	P C>0,45%	P SCM	M INOX	N AI	N AC,ADC	S Ti	H 25-35 HRC	
15-60	15-60	10-60	8-30	8-20	15-35	15-35	5-10	8-20	m/min
A	M	PM	V	ISO 3 6GX	B/4	DIN 371	DIN 376		

EDP	M	P	oversize	L	I	l1	d	a	Z	Type	DIN	Price
OSG-11-48205125	2	0,4	+0,019	45	-	8	2,8	2,1	2	1	DIN371	
OSG-11-48205133	2,5	0,45	+0,020	50	-	9	2,8	2,1	2	1	DIN371	
OSG-11-48205138	3	0,5	+0,020	56	11	18	3,5	2,7	3	2	DIN371	
OSG-11-48205144	4	0,7	+0,022	63	13	21	4,5	3,4	3	2	DIN371	
OSG-11-48205149	5	0,8	+0,024	70	16	25	6	4,9	3	2	DIN371	
OSG-11-48205155	6	1	+0,026	80	19	30	6	4,9	3	2	DIN371	
OSG-11-48205161	8	1,25	+0,028	90	22	35	8	6,2	3	2	DIN371	
OSG-11-48205169	10	1,5	+0,032	100	24	39	10	8	3	2	DIN371	
OSG-11-48205179	12	1,75	+0,034	110	28	-	9	7	3	3	DIN376	
OSG-11-48205202	16	2	+0,038	110	32	-	12	9	3	3	DIN376	

Available on request

A-SFT 7GX

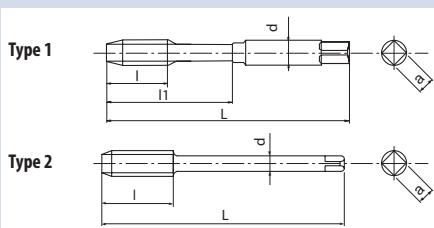
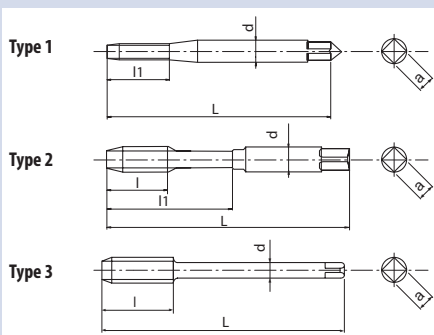
Threading | Cutting taps | Metric



- First choice in quality and performance
- Powder metal spiral-fluted cutting tap for blind holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels
- For 7G internal thread tolerance

P C<0,2%	P 0,25<C<0,4	P C>0,45%	P SCM	M INOX	N AI	N AC,ADC	S Ti	H 25-35 HRC	
15-60	15-60	10-60	8-30	8-20	15-35	15-35	5-10	8-20	m/min
A	M	PM	V	45°	7GX	C/2,5	DIN 371	DIN 376	

EDP	M	P	oversize	L	I	l1	d	a	Z	Type	DIN	Price
OSG-11-48202125	2	0,4	+0,038	45	3,2	10	2,8	2,1	2	1	DIN371	
OSG-11-48202133	2,5	0,45	+0,040	50	3,6	13	2,8	2,1	2	1	DIN371	
OSG-11-48202138	3	0,5	+0,040	56	4	18	3,5	2,7	3	1	DIN371	



High Performance Threading | Cutting taps

A-POT 6GX / A-SFT 7GX Metric

EDP	M	P	oversize	L	I	l1	d	a	Z	Type	DIN	Price
OSG-11-48202144	4	0,7	+0,044	63	5,6	21	4,5	3,4	3	1	DIN371	
OSG-11-48202149	5	0,8	+0,048	70	6,4	25	6	4,9	3	1	DIN371	
OSG-11-48202155	6	1	+0,052	80	8	30	6	4,9	3	1	DIN371	
OSG-11-48202161	8	1,25	+0,056	90	10	35	8	6,2	3	1	DIN371	
OSG-11-48202169	10	1,5	+0,064	100	12	39	10	8	3	1	DIN371	
OSG-11-48202179	12	1,75	+0,068	110	14	-	9	7	3	2	DIN376	
OSG-11-48202202	16	2	+0,076	110	16	-	12	9	3	2	DIN376	

Available on request

A-POT 7GX

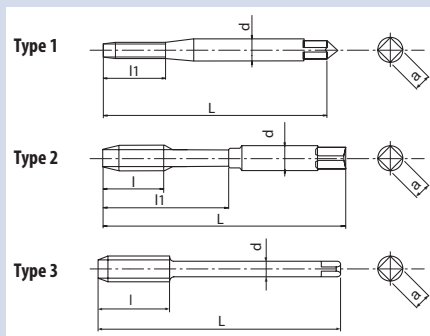
Threading | Cutting taps | Metric



- First choice in quality and performance
- Powder metal spiral-point cutting tap for through holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels
- For 7G internal thread tolerance

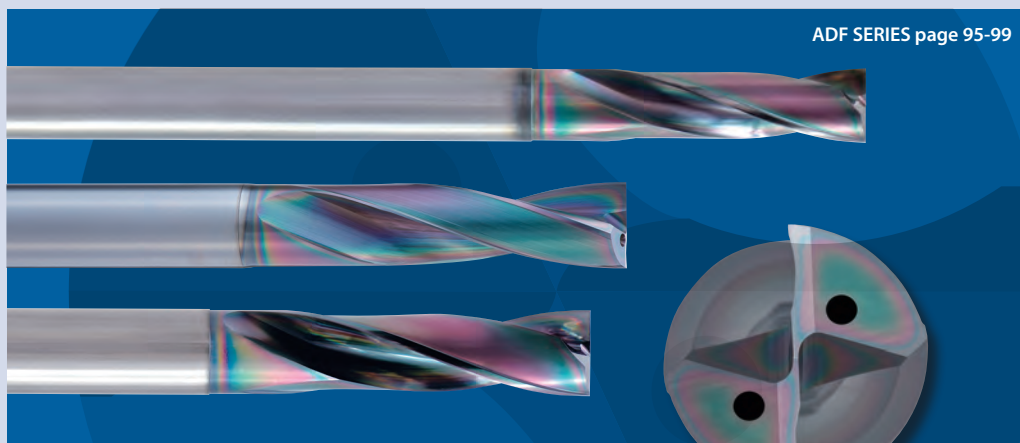
P	P	P	P	M	N	N	S	H	
C<0,2%	0,25<C<0,4	C>0,45%	SCM	INOX	AI	AC/ADC	TI	25-35 HRC	
15-60	15-60	10-60	8-30	8-20	15-35	15-35	5-10	8-20	m/min

A	M	PM	V	7GX	B/4	DIN 371	DIN 376
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EDP	M	P	oversize	L	I	l1	d	a	Z	Type	DIN	Price
OSG-11-48206125	2	0,4	+0,038	45	-	8	2,8	2,1	2	1	DIN371	
OSG-11-48206133	2,5	0,45	+0,040	50	-	9	2,8	2,1	2	1	DIN371	
OSG-11-48206138	3	0,5	+0,040	56	11	18	3,5	2,7	3	2	DIN371	
OSG-11-48206144	4	0,7	+0,044	63	13	21	4,5	3,4	3	2	DIN371	
OSG-11-48206149	5	0,8	+0,048	70	16	25	6	4,9	3	2	DIN371	
OSG-11-48206155	6	1	+0,052	80	19	30	6	4,9	3	2	DIN371	
OSG-11-48206161	8	1,25	+0,056	90	22	35	8	6,2	3	2	DIN371	
OSG-11-48206169	10	1,5	+0,064	100	24	39	10	8	3	2	DIN371	
OSG-11-48206179	12	1,75	+0,068	110	14	-	28	7	3	3	DIN376	
OSG-11-48206202	16	2	+0,076	110	16	-	32	9	3	3	DIN376	

Available on request



ADF SERIES page 95-99



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JUNE 2023 V3 SOMTA CATALOGUE

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OSG GROUP COMPANY

A-SFT FORM E

Threading | Cutting taps | Metric



- First choice in quality and performance
- Powder metal spiral-fluted cutting tap for blind holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels
- Form E chamfer

P	P	P	P	M	N	N	S	H	
C<0.2%	0.25<C<0.4	C>0.45%	SCM	INOX	Al	AC,ADC	Ti	25-35 HRC	
15-60	15-60	10-60	8-30	8-20	15-35	15-35	5-10	8-20	m/min
A	M	PM	V	45°	ISO 2 6HX	E/1,5	DIN 371	DIN 376	

EDP	M	P	L	I	I1	d	a	Z	Type	DIN	Price
OSG-11-48203138	3	0,5	56	4	18	3,5	2,7	3	1	DIN371	
OSG-11-48203144	4	0,7	63	5,6	21	4,5	3,4	3	1	DIN371	
OSG-11-48203149	5	0,8	70	6,4	25	6	4,9	3	1	DIN371	
OSG-11-48203155	6	1	80	8	30	6	4,9	3	1	DIN371	
OSG-11-48203161	8	1,25	90	10	35	8	6,2	3	1	DIN371	
OSG-11-48203169	10	1,5	100	12	39	10	8	3	1	DIN371	
OSG-11-48203179	12	1,75	110	14	-	9	7	3	2	DIN376	
OSG-11-48203191	14	2	110	16	-	11	9	3	2	DIN376	
OSG-11-48203202	16	2	110	16	-	12	9	3	2	DIN376	

Available on request

A-SFT+0.1

Threading | Cutting taps | Metric



- First choice in quality and performance
- Powder metal spiral-fluted cutting tap for blind holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels
- Oversized tap for 6H +0,1mm thread tolerance

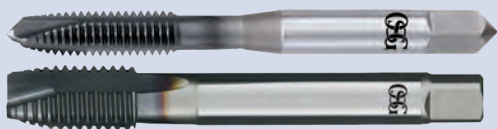
P	P	P	P	M	N	N	S	H	
C<0.2%	0.25<C<0.4	C>0.45%	SCM	INOX	Al	AC,ADC	Ti	25-35 HRC	
15-60	15-60	10-60	8-30	8-20	15-35	15-35	5-10	8-20	m/min
A	M	PM	V	45°	6H +0.1	C/2,5	DIN 371	DIN 376	

EDP	M	P	L	I	I1	d	a	Z	Type	DIN	Price
OSG-11-48204138	3	0,5	56	4	18	3,5	2,7	3	1	DIN371	
OSG-11-48204144	4	0,7	63	5,6	21	4,5	3,4	3	1	DIN371	
OSG-11-48204149	5	0,8	70	6,4	25	6	4,9	3	1	DIN371	
OSG-11-48204155	6	1	80	8	30	6	4,9	3	1	DIN371	
OSG-11-48204161	8	1,25	90	10	35	8	6,2	3	1	DIN371	
OSG-11-48204169	10	1,5	100	12	39	10	8	3	1	DIN371	
OSG-11-48204179	12	1,75	110	14	-	9	7	3	2	DIN376	
OSG-11-48204202	16	2	110	16	-	12	9	3	2	DIN376	

Available on request

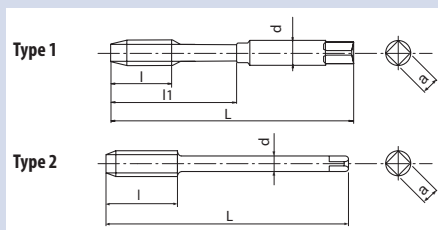
A-POT+0.1

Threading | Cutting taps | Metric



- First choice in quality and performance
- Powder metal spiral-point cutting tap for through holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels
- Oversized tap for 6H +0,1mm thread tolerance

P	P	P	P	M	N	N	S	H	
C<0,2%	0,25<C<0,4	C>0,45%	SCM	INOX	AI	AC,ADC	Ti	25-35 HRC	
15-60	15-60	10-60	8-30	8-20	15-35	15-35	5-10	8-20	m/min
A	M	PM	V	6H +0.1	B/4	DIN 371	DIN 376		

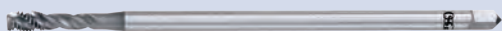


EDP	M	P	L	I	I1	d	a	Z	Type	DIN	Price
OSG-11-48259138	3	0,5	56	11	18	3,5	2,7	3	1	DIN371	
OSG-11-48259144	4	0,7	63	13	21	4,5	3,4	3	1	DIN371	
OSG-11-48259149	5	0,8	70	16	25	6	4,9	3	1	DIN371	
OSG-11-48259155	6	1	80	19	30	6	4,9	3	1	DIN371	
OSG-11-48259161	8	1,25	90	22	35	8	6,2	3	1	DIN371	
OSG-11-48259169	10	1,5	100	24	39	10	8	3	1	DIN371	
OSG-11-48259179	12	1,75	110	28	-	9	7	3	2	DIN376	
OSG-11-48259202	16	2	110	32	-	12	9	3	2	DIN376	

Available on request

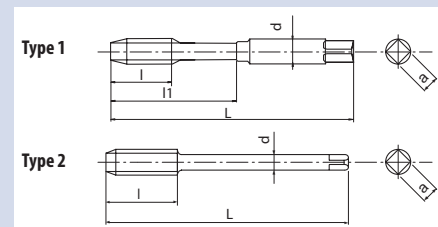
A-LT-SFT

Threading | Cutting taps | Metric



- First choice in quality and performance
- Powder metal spiral-fluted cutting tap for blind holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels
- With long shank for long reach threading

P	P	P	P	M	N	N	S	H	
C<0,2%	0,25<C<0,4	C>0,45%	SCM	INOX	AI	AC,ADC	Ti	25-35 HRC	
15-25	15-25	10-25	8-20	8-20	15-35	15-35	5-10	8-20	m/min
A	M	PM	V	45°	ISO 2 6HX	C/2,5			



EDP	M	P	L	I	I1	d	a	Z	Type	Price
OSG-11-48208125	2	0,4	80	3,2	10	2,8	2,1	2	1	
OSG-11-48208133	2,5	0,45	100	3,6	13	2,8	2,1	2	1	
OSG-11-48208138	3	0,5	100	4	18	3,5	2,7	3	1	
OSG-11-48208144	4	0,7	125	5,6	21	4,5	3,4	3	1	
OSG-11-48208149	5	0,8	160	6,4	25	6	4,9	3	1	
OSG-11-48208155	6	1	160	8	30	6	4,9	3	1	
OSG-11-48208161	8	1,25	180	10	35	8	6,2	3	1	
OSG-11-48208169	10	1,5	200	12	39	10	8	3	1	
OSG-11-48209155	6	1	160	10	-	4,5	3,4	3	2	
OSG-11-48209161	8	1,25	180	11	-	6	4,9	3	2	
OSG-11-48209169	10	1,5	200	14	-	7	5,5	3	2	



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JUNE 2023 V3 SOMTA CATALOGUE

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EDP	M	P	L	I	I1	d	a	Z	Type	Price
OSG-11-48209179	12	1,75	200	14	-	9	7	3	2	
OSG-11-48209191	14	2	200	16	-	11	9	3	2	
OSG-11-48209202	16	2	200	16	-	12	9	3	2	
OSG-11-48209214	18	2,5	200	25	-	14	11	4	2	
OSG-11-48209228	20	2,5	200	25	-	16	12	4	2	

Available on request

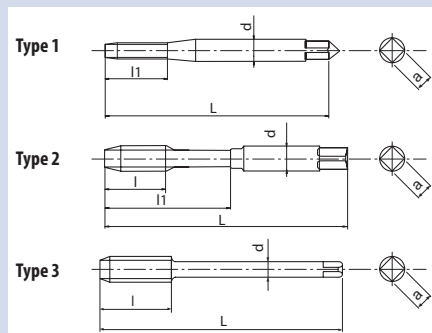
A-LT-POT

Threading | Cutting taps | Metric



- First choice in quality and performance
- Powder metal spiral-point cutting tap for through holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels
- With long shank for long reach threading

P	P	P	P	M	N	N	S	H	
C<0,2%	0,25<C<0,4	C>0,45%	SOM	INOX	Al	AC/ADC	Ti	25-35 HRC	
15-60	15-60	10-60	8-30	8-20	15-35	15-35	5-10	8-20	m/min
A	M	PM	V	ISO 2 6HX	B/4		DIN 371	DIN 376	



EDP	M	P	L	I	I1	d	a	Z	Type	DIN	Price
OSG-11-48210125	2	0,4	80	8	-	2,8	2,1	2	1	DIN371	
OSG-11-48210133	2,5	0,45	100	9	-	2,8	2,1	2	1	DIN371	
OSG-11-48210138	3	0,5	100	11	18	3,5	2,7	3	2	DIN371	
OSG-11-48210144	4	0,7	125	13	21	4,5	3,4	3	2	DIN371	
OSG-11-48210149	5	0,8	160	16	25	6	4,9	3	2	DIN371	
OSG-11-48210155	6	1	160	19	30	6	4,9	3	2	DIN371	
OSG-11-48210161	8	1,25	180	22	35	8	6,2	3	2	DIN371	
OSG-11-48210169	10	1,5	200	24	39	10	8	3	2	DIN371	
OSG-11-48211155	6	1	160	19	-	4,5	3,4	3	3	DIN376	
OSG-11-48211161	8	1,25	180	22	-	6	4,9	3	3	DIN376	
OSG-11-48211169	10	1,5	200	24	-	7	5,5	3	3	DIN376	
OSG-11-48211179	12	1,75	200	28	-	9	7	3	3	DIN376	
OSG-11-48211191	14	2	200	30	-	11	9	3	3	DIN376	
OSG-11-48211202	16	2	200	32	-	12	9	3	3	DIN376	
OSG-11-48211214	18	2,5	200	34	-	14	11	3	3	DIN376	
OSG-11-48211228	20	2,5	200	34	-	16	12	3	3	DIN376	

Available on request



P2D P3D P4D P5D page 119-125

A-SFT-LH

Threading | Cutting taps | Metric



- First choice in quality and performance
- Powder metal spiral-fluted cutting tap for blind holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels
- For left-hand threads

P	P	P	P	M	N	N	S	H	
C<0,2%	0,25<C<0,4	C>0,45%	SCM	INOX	AI	AC/ADC	Ti	25-35 HRC	
15-60	15-60	10-60	8-30	8-20	15-35	15-35	5-10	8-20	m/min



EDP	M	P	L	I	I1	d	a	Z	Type	DIN	Price
OSG-11-48217138	3	0,5	56	4	18	3,5	2,7	3	1	DIN371	
OSG-11-48217144	4	0,7	63	5,6	21	4,5	3,4	3	1	DIN371	
OSG-11-48217149	5	0,8	70	6,4	25	6	4,9	3	1	DIN371	
OSG-11-48217155	6	1	80	8	30	6	4,9	3	1	DIN371	
OSG-11-48217161	8	1,25	90	10	35	8	6,2	3	1	DIN371	
OSG-11-48217169	10	1,5	100	12	39	10	8	3	1	DIN371	
OSG-11-48217179	12	1,75	110	14	-	9	7	3	2	DIN376	
OSG-11-48217191	14	2	110	16	-	11	9	3	2	DIN376	
OSG-11-48217202	16	2	110	16	-	12	9	3	2	DIN376	
OSG-11-48217214	18	2,5	125	25	-	14	11	4	2	DIN376	
OSG-11-48217228	20	2,5	140	25	-	16	12	4	2	DIN376	
OSG-11-48217238	22	2,5	140	25	-	18	14,5	4	2	DIN376	
OSG-11-48217247	24	3	160	30	-	18	14,5	4	2	DIN376	

Available on request

A-POT-LH

Threading | Cutting taps | Metric

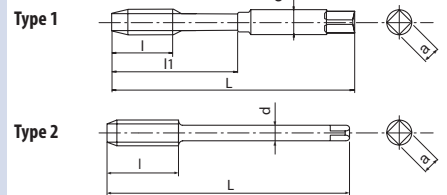


- First choice in quality and performance
- Powder metal spiral-point cutting tap for through holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels
- For left-hand threads

P	P	P	P	M	N	N	S	H	
C<0,2%	0,25<C<0,4	C>0,45%	SCM	INOX	AI	AC/ADC	Ti	25-35 HRC	
15-60	15-60	10-60	8-30	8-20	15-35	15-35	5-10	8-20	m/min



EDP	M	P	L	I	I1	d	a	Z	Type	DIN	Price
OSG-11-48218138	3	0,5	56	11	18	3,5	2,7	3	1	DIN371	
OSG-11-48218144	4	0,7	63	13	21	4,5	3,4	3	1	DIN371	
OSG-11-48218149	5	0,8	70	16	25	6	4,9	3	1	DIN371	
OSG-11-48218155	6	1	80	19	30	6	4,9	3	1	DIN371	
OSG-11-48218161	8	1,25	90	22	35	8	6,2	3	1	DIN371	
OSG-11-48218169	10	1,5	100	24	39	10	8	3	1	DIN371	

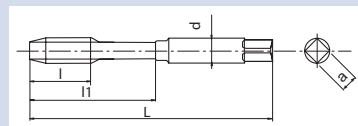


EDP	M	P	L	I	I1	d	a	Z	Type	DIN	Price
OSG-11-48218179	12	1,75	110	28	-	9	7	3	2	DIN376	
OSG-11-48218191	14	2	110	30	-	11	9	3	2	DIN376	
OSG-11-48218202	16	2	110	32	-	12	9	3	2	DIN376	
OSG-11-48218214	18	2,5	125	34	-	14	11	3	2	DIN376	
OSG-11-48218228	20	2,5	140	34	-	16	12	3	2	DIN376	
OSG-11-48218238	22	2,5	140	34	-	18	14,5	3	2	DIN376	
OSG-11-48218247	24	3	160	38	-	18	14,5	3	2	DIN376	

Available on request

A-SFT-HB Weldon

Threading | Cutting taps | Metric

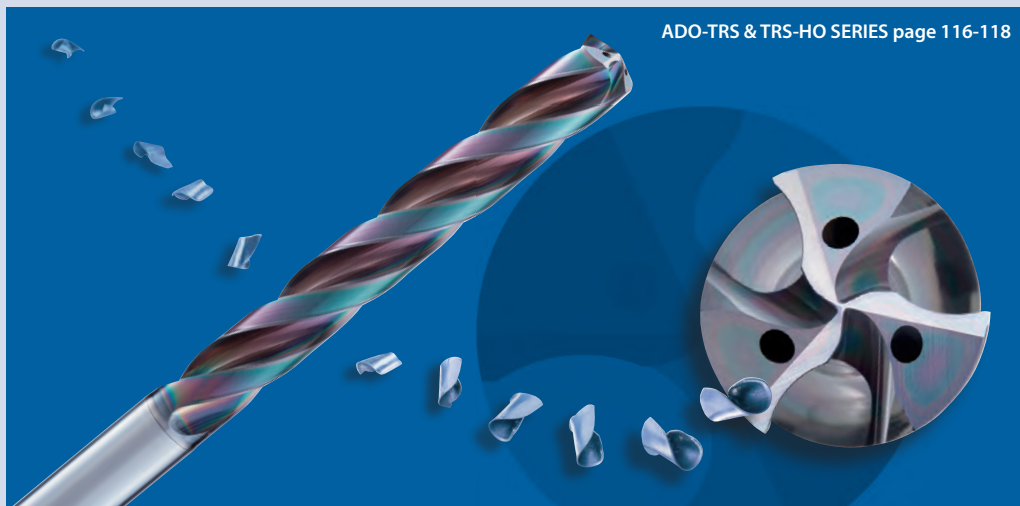


- First choice in quality and performance
- Powder metal spiral-fluted cutting tap for blind holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels
- With Weldon shank

P	P	P	P	M	N	N	S	H	
C < 0,2%	0,25 < C < 0,4	C > 0,45%	SCM	INOX	Al	AC/DC	Ti	25-35 HRC	
15-60	15-60	10-60	8-30	8-20	15-35	15-35	5-10	8-20	m/min
	M	PM			ISO 2 6HX			DIN 1835	HB

EDP	M	P	L	I	I1	d	a	Z	DIN	Price
OSG-11-48220138	3	0,5	56	4	18	6	4,9	3	DIN371/1835	
OSG-11-48220144	4	0,7	63	5,6	21	6	4,9	3	DIN371/1835	
OSG-11-48220149	5	0,8	70	6,4	25	6	4,9	3	DIN371/1835	
OSG-11-48220155	6	1	80	8	30	6	4,9	3	DIN371/1835	
OSG-11-48220161	8	1,25	90	10	35	8	6,2	3	DIN371/1835	
OSG-11-48220169	10	1,5	100	12	39	10	8	3	DIN371/1835	
OSG-11-48220179	12	1,75	110	14	46	12	9	3	DIN371/1835	
OSG-11-48220191	14	2	110	16	49	14	11	3	DIN371/1835	
OSG-11-48220202	16	2	110	16	56	16	12	3	DIN371/1835	

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ADO-TRS & TRS-HO SERIES page 116-118

High Performance Threading | Cutting taps

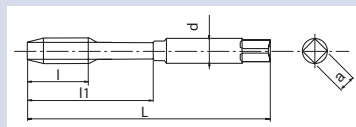
A-POT-LH / A-SFT-HB Weldon Metric



A-POT-HB Weldon

Threading | Cutting taps | Metric



- First choice in quality and performance
- Powder metal spiral-point cutting tap for through holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels
- With Weldon shank



P  C<0,2%	P  0,25<C<0,4	P  C>0,45%	P  SCM	M  INOX	N  Al	N  AC,ADC	S  Ti	H  25-35 HRC	
15-60	15-60	10-60	8-30	8-20	15-35	15-35	5-10	8-20	m/min

A	M	PM	V	ISO 2 6HX	B/4	DIN 371	DIN 376	DIN 1835	HB
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EDP	M	P	L	I	I1	d	a	Z	DIN	Price
OSG-11-48221138	3	0,5	56	11	18	6	4,9	3	DIN371/1835	
OSG-11-48221144	4	0,7	63	13	21	6	4,9	3	DIN371/1835	
OSG-11-48221149	5	0,8	70	16	25	6	4,9	3	DIN371/1835	
OSG-11-48221155	6	1	80	19	30	6	4,9	3	DIN371/1835	
OSG-11-48221161	8	1,25	90	22	35	8	6,2	3	DIN371/1835	
OSG-11-48221169	10	1,5	100	24	39	10	8	3	DIN371/1835	
OSG-11-48221179	12	1,75	110	28	46	12	9	3	DIN376/1835	
OSG-11-48221191	14	2	110	30	49	14	11	3	DIN376/1835	
OSG-11-48221202	16	2	110	32	56	16	12	3	DIN376/1835	

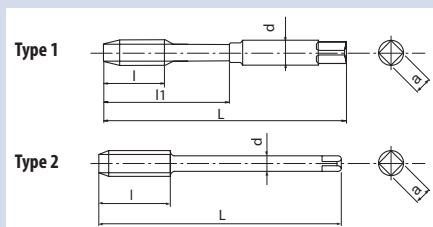
Available on request






A-SFT

Threading | Cutting taps | Metric Fine



- First choice in quality and performance
- Powder metal spiral-fluted cutting tap for blind holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels



P  C<0,2%	P  0,25<C<0,4	P  C>0,45%	P  SCM	M  INOX	N  Al	N  AC,ADC	S  Ti	H  25-35 HRC	
15-60	15-60	10-60	8-30	8-20	15-35	15-35	5-10	8-20	m/min

A	MF	PM	V	45°	ISO 2 6HX	C/2,5	DIN 371	DIN 374
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EDP	MF	P	L	I	I1	d	a	Z	Type	DIN	Price
OSG-11-48139135	2,5	0,35	50	3,6	13	2,8	2,1	2	1	DIN371	
OSG-11-48139137	2,6	0,35	50	3,6	13	2,8	2,1	2	1	DIN371	
OSG-11-48139141	3	0,35	56	4	18	3,5	2,7	3	1	DIN371	
OSG-11-48139143	3,5	0,35	56	4,8	20	4	3	3	1	DIN371	
OSG-11-48139145	4	0,5	63	5,6	21	4,5	3,4	3	1	DIN371	
OSG-11-48139146	4	0,35	63	5,6	21	4,5	3,4	3	1	DIN371	
OSG-11-48139148	4,5	0,5	70	6	25	6	4,9	3	1	DIN371	
OSG-11-48139151	5	0,5	70	6,4	25	6	4,9	3	1	DIN371	
OSG-11-48139601	6	0,75	80	8	30	6	4,9	3	1	DIN371	
OSG-11-48139602	6	0,5	80	8	30	6	4,9	3	1	DIN371	
OSG-11-48139160	7	0,75	80	8	30	7	5,5	3	1	DIN371	
OSG-11-48139603	8	1	90	10	35	8	6,2	3	1	DIN371	



EDP	MF	P	L	I	I1	d	a	Z	Type	DIN	Price
OSG-11-48139604	8	0,75	80	10	35	8	6,2	3	1	DIN371	
OSG-11-48139605	9	1	90	10	35	9	7	3	1	DIN371	
OSG-11-48139606	10	1,25	100	12	39	10	8	3	1	DIN371	
OSG-11-48139607	10	1	90	12	35	10	8	3	1	DIN371	
OSG-11-48139608	10	0,75	90	12	35	10	8	3	1	DIN371	
OSG-11-48139156	6	0,75	80	8	-	4,5	3,4	3	2	DIN374	
OSG-11-48139157	6	0,5	80	8	-	4,5	3,4	3	2	DIN374	
OSG-11-48139162	8	1	90	10	-	6	4,9	3	2	DIN374	
OSG-11-48139163	8	0,75	80	8	-	6	4,9	3	2	DIN374	
OSG-11-48139167	9	1	90	10	-	7	5,5	3	2	DIN374	
OSG-11-48139170	10	1,25	100	12	-	7	5,5	3	2	DIN374	
OSG-11-48139171	10	1	90	10	-	7	5,5	3	2	DIN374	
OSG-11-48139172	10	0,75	90	10	-	7	5,5	3	2	DIN374	
OSG-11-48139176	11	1	90	12	-	8	6,2	3	2	DIN374	
OSG-11-48139180	12	1,5	100	14	-	9	7	3	2	DIN374	
OSG-11-48139181	12	1,25	100	12	-	9	7	3	2	DIN374	
OSG-11-48139182	12	1	100	12	-	9	7	3	2	DIN374	
OSG-11-48139192	14	1,5	100	16	-	11	9	3	2	DIN374	
OSG-11-48139193	14	1,25	100	16	-	11	9	3	2	DIN374	
OSG-11-48139194	14	1	100	16	-	11	9	3	2	DIN374	
OSG-11-48139203	16	1,5	100	16	-	12	9	3	2	DIN374	
OSG-11-48139204	16	1	100	16	-	12	9	3	2	DIN374	
OSG-11-48139216	18	1,5	110	16	-	14	11	4	2	DIN374	
OSG-11-48139218	18	1	110	16	-	14	11	4	2	DIN374	
OSG-11-48139220	20	2	140	25	-	16	12	4	2	DIN374	
OSG-11-48139230	20	1,5	125	16	-	16	12	4	2	DIN374	
OSG-11-48139232	20	1	125	16	-	16	12	4	2	DIN374	
OSG-11-48139239	22	2	140	25	-	18	14,5	4	2	DIN374	
OSG-11-48139240	22	1,5	125	16	-	18	14,5	4	2	DIN374	
OSG-11-48139241	22	1	125	16	-	18	14,5	4	2	DIN374	
OSG-11-48139249	24	2	140	30	-	18	14,5	4	2	DIN374	
OSG-11-48139250	24	1,5	140	16	-	18	14,5	4	2	DIN374	
OSG-11-48139251	24	1	140	16	-	18	14,5	4	2	DIN374	

Available on request

A-POT

Threading | Cutting taps | Metric Fine

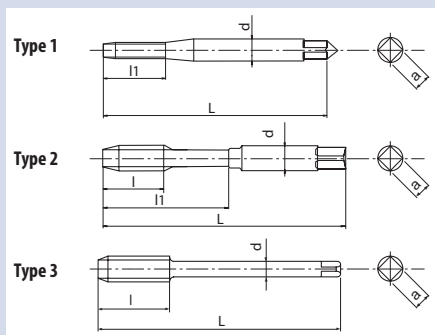


- First choice in quality and performance
- Powder metal spiral-point cutting tap for through holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels

P	P	P	P	M	N	N	S	H	
C<0,2%	0,25<C<0,4	C>0,45%	SCM	INOX	Al	AC,ADC	Ti	25-35 HRC	
15-60	15-60	10-60	8-30	8-20	15-35	15-35	5-10	8-20	m/min

A	MF	PM	V	ISO 2 6HX	B/4	DIN 371	DIN 374
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EDP	MF	P	L	I	I1	d	a	Z	Type	DIN	Price
OSG-11-48145135	2,5	0,35	50	-	9	2,8	2,1	2	1	DIN371	
OSG-11-48145137	2,6	0,35	50	-	9	2,8	2,1	2	1	DIN371	
OSG-11-48145141	3	0,35	56	8	18	3,5	2,7	3	2	DIN371	
OSG-11-48145143	3,5	0,35	56	9	20	4	3	3	2	DIN371	
OSG-11-48145145	4	0,5	63	10	21	4,5	3,4	3	2	DIN371	
OSG-11-48145146	4	0,35	63	10	21	4,5	3,4	3	2	DIN371	
OSG-11-48145148	4,5	0,5	70	12	25	6	4,9	3	2	DIN371	
OSG-11-48145151	5	0,5	70	12	25	6	4,9	3	2	DIN371	
OSG-11-48145601	6	0,75	80	14	30	6	4,9	3	2	DIN371	
OSG-11-48145602	6	0,5	80	14	30	6	4,9	3	2	DIN371	
OSG-11-48145160	7	0,75	80	14	30	7	5,5	3	2	DIN371	
OSG-11-48145603	8	1	90	22	35	8	6,2	3	2	DIN371	
OSG-11-48145604	8	0,75	80	18	30	8	6,2	3	2	DIN371	



EDP	MF	P	L	I	I1	d	a	Z	Type	DIN	Price
OSG-11-48145605	9	1	90	22	35	9	7	3	2	DIN371	
OSG-11-48145606	10	1,25	100	24	39	10	8	3	2	DIN371	
OSG-11-48145607	10	1	90	20	35	10	8	3	2	DIN371	
OSG-11-48145608	10	0,75	90	20	35	10	8	3	2	DIN371	
OSG-11-48145156	6	0,75	80	14	-	4,5	3,4	3	3	DIN374	
OSG-11-48145157	6	0,5	80	14	-	4,5	3,4	3	3	DIN374	
OSG-11-48145162	8	1	90	22	-	6	4,9	3	3	DIN374	
OSG-11-48145163	8	0,75	80	18	-	6	4,9	3	3	DIN374	
OSG-11-48145167	9	1	90	22	-	7	5,5	3	3	DIN374	
OSG-11-48145170	10	1,25	100	24	-	7	5,5	3	3	DIN374	
OSG-11-48145171	10	1	90	20	-	7	5,5	3	3	DIN374	
OSG-11-48145172	10	0,75	90	20	-	7	5,5	3	3	DIN374	
OSG-11-48145176	11	1	90	20	-	8	6,2	3	3	DIN374	
OSG-11-48145180	12	1,5	100	22	-	9	7	3	3	DIN374	
OSG-11-48145181	12	1,25	100	22	-	9	7	3	3	DIN374	
OSG-11-48145182	12	1	100	22	-	9	7	3	3	DIN374	
OSG-11-48145192	14	1,5	100	22	-	11	9	4	3	DIN374	
OSG-11-48145193	14	1,25	100	22	-	11	9	4	3	DIN374	
OSG-11-48145194	14	1	100	22	-	11	9	4	3	DIN374	
OSG-11-48145203	16	1,5	100	22	-	12	9	4	3	DIN374	
OSG-11-48145204	16	1	100	22	-	12	9	4	3	DIN374	
OSG-11-48145216	18	1,5	110	25	-	14	11	4	3	DIN374	
OSG-11-48145218	18	1	110	25	-	14	11	4	3	DIN374	
OSG-11-48145220	20	2	140	34	-	16	12	4	3	DIN374	
OSG-11-48145230	20	1,5	125	25	-	16	12	4	3	DIN374	
OSG-11-48145232	20	1	125	25	-	16	12	4	3	DIN374	
OSG-11-48145239	22	2	140	34	-	18	14,5	4	3	DIN374	
OSG-11-48145240	22	1,5	125	25	-	18	14,5	4	3	DIN374	
OSG-11-48145241	22	1	125	25	-	18	14,5	4	3	DIN374	
OSG-11-48145249	24	2	140	28	-	18	14,5	4	3	DIN374	
OSG-11-48145250	24	1,5	140	28	-	18	14,5	4	3	DIN374	
OSG-11-48145251	24	1	140	28	-	18	14,5	4	3	DIN374	

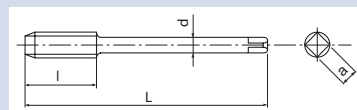
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A-OIL-SFT

Threading | Cutting taps | Metric Fine



- First choice in quality and performance
- Powder metal spiral-fluted cutting tap for blind holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels
- Centre through coolant



P C<0,2%	P 0,25<C<0,4	P C>0,45%	P SCM	M INOX	N AI	N AC/ADC	S Ti	H 25-35 HRC	
15-60	15-60	10-60	8-30	8-20	15-35	15-35	5-10	8-20	m/min
A	MF	PM	V	45°	ISO 2 6HX	C/2,5			DIN 374

EDP	MF	P	L	I	d	a	Z	DIN	Price
OSG-11-48140162	8	1	90	10	6	4,9	3	DIN374	
OSG-11-48140171	10	1	90	10	7	5,5	3	DIN374	
OSG-11-48140170	10	1,25	100	12	7	5,5	3	DIN374	
OSG-11-48140180	12	1,5	100	14	9	7	3	DIN374	
OSG-11-48140192	14	1,5	100	16	11	9	3	DIN374	
OSG-11-48140203	16	1,5	100	16	12	9	3	DIN374	
OSG-11-48140216	18	1,5	110	16	14	11	4	DIN374	
OSG-11-48140230	20	1,5	125	16	16	12	4	DIN374	

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OSG GROUP COMPANY

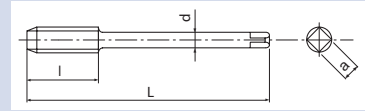
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JUNE 2023 V3 SOMTA CATALOGUE

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A-OIL-POT

Threading | Cutting taps | Metric Fine



- First choice in quality and performance
- Powder metal spiral-point cutting tap for through holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels
- Side through coolant

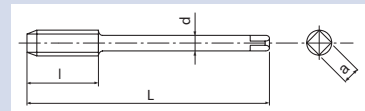
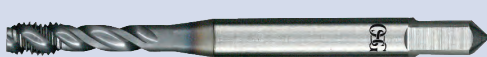
P	P	P	P	M	N	N	S	H	
C<0,2%	0,25<C<0,4	C>0,45%	SCM	INOX	Al	AC,ADC	Ti	25-35 HRC	
15-60	15-60	10-60	8-30	8-20	15-35	15-35	5-10	8-20	m/min
A	MF	PM	V	ISO 2 6HX	B/4			DIN 374	

EDP	MF	P	L	I	d	a	Z	DIN	Price
OSG-11-48214162	8	1	90	22	6	4,9	3	DIN374	
OSG-11-48214171	10	1	90	20	7	5,5	3	DIN374	
OSG-11-48214170	10	1,25	100	24	7	5,5	3	DIN374	
OSG-11-48214180	12	1,5	100	22	9	7	3	DIN374	
OSG-11-48214192	14	1,5	100	22	11	9	4	DIN374	
OSG-11-48214203	16	1,5	100	22	12	9	4	DIN374	
OSG-11-48214216	18	1,5	110	25	14	11	4	DIN374	
OSG-11-48214230	20	1,5	125	25	16	12	4	DIN374	

Available on request

A-SFT 6GX

Threading | Cutting taps | Metric Fine



- First choice in quality and performance
- Powder metal spiral-fluted cutting tap for blind holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels
- For 6G internal thread tolerance

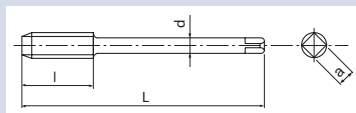
P	P	P	P	M	N	N	S	H	
C<0,2%	0,25<C<0,4	C>0,45%	SCM	INOX	Al	AC,ADC	Ti	25-35 HRC	
15-60	15-60	10-60	8-30	8-20	15-35	15-35	5-10	8-20	m/min
A	MF	PM	V	45°	ISO 3 6GX	C/2,5		DIN 374	

EDP	MF	P	oversize	L	I	d	a	Z	DIN	Price
OSG-11-48201156	6	0,75	+0,022	80	8	4,5	3,4	3	DIN374	
OSG-11-48201162	8	1	+0,026	90	10	6	4,9	3	DIN374	
OSG-11-48201163	8	0,75	+0,022	80	8	6	4,9	3	DIN374	
OSG-11-48201170	10	1,25	+0,028	100	12	7	5,5	3	DIN374	
OSG-11-48201171	10	1	+0,026	90	10	7	5,5	3	DIN374	
OSG-11-48201180	12	1,5	+0,032	100	14	9	7	3	DIN374	
OSG-11-48201181	12	1,25	+0,028	100	12	9	7	3	DIN374	
OSG-11-48201182	12	1	+0,026	100	12	9	7	3	DIN374	
OSG-11-48201192	14	1,5	+0,032	100	16	11	9	3	DIN374	
OSG-11-48201203	16	1,5	+0,032	100	16	12	9	3	DIN374	
OSG-11-48201216	18	1,5	+0,032	110	16	14	11	4	DIN374	
OSG-11-48201230	20	1,5	+0,032	125	16	16	12	4	DIN374	
OSG-11-48201240	22	1,5	+0,032	125	16	18	14,5	4	DIN374	
OSG-11-48201250	24	1,5	+0,032	140	16	18	14,5	4	DIN374	

Available on request

A-POT 6GX

Threading | Cutting taps | Metric Fine



- First choice in quality and performance
- Powder metal spiral-point cutting tap for through holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels
- For 6G internal thread tolerance

P	P	P	P	M	N	N	S	H	
C < 0,2%	0,25 < C < 0,4	C > 0,45%	SCM	INOX	Al	AC, ADC	Ti	25-35 HRC	
15-60	15-60	10-60	8-30	8-20	15-35	15-35	5-10	8-20	m/min

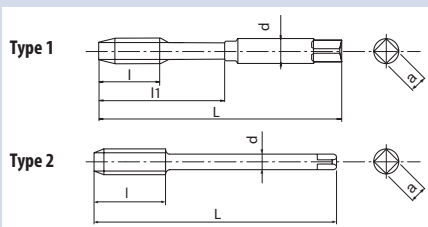
A	MF	PM	V	ISO 3 6GX	B/4	DIN 374
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EDP	MF	P	oversize	L	I	d	a	Z	DIN	Price
OSG-11-48205156	6	0,75	+0,022	80	14	4,5	3,4	3	DIN374	
OSG-11-48205162	8	1	+0,026	80	22	6	4,9	3	DIN374	
OSG-11-48205163	8	0,75	+0,022	80	18	6	4,9	3	DIN374	
OSG-11-48205170	10	1,25	+0,028	90	24	7	5,5	3	DIN374	
OSG-11-48205171	10	1	+0,026	90	20	7	5,5	3	DIN374	
OSG-11-48205180	12	1,5	+0,032	90	22	9	7	3	DIN374	
OSG-11-48205181	12	1,25	+0,028	90	22	9	7	3	DIN374	
OSG-11-48205182	12	1	+0,026	90	22	9	7	3	DIN374	
OSG-11-48205192	14	1,5	+0,032	90	22	11	9	4	DIN374	
OSG-11-48205203	16	1,5	+0,032	100	22	12	9	4	DIN374	
OSG-11-48205216	18	1,5	+0,032	100	25	14	11	4	DIN374	
OSG-11-48205230	20	1,5	+0,032	140	25	16	12	4	DIN374	
OSG-11-48205240	22	1,5	+0,032	140	25	18	14,5	4	DIN374	
OSG-11-48205250	24	1,5	+0,032	140	28	18	14,5	4	DIN374	

Available on request

A-SFT

Threading | Cutting taps | UNC



- First choice in quality and performance
- Powder metal spiral-fluted cutting tap for blind holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels

P	P	P	P	M	N	N	S	H	
C < 0,2%	0,25 < C < 0,4	C > 0,45%	SCM	INOX	Al	AC, ADC	Ti	25-35 HRC	
15-60	15-60	10-60	8-30	8-20	15-35	15-35	5-10	8-20	m/min

A	UNC	PM	V	45°	ANSI 2BX	C/2,5	DIN 2184-1	DIN 2184-1
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EDP	UNC	P	L	I	I1	d	a	Z	Type	DIN	Price
OSG-11-48139453	No. 2	56	45	3,6	11	2,8	2,1	2	1	DIN2184-1	
OSG-11-48139455	No. 3	48	50	3,6	13	2,8	2,1	2	1	DIN2184-1	
OSG-11-48139457	No. 4	40	56	5,1	18	3,5	2,7	2	1	DIN2184-1	
OSG-11-48139459	No. 5	40	56	5,1	18	3,5	2,7	2	1	DIN2184-1	
OSG-11-48139461	No. 6	32	56	6,4	20	4	3	2	1	DIN2184-1	
OSG-11-48139464	No. 8	32	63	6,4	21	4,5	3,4	2	1	DIN2184-1	



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EDP	UNC	P	L	I	I1	d	a	Z	Type	DIN	Price
OSG-11-48139466	No. 10	24	70	8,5	25	6	4,9	2	1	DIN2184-1	
OSG-11-48139468	No. 12	24	80	8,5	30	6	4,9	2	1	DIN2184-1	
OSG-11-48139471	1/4	20	80	10,2	30	7	5,5	2	1	DIN2184-1	
OSG-11-48139474	5/16	18	90	11,3	35	8	6,2	3	1	DIN2184-1	
OSG-11-48139479	3/8	16	100	12,7	39	10	8	3	1	DIN2184-1	
OSG-11-48139484	7/16	14	100	14,5	-	8	6,2	3	2	DIN2184-1	
OSG-11-48139489	1/2	13	110	15,6	-	9	7	3	2	DIN2184-1	
OSG-11-48139494	9/16	12	110	16,9	-	11	9	3	2	DIN2184-1	
OSG-11-48139501	5/8	11	110	18,5	-	12	9	3	2	DIN2184-1	
OSG-11-48139515	3/4	10	125	25,4	-	14	11	4	2	DIN2184-1	
OSG-11-48139526	7/8	9	140	28,2	-	18	14,5	4	2	DIN2184-1	
OSG-11-48139538	1"	8	160	31,8	-	18	14,5	4	2	DIN2184-1	

Available on request

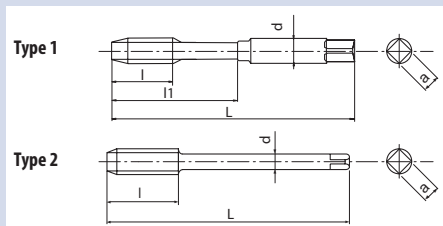
A-POT

Threading | Cutting taps | UNC



- First choice in quality and performance
- Powder metal spiral-point cutting tap for through holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels

P	P	P	P	M	N	N	S	H	
C < 0.2%	0.25 < C < 0.4	C > 0.45%	SCM	INOX	Al	AC/ADC	Ti	25-35 HRC	
15-60	15-60	10-60	8-30	8-20	15-35	15-35	5-10	8-20	m/min



EDP	UNC	P	L	I	I1	d	a	Z	Type	DIN	Price
OSG-11-48145453	No. 2	56	45	-	9	2,8	2,1	2	1	DIN2184-1	
OSG-11-48145455	No. 3	48	50	-	9	2,8	2,1	2	1	DIN2184-1	
OSG-11-48145457	No. 4	40	56	11	18	3,5	2,7	2	1	DIN2184-1	
OSG-11-48145459	No. 5	40	56	11	18	3,5	2,7	3	1	DIN2184-1	
OSG-11-48145461	No. 6	32	56	12	20	4	3	3	1	DIN2184-1	
OSG-11-48145464	No. 8	32	63	13	21	4,5	3,4	3	1	DIN2184-1	
OSG-11-48145466	No. 10	24	70	16	25	6	4,9	3	1	DIN2184-1	
OSG-11-48145468	No. 12	24	80	17	30	6	4,9	3	1	DIN2184-1	
OSG-11-48145471	1/4	20	80	19	30	7	5,5	3	1	DIN2184-1	
OSG-11-48145474	5/16	18	90	22	35	8	6,2	3	1	DIN2184-1	
OSG-11-48145479	3/8	16	100	24	39	10	8	3	1	DIN2184-1	
OSG-11-48145484	7/16	14	100	24	-	8	6,2	3	2	DIN2184-1	
OSG-11-48145489	1/2	13	110	28	-	9	7	3	2	DIN2184-1	
OSG-11-48145494	9/16	12	110	30	-	11	9	3	2	DIN2184-1	
OSG-11-48145501	5/8	11	110	32	-	12	9	3	2	DIN2184-1	
OSG-11-48145515	3/4	10	125	34	-	14	11	3	2	DIN2184-1	
OSG-11-48145526	7/8	9	140	34	-	18	14,5	3	2	DIN2184-1	
OSG-11-48145538	1"	8	160	38	-	18	14,5	3	2	DIN2184-1	

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AD & ADO SERIES page 99-101 & 106-114

High Performance Threading | Cutting taps

A-SFT / A-POT UNC

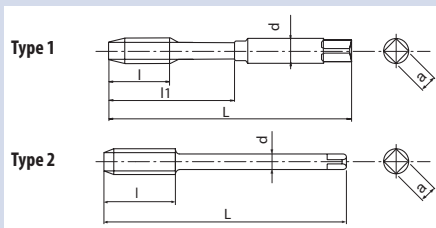
A-SFT

Threading | Cutting taps | UNF



- First choice in quality and performance
- Powder metal spiral-fluted cutting tap for blind holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels

P	P	P	P	M	N	N	S	H	
C<0,2%	0,25<C<0,4	C>0,45%	SCM	INOX	Al	AC,ADC	Ti	25-35 HRC	
15-60	15-60	10-60	8-30	8-20	15-35	15-35	5-10	8-20	m/min
A	UNF	PM	V	45°	ANSI 2BX	C/2,5	DIN 2184-1	DIN 2184-1	



EDP	UNF	P	L	I	I1	d	a	Z	Type	DIN	Price
OSG-11-48139454	No. 2	64	45	3,6	11	2,8	2,1	2	1	DIN2184-1	
OSG-11-48139456	No. 3	56	50	3,6	13	2,8	2,1	2	1	DIN2184-1	
OSG-11-48139458	No. 4	48	56	5,1	18	3,5	2,7	2	1	DIN2184-1	
OSG-11-48139460	No. 5	44	56	5,1	18	3,5	2,7	2	1	DIN2184-1	
OSG-11-48139462	No. 6	40	56	6,4	20	4	3	2	1	DIN2184-1	
OSG-11-48139465	No. 8	36	63	6,4	21	4,5	3,4	2	1	DIN2184-1	
OSG-11-48139467	No. 10	32	70	8,5	25	6	4,9	2	1	DIN2184-1	
OSG-11-48139469	No. 12	28	80	8,5	30	6	4,9	2	1	DIN2184-1	
OSG-11-48139472	1/4	28	80	10,2	30	7	5,5	2	1	DIN2184-1	
OSG-11-48139476	5/16	24	90	11,3	35	8	6,2	3	1	DIN2184-1	
OSG-11-48139481	3/8	24	90	12,7	35	10	8	3	1	DIN2184-1	
OSG-11-48139486	7/16	20	100	14,5	-	8	6,2	3	2	DIN2184-1	
OSG-11-48139491	1/2	20	100	15,6	-	9	7	3	2	DIN2184-1	
OSG-11-48139496	9/16	18	100	16,9	-	11	9	3	2	DIN2184-1	
OSG-11-48139504	5/8	18	100	18,5	-	12	9	3	2	DIN2184-1	
OSG-11-48139517	3/4	16	110	25,4	-	14	11	4	2	DIN2184-1	
OSG-11-48139528	7/8	14	125	28,2	-	18	14,5	4	2	DIN2184-1	
OSG-11-48139539	1"	12	140	31,8	-	18	14,5	4	2	DIN2184-1	

Available on request

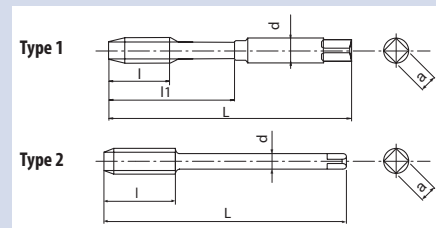
A-POT

Threading | Cutting taps | UNF



- First choice in quality and performance
- Powder metal spiral-point cutting tap for through holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels

P	P	P	P	M	N	N	S	H	
C<0,2%	0,25<C<0,4	C>0,45%	SCM	INOX	Al	AC,ADC	Ti	25-35 HRC	
15-60	15-60	10-60	8-30	8-20	15-35	15-35	5-10	8-20	m/min
A	UNF	PM	V	ANSI 2BX	B/4	DIN 2184-1	DIN 2184-1		



EDP	UNF	P	L	I	I1	d	a	Z	Type	DIN	Price
OSG-11-48145454	No. 2	64	45	-	9	2,8	2,1	2	1	DIN2184-1	

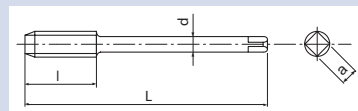


EDP	UNF	P	L	I	l1	d	a	Z	Type	DIN	Price
OSG-11-48145456	No. 3	56	50	-	9	2,8	2,1	2	1	DIN2184-1	
OSG-11-48145458	No. 4	48	56	11	18	3,5	2,7	2	1	DIN2184-1	
OSG-11-48145460	No. 5	44	56	11	18	3,5	2,7	3	1	DIN2184-1	
OSG-11-48145462	No. 6	40	56	12	20	4	3	3	1	DIN2184-1	
OSG-11-48145465	No. 8	36	63	13	21	4,5	3,4	3	1	DIN2184-1	
OSG-11-48145467	No. 10	32	70	16	25	6	4,9	3	1	DIN2184-1	
OSG-11-48145469	No. 12	28	80	17	30	6	4,9	3	1	DIN2184-1	
OSG-11-48145472	1/4	28	80	19	30	7	5,5	3	1	DIN2184-1	
OSG-11-48145476	5/16	24	90	22	35	8	6,2	3	1	DIN2184-1	
OSG-11-48145481	3/8	24	90	20	35	10	8	3	1	DIN2184-1	
OSG-11-48145486	7/16	20	100	24	-	8	6,2	3	2	DIN2184-1	
OSG-11-48145491	1/2	20	100	22	-	9	7	3	2	DIN2184-1	
OSG-11-48145496	9/16	18	100	22	-	11	9	3	2	DIN2184-1	
OSG-11-48145504	5/8	18	100	22	-	12	9	3	2	DIN2184-1	
OSG-11-48145517	3/4	16	110	25	-	14	11	3	2	DIN2184-1	
OSG-11-48145528	7/8	14	125	25	-	18	14,5	3	2	DIN2184-1	
OSG-11-48145539	1"	12	140	28	-	18	14,5	3	2	DIN2184-1	

Available on request

A-SFT

Threading | Cutting taps | G (BSP)



- First choice in quality and performance
- Powder metal spiral-fluted cutting tap for blind holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels

P	P	P	P	M	N	N	S	H	
C<0.2%	0.25<C<0.4	C>0.45%	SCM	INOX	Al	AC,ADC	Ti	25-35 HRC	
15-60	15-60	10-60	8-30	8-20	15-35	15-35	5-10	8-20	m/min
A	G	PM	V	45°	C/2,5	DIN 5156			

EDP	G	P	L	I	d	a	Z	DIN	Price
OSG-11-48139900	1/8	28	90	20	7	5,5	3	DIN5156	
OSG-11-48139000	1/4	19	100	22	11	9	3	DIN5156	
OSG-11-48139100	3/8	19	100	22	12	9	4	DIN5156	



ADO-SUS SERIES page 102-105

High Performance Threading | Cutting taps



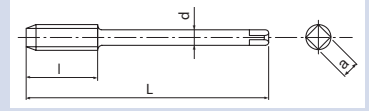
A-POT UNF / A-SFT G (BSP)

EDP	G	P	L	I	d	a	Z	DIN	Price
OSG-11-48139200	1/2	14	125	25	16	12	4	DIN5156	
OSG-11-48139300	5/8	14	125	25	18	14,5	4	DIN5156	
OSG-11-48139400	3/4	14	140	28	20	16	4	DIN5156	
OSG-11-48139500	7/8	14	150	28	22	18	4	DIN5156	
OSG-11-48139600	1"	11	160	30	25	20	4	DIN5156	

Available on request

A-POT

Threading | Cutting taps | G (BSP)



- First choice in quality and performance
- Powder metal spiral-point cutting tap for through holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels

P	P	P	P	M	N	N	S	H	
C<0,2%	0,25<C<0,4	C>0,45%	SCM	INOX	Al	AC,ADC	Ti	25-35 HRC	
15-60	15-60	10-60	8-30	8-20	15-35	15-35	5-10	8-20	m/min

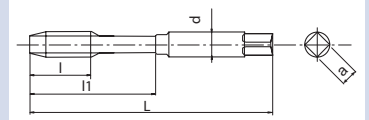


EDP	G	P	L	I	d	a	Z	DIN	Price
OSG-11-48145900	1/8	28	90	20	7	5,5	3	DIN5156	
OSG-11-48145000	1/4	19	100	22	11	9	3	DIN5156	
OSG-11-48145100	3/8	19	100	22	12	9	3	DIN5156	
OSG-11-48145200	1/2	14	125	25	16	12	3	DIN5156	
OSG-11-48145300	5/8	14	125	25	18	14,5	4	DIN5156	
OSG-11-48145400	3/4	14	140	28	20	16	4	DIN5156	
OSG-11-48145500	7/8	14	150	28	22	18	4	DIN5156	
OSG-11-48145600	1"	11	160	30	25	20	4	DIN5156	

Available on request

A-SFT

Threading | Cutting taps | BSW



- First choice in quality and performance
- Powder metal spiral-fluted cutting tap for blind holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels

P	P	P	P	M	N	N	S	H	
C<0,2%	0,25<C<0,4	C>0,45%	SCM	INOX	Al	AC,ADC	Ti	25-35 HRC	
15-60	15-60	10-60	8-30	8-20	15-35	15-35	5-10	8-20	m/min



EDP	BSW	TPI	L	I	I1	d	a	Z	DIN	Price
OSG-11-48139702	1/8	40	56	7	18	3,5	2,7	2	DIN2184-1	
OSG-11-48139704	3/16	24	70	10	25	6	4,9	2	DIN2184-1	
OSG-11-48139706	1/4	20	80	13	30	7	5,5	2	DIN2184-1	
OSG-11-48139707	5/16	18	90	14	35	8	6,2	3	DIN2184-1	
OSG-11-48139708	3/8	16	100	16	39	10	8	3	DIN2184-1	
OSG-11-48139709	7/16	14	100	22	-	8	6,2	3	DIN2184-1	
OSG-11-48139710	1/2	12	110	25	-	9	7	3	DIN2184-1	
OSG-11-48139712	5/8	11	110	27	-	12	9	3	DIN2184-1	



EDP	BSW	TPI	L	I	I1	d	a	Z	DIN	Price
OSG-11-48139713	3/4	10	125	30	-	14	11	4	DIN2184-1	
OSG-11-48139714	7/8	9	140	32	-	18	14,5	4	DIN2184-1	
OSG-11-48139715	1"	8	160	36	-	18	14,5	4	DIN2184-1	

Available on request

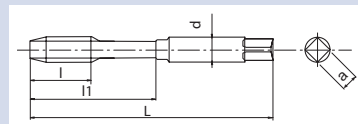
A-POT

Threading | Cutting taps | BSW



- First choice in quality and performance
- Powder metal spiral-point cutting tap for through holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels

P	P	P	P	M	N	N	S	H	
C<0,2%	0,25<C<0,4	C>0,45%	SCM	INOX	Al	AC/ADC	Ti	25-35 HRC	
15-60	15-60	10-60	8-30	8-20	15-35	15-35	5-10	8-20	m/min
A	BSW	PM	V	MED	B/4				DIN 2184-1



EDP	BSW	TPI	L	I	I1	d	a	Z	DIN	Price
OSG-11-48205702	1/8	40	56	11	18	3,5	2,7	3	DIN2184-1	
OSG-11-48205704	3/16	24	70	16	25	6	4,9	3	DIN2184-1	
OSG-11-48205706	1/4	20	80	19	30	7	5,5	3	DIN2184-1	
OSG-11-48205707	5/16	18	90	22	35	8	6,2	3	DIN2184-1	
OSG-11-48205708	3/8	16	100	24	39	10	8	3	DIN2184-1	
OSG-11-48205709	7/16	14	100	24	-	8	6,2	3	DIN2184-1	
OSG-11-48205710	1/2	12	110	28	-	9	7	3	DIN2184-1	
OSG-11-48205712	5/8	11	110	32	-	12	9	3	DIN2184-1	
OSG-11-48205713	3/4	10	125	34	-	14	11	3	DIN2184-1	
OSG-11-48205714	7/8	9	140	34	-	18	14,5	3	DIN2184-1	
OSG-11-48205715	1"	8	160	38	-	18	14,5	3	DIN2184-1	

Available on request

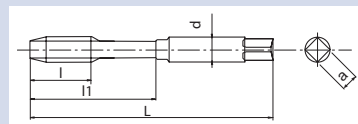
A-SFT

Threading | Cutting taps | BSF



- First choice in quality and performance
- Powder metal spiral-fluted cutting tap for blind holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels

P	P	P	P	M	N	N	S	H	
C<0,2%	0,25<C<0,4	C>0,45%	SCM	INOX	Al	AC/ADC	Ti	25-35 HRC	
15-60	15-60	10-60	8-30	8-20	15-35	15-35	5-10	8-20	m/min
A	BSF	PM	V	MED	C/2,5				DIN 2184-1



EDP	BSF	TPI	L	I	I1	d	a	Z	DIN	Price
OSG-11-48139731	1/4	26	80	17	30	7	5,5	3	DIN2184-1	
OSG-11-48139732	5/16	22	90	17	35	8	6,2	3	DIN2184-1	
OSG-11-48139733	3/8	20	100	18	39	10	8	3	DIN2184-1	
OSG-11-48139734	7/16	18	100	22	-	8	6,2	3	DIN2184-1	
OSG-11-48139735	1/2	16	100	22	-	9	7	3	DIN2184-1	
OSG-11-48139737	5/8	14	110	27	-	12	9	3	DIN2184-1	
OSG-11-48139739	3/4	12	125	27	-	14	11	3	DIN2184-1	

High Performance Threading | Cutting taps

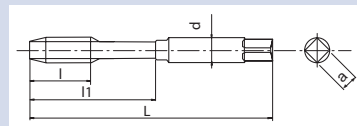
A-SFT / A-POT BSW / A-SFT BSF

EDP	BSF	TPI	L	I	I1	d	a	Z	DIN	Price
OSG-11-48139742	1"	10	160	36	-	18	14,5	3	DIN2184-1	

Available on request

A-POT

Threading | Cutting taps | BSF



- First choice in quality and performance
- Powder metal spiral-point cutting tap for through holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels

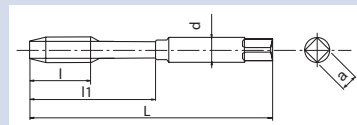
P C<0,2%	P 0,25<C<0,4	P C>0,45%	P SCM	M INOX	N AI	N AC,ADC	S Ti	H 25-35 HRC		
15-60	15-60	10-60	8-30	8-20	15-35	15-35	5-10	8-20	m/min	
A	BSF	PM	V	MED	B/4	DIN 2184-1				

EDP	BSF	TPI	L	I	I1	d	a	Z	DIN	Price
OSG-11-48205731	1/4	26	80	19	30	7	5,5	3	DIN2184-1	
OSG-11-48205732	5/16	22	90	22	35	8	6,2	3	DIN2184-1	
OSG-11-48205733	3/8	20	100	24	39	10	8	3	DIN2184-1	
OSG-11-48205734	7/16	18	100	24	-	8	6,2	3	DIN2184-1	
OSG-11-48205735	1/2	16	100	22	-	9	7	3	DIN2184-1	
OSG-11-48205737	5/8	14	110	32	-	12	9	3	DIN2184-1	
OSG-11-48205739	3/4	12	125	34	-	14	11	3	DIN2184-1	
OSG-11-48205742	1"	10	160	38	-	18	14,5	3	DIN2184-1	

Available on request

A-SFT

Threading | Cutting taps | BA



- First choice in quality and performance
- Powder metal spiral-fluted cutting tap for blind holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels

P C<0,2%	P 0,25<C<0,4	P C>0,45%	P SCM	M INOX	N AI	N AC,ADC	S Ti	H 25-35 HRC		
15-60	15-60	10-60	8-30	8-20	15-35	15-35	5-10	8-20	m/min	
A	BA (BS93)	PM	V	C/2,5						

EDP	BA	L	I	I1	d	a	Z	Price
OSG-11-48139910	No. 0	66	19	30	6,3	5	3	
OSG-11-48139911	No. 1	62	17	26	5,6	4,5	3	
OSG-11-48139912	No. 2	58	16	25	5	4	3	
OSG-11-48139913	No. 3	53	13	21	4,5	3,55	2	
OSG-11-48139914	No. 4	50	13	20	3,55	2,8	2	
OSG-11-48139915	No. 5	48	11	18	3,15	2,5	2	
OSG-11-48139916	No. 6	44,5	9,5	-	2,8	2,24	2	
OSG-11-48139917	No. 7	44,5	9,5	-	2,8	2,24	2	
OSG-11-48139918	No. 8	44,5	9,5	-	2,8	2,24	2	
OSG-11-48139919	No. 9	41	8	-	2,5	2	2	
OSG-11-48139920	No. 10	41	8	-	2,5	2	2	
OSG-11-48139921	No. 11	41	8	-	2,5	2	2	



EDP	BA	L	I	I1	d	a	Z	Price
OSG-11-48139922	No. 12	40	7	-	2,5	2	2	

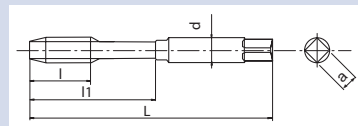
Available on request

A-POT

Threading | Cutting taps | BA



- First choice in quality and performance
- Powder metal spiral-point cutting tap for through holes
- Multilayer TiCN coating
- High speed tapping in general steels, aluminium, stainless steels



P	P	P	P	M	N	N	S	H	
C<0,2%	0,25<C<0,4	C>0,45%	SDM	INOX	Al	AC,ADC	Ti	25-35 HRC	
15-60	15-60	10-60	8-30	8-20	15-35	15-35	5-10	8-20	m/min



EDP	BA	L	I	I1	d	a	Z	Price
OSG-11-48205910	No. 0	66	19	30	6,3	5	3	
OSG-11-48205911	No. 1	62	17	26	5,6	4,5	3	
OSG-11-48205912	No. 2	58	16	25	5	4	3	
OSG-11-48205913	No. 3	53	13	21	4,5	3,55	3	
OSG-11-48205914	No. 4	50	13	20	3,55	2,8	3	
OSG-11-48205915	No. 5	48	11	18	3,15	2,5	3	
OSG-11-48205916	No. 6	44,5	9,5	-	2,8	2,24	2	
OSG-11-48205917	No. 7	44,5	9,5	-	2,8	2,24	2	
OSG-11-48205918	No. 8	44,5	9,5	-	2,8	2,24	2	
OSG-11-48205919	No. 9	41	8	-	2,5	2	2	
OSG-11-48205920	No. 10	41	8	-	2,5	2	2	
OSG-11-48205921	No. 11	41	8	-	2,5	2	2	
OSG-11-48205922	No. 12	40	7	-	2,5	2	2	

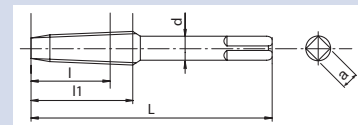
Available on request

A-TPT

Threading | Cutting taps | RC (BSPT)



- First choice in quality and performance
- Powder metal straight flute cutting tap for through & blind holes
- Multilayer TiCN coating
- High speed tapping in general steels and aluminium
- RC (BSPT) tapered 1:16



P	P	P	P	N	N	
C<0,2%	0,25<C<0,4	C>0,45%	SDM	Al	AC,ADC	
5-10	5-10	5-10	5-10	5-10	10-15	m/min



EDP	RC	I1	L	I	d	a	Z	DIN	Price
OSG-11-48212384	1/8	28	90	15	7	5,5	4	DIN5156	
OSG-11-48212394	1/4	19	100	19	11	9	4	DIN5156	
OSG-11-48212404	3/8	19	110	21	12	9	4	DIN5156	
OSG-11-48212414	1/2	14	125	26	16	12	4	DIN5156	
OSG-11-48212434	3/4	14	140	28	20	16	4	DIN5156	
OSG-11-48212454	1"	11	160	33	25	20	4	DIN5156	

Available on request

High Performance Threading | Cutting taps

A-SFT / A-POT BA / A-TPT RC (BSPT)



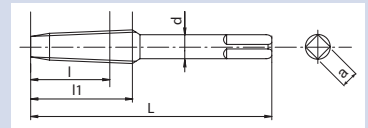
shaping your dreams

A-SFT

Threading | Cutting taps | RC (BSPT)



- First choice in quality and performance
- Powder metal spiral flute cutting tap for blind holes
- Multilayer TiCN coating
- High speed tapping in general steels and aluminium
- RC (BSPT) tapered 1:16



P	P	P	P	N	N	
C < 0,2%	0,25 < C < 0,4	C > 0,45%	SCM	Al	AC/ADC	
5-10	5-10	5-10	5-10	5-10	10-15	m/min

A	Rc (PT)	PM	V	45°	C/2,5	DIN 5156
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EDP	RC	P	L	I	d	a	I1	Z	DIN	Price
OSG-11-48302374	1/16	28	90	10,1	6	4,9	14	3	DIN5156	
OSG-11-48302384	1/8	28	90	10,1	7	5,5	15	3	DIN5156	
OSG-11-48302394	1/4	19	100	15	11	9	19	3	DIN5156	
OSG-11-48302404	3/8	19	100	15,4	12	9	21	4	DIN5156	
OSG-11-48302414	1/2	14	125	20,5	16	12	26	4	DIN5156	
OSG-11-48302434	3/4	14	140	21,8	20	16	28	4	DIN5156	
OSG-11-48302454	1"	11	160	26	25	23	33	4	DIN5156	

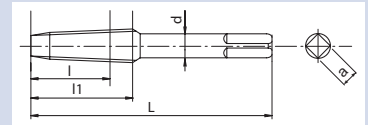
Available on request

A-SFT

Threading | Cutting taps | NPT



- First choice in quality and performance
- Powder metal spiral flute cutting tap for blind holes
- Multilayer TiCN coating
- High speed tapping in general steels and aluminium
- NPT tapered 1:16

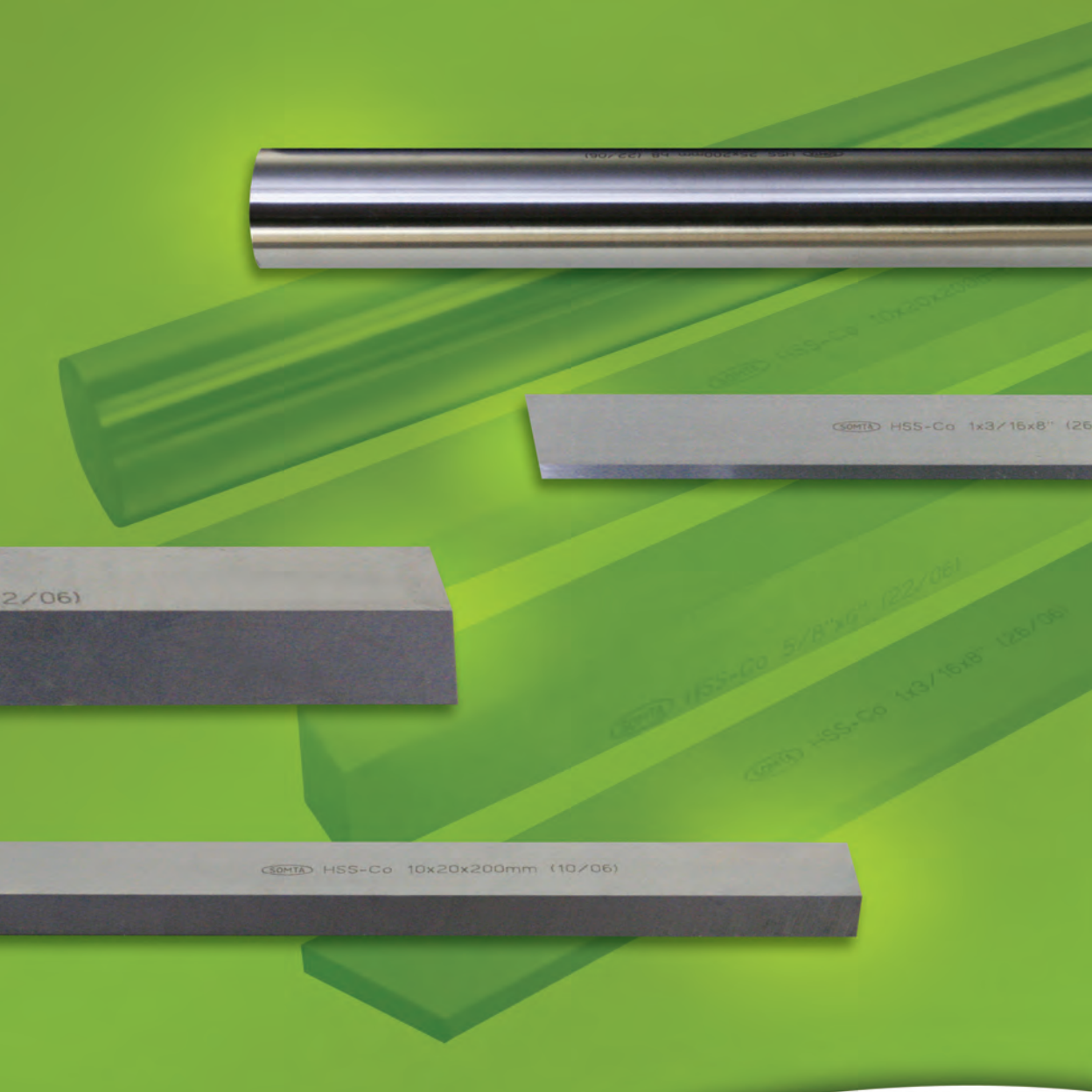


P	P	P	P	N	N	
C < 0,2%	0,25 < C < 0,4	C > 0,45%	SCM	Al	AC/ADC	
5-10	5-10	5-10	5-10	5-10	10-15	m/min

A	NPT	PM	V	45°	C/2,5	DIN 5156
----------	------------	-----------	----------	------------	--------------	-----------------

EDP	NPT	P	L	I	d	a	I1	Z	DIN	Price
OSG-11-48331500	1/16	27	90	12	6	4,9	18	3	DIN5156	
OSG-11-48331600	1/8	27	90	12,05	7	5,5	19	3	DIN5156	
OSG-11-48331700	1/4	18	100	17,45	11	9	28	3	DIN5156	
OSG-11-48331800	3/8	18	110	17,65	12	9	28	4	DIN5156	
OSG-11-48331900	1/2	14	125	22,85	16	12	35	4	DIN5156	
OSG-11-48331000	3/4	14	140	22,95	20	16	35	4	DIN5156	
OSG-11-48331100	1"	11 1/2	160	27,4	25	20	45	4	DIN5156	

Available on request



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OSG GROUP COMPANY

TOOLBITS & MISCELLANEOUS



OSG GROUP COMPANY

Square Toolbits

Blanks for the manufacture of tools for high tensile and heat resistant steels where high temperatures and abrasion may be expected during machining, 10° bevel at both ends.



Code
601

P	M	K	Ti	Ni	Cu	N	Syn	H
1.1 1.2 1.3 1.4 1.5 1.6	2.1 2.2 2.3 2.4	3.1 3.2 3.3 3.4	4.1 4.2 4.3	5.1 5.2 5.3	6.1 6.2 6.3 6.4	7.1 7.2 7.3 7.4	8.1 8.2 8.3	9.1 9.2 9.3 9.4
● ● ● ● ○		● ● ○ ○			○ ○ ○ ○	○ ○ ○ ○		

Properties		
mm	BASED ON ISO 5421	HSS
W h 13		

W	L	Code	Price	W	L	Code	Price
4	63	6010025		10	100	6010140	
5	63	6010034		10	160	6010150	
6	63	6010050		10	200	6010152	
6	80	6010060		12	80	6010160	
6	100	6010070		12	100	6010170	
6	200	6010085		12	160	6010191	
8	63	6010090		12	200	6010192	
8	80	6010100		16	100	6010200	
8	100	6010110		16	160	6010220	
8	160	6010120		16	200	6010222	
8	200	6010122		20	160	6010256	
10	63	6010125		20	200	6010267	
10	80	6010130		25	200	6010290	

Code
602

Square Toolbits

Blanks for the manufacture of tools for high tensile and heat resistant steels where high temperatures and abrasion may be expected during machining, 10° bevel at both ends.



Properties		
inch	BASED ON ISO 5421	HSS
W h 13		

P	M	K	Ti	Ni	Cu	N	Syn	H
1.1 1.2 1.3 1.4 1.5 1.6	2.1 2.2 2.3 2.4	3.1 3.2 3.3 3.4	4.1 4.2 4.3	5.1 5.2 5.3	6.1 6.2 6.3 6.4	7.1 7.2 7.3 7.4	8.1 8.2 8.3	9.1 9.2 9.3 9.4
● ● ● ● ○		● ● ○ ○			○ ○ ○ ○	○ ○ ○ ○		

W	L	Code	Price	W	L	Code	Price
3/16	2.1/2	6020010		7/16	3.1/2	6020110	
1/4	2.1/2	6020020		1/2	4"	6020120	
1/4	3"	6020025		1/2	6"	6020130	
1/4	4"	6020030		1/2	8"	6020140	
5/16	2.1/2	6020050		5/8	4.1/2	6020155	
5/16	3"	6020052		5/8	6"	6020160	
5/16	4"	6020060		5/8	8"	6020170	
3/8	3"	6020080		3/4	5"	6020180	
3/8	4"	6020090		3/4	6"	6020190	
3/8	6"	6020095					



TOOLBITS &
MISCELLANEOUS



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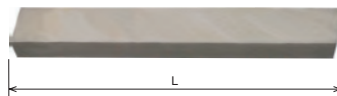
298

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Square Toolbits

Blanks for the manufacture of tools for high tensile and heat resistant steels where high temperatures and abrasion may be expected during machining, 10° bevel at both ends.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

W	L	Code	Price	W	L	Code	Price
5	40	6210030		12	80	6210160	
6	100	6210070		12	100	6210170	
6	200	6210085		12	160	6210180	
8	100	6210110		12	200	6210195	
8	160	6210120		16	100	6210200	
8	200	6210122		16	160	6210220	
10	63	6210125		16	200	6210224	
10	100	6210140		20	160	6210258	
10	160	6210150		20	200	6210290	
10	200	6210152		25	200	6210300	

Code

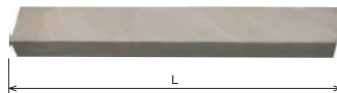
621

Properties

mm	BASED ON ISO 5421	HSS Co8
W h 13		

Square Toolbits

Blanks for the manufacture of tools for high tensile and heat resistant steels where high temperatures and abrasion may be expected during machining, 10° bevel at both ends.



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

W	L	Code	Price	W	L	Code	Price
3/16	2.1/2	6220010		3/8	8"	6220100	
1/4	2.1/2	6220020		1/2	4"	6220120	
1/4	3"	6220022		1/2	6"	6220130	
1/4	4"	6220030		1/2	8"	6220140	
5/16	2.1/2	6220050		5/8	4"	6220150	
5/16	4"	6220060		5/8	6"	6220160	
5/16	8"	6220070		3/4	5"	6220180	
3/8	3"	6220080		3/4	6"	6220190	
3/8	4"	6220085		1"	8"	6220250	
3/8	6"	6220095					

Code

622

Properties

inch	BASED ON ISO 5421	HSS Co8
W h 13		





OSG GROUP COMPANY

Round Toolbits

Blanks for the manufacture of tools for high tensile and heat resistant steels where high temperatures and abrasion may be expected during machining.



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	○					●	●	○	○							○	○	○	○	○	○	○	○							

d	L	Code	Price	d	L	Code	Price
4	100	6050032		10	100	6050140	
5	100	6050037		10	160	6050150	
6	100	6050070		12	100	6050170	
6	200	6050085		16	100	6050200	
8	100	6050110		20	200	6050258	

Code

605

Properties

mm
BASED ON
ISO 5421
HSS

h8 (d)

Round Toolbits

Blanks for the manufacture of tools for high tensile and heat resistant steels where high temperatures and abrasion may be expected during machining.



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	○					●	●	○	○							○	○	○	○	○	○	○	○							

d	L	Code	Price	d	L	Code	Price
1/4	4"	6060070		1/2	4"	6060170	
5/16	4"	6060110		5/8	4"	6060200	
3/8	4"	6060140					

Code

625

Properties

mm
BASED ON
ISO 5421
HSS Co8

h8 (d)

Round Toolbits

Blanks for the manufacture of tools for high tensile and heat resistant steels where high temperatures and abrasion may be expected during machining.



P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	●	●			●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○				

d	L	Code	Price	d	L	Code	Price
4	100	6250032		10	160	6250145	
5	100	6250038		10	200	6250150	
6	100	6250070		12	100	6250170	
6	200	6250085		12	200	6250192	
8	100	6250110		16	160	6250240	
8	160	6250120		20	200	6250253	
8	200	6250122		25	200	6250255	
10	100	6250140					



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300

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TOOLBITS &
MISCELLANEOUS

Double Bevel Parting Blades

For parting off and slotting applications, with increased wear resistance.



P					M				K				Ti			Ni				Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

b	h	L	Code	Price	b	h	L	Code	Price
3	12	120	6440010		3	20	140	6440070	
3	16	140	6440030		4	20	140	6440080	
4	18	140	6440060						

Code

644

Properties

mm	ISO 5421	HSS Co8
h 13		

Double Bevel Parting Blades

For parting off and slotting applications, with increased wear resistance.



P					M				K				Ti			Ni				Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
●	●	●	●	●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

b	h	L	Code	Price	b	h	L	Code	Price
3/32	1/2	4 1/2	6470005		1/8	7/8	6"	6470030	
3/32	5/8	5"	6470008		1/8	7/8	7"	6470035	
1/8	5/8	6"	6470010		3/16	1"	8"	6470060	
1/8	3/4	6"	6470020						

Code

647

Properties

inch	ISO 5421	HSS Co8
h 13		

Hi-Cut

Chassis Punches

Used for punching holes in sheetmetal up to 1.6mm in thickness.



P					M				K				Ti			Ni				Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

Size	Code	Price	Size	Code	Price
12.7	9901270		37.5	9903750	
19	9901900		45	9904500	
20	9902000		51	9905100	
35	9903500				

Not available once current stock is depleted

Code










990

Core Drill Cutters (Sluggers) with Pilot Pin

For cutting holes in various materials with high speed.



Vc: m/min

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
																																		
35	30	30	30	25	20	15	20	15	10					40	40	30	30	25																

Size	Cutter Length	Pilot Pin	Code	Price	Size	Cutter Length	Pilot Pin	Code	Price
------	---------------	-----------	------	-------	------	---------------	-----------	------	-------

Regular Length

12	25	6.35x77	9RA1200		39	25	6.35x77	9RA3900	
13	25	6.35x77	9RA1300		40	25	6.35x77	9RA4000	
14	25	6.35x77	9RA1400		41	25	6.35x77	9RA4100	
15	25	6.35x77	9RA1500		42	25	6.35x77	9RA4200	
16	25	6.35x77	9RA1600		43	25	6.35x77	9RA4300	
17	25	6.35x77	9RA1700		44	25	6.35x77	9RA4400	
18	25	6.35x77	9RA1800		45	25	6.35x77	9RA4500	
19	25	6.35x77	9RA1900		46	25	6.35x77	9RA4600	
20	25	6.35x77	9RA2000		47	25	6.35x77	9RA4700	
21	25	6.35x77	9RA2100		48	25	6.35x77	9RA4800	
22	25	6.35x77	9RA2200		49	25	6.35x77	9RA4900	
23	25	6.35x77	9RA2300		50	25	6.35x77	9RA5000	
24	25	6.35x77	9RA2400		51	25	6.35x77	9RA5100	
25	25	6.35x77	9RA2500		52	25	6.35x77	9RA5200	
26	25	6.35x77	9RA2600		53	25	6.35x77	9RA5300	
27	25	6.35x77	9RA2700		54	25	6.35x77	9RA5400	
28	25	6.35x77	9RA2800		55	25	6.35x77	9RA5500	
29	25	6.35x77	9RA2900		56	25	6.35x77	9RA5600	
30	25	6.35x77	9RA3000		57	25	6.35x77	9RA5700	
31	25	6.35x77	9RA3100		58	25	6.35x77	9RA5800	
32	25	6.35x77	9RA3200		59	25	6.35x77	9RA5900	
33	25	6.35x77	9RA3300		60	25	6.35x77	9RA6000	
34	25	6.35x77	9RA3400		61	25	8x90	9RA6100	
35	25	6.35x77	9RA3500		62	25	8x90	9RA6200	
36	25	6.35x77	9RA3600		63	25	8x90	9RA6300	
37	25	6.35x77	9RA3700		64	25	8x90	9RA6400	
38	25	6.35x77	9RA3800		65	25	8x90	9RA6500	

Long Series

12	50	6.35x102	9RA1201		32	50	6.35x102	9RA3201	
13	50	6.35x102	9RA1301		33	50	6.35x102	9RA3301	
14	50	6.35x102	9RA1401		34	50	6.35x102	9RA3401	
15	50	6.35x102	9RA1501		35	50	6.35x102	9RA3501	
16	50	6.35x102	9RA1601		36	50	6.35x102	9RA3601	
17	50	6.35x102	9RA1701		37	50	6.35x102	9RA3701	
18	50	6.35x102	9RA1801		38	50	6.35x102	9RA3801	
19	50	6.35x102	9RA1901		39	50	6.35x102	9RA3901	
20	50	6.35x102	9RA2001		40	50	6.35x102	9RA4001	
21	50	6.35x102	9RA2101		41	50	6.35x102	9RA4101	
22	50	6.35x102	9RA2201		42	50	6.35x102	9RA4201	
23	50	6.35x102	9RA2301		43	50	6.35x102	9RA4301	
24	50	6.35x102	9RA2401		44	50	6.35x102	9RA4401	
25	50	6.35x102	9RA2501		45	50	6.35x102	9RA4501	
26	50	6.35x102	9RA2601		46	50	6.35x102	9RA4601	
27	50	6.35x102	9RA2701		47	50	6.35x102	9RA4701	
28	50	6.35x102	9RA2801		48	50	6.35x102	9RA4801	
29	50	6.35x102	9RA2901		49	50	6.35x102	9RA4901	
30	50	6.35x102	9RA3001		50	50	6.35x102	9RA5001	
31	50	6.35x102	9RA3101						

Continued on next page...



Core Drill Cutters (Sluggers) with Pilot Pin

For cutting holes in various materials with high speed.



OSG GROUP COMPANY

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
35	30	30	25	20	15	20	15	10		40	40	30	25																					

Vc: m/min

Size	Cutter Length	Pilot Pin	Code	Price	Size	Cutter Length	Pilot Pin	Code	Price
------	---------------	-----------	------	-------	------	---------------	-----------	------	-------

Long Series

... from previous page

51	50	6.35x102	9RA5101		58	50	6.35x102	9RA5801	
52	50	6.35x102	9RA5201		59	50	6.35x102	9RA5901	
53	50	6.35x102	9RA5301		60	50	6.35x102	9RA6001	
54	50	6.35x102	9RA5401		61	50	8x115	9RA6101	
55	50	6.35x102	9RA5501		62	50	8x115	9RA6201	
56	50	6.35x102	9RA5601		63	50	8x115	9RA6301	
57	50	6.35x102	9RA5701		64	50	8x115	9RA6401	
					65	50	8x115	9RA6501	

Code

9RA

Properties

mm **HSS**

Description

Code

Price

Core Drill Cutter (Slugger) Set - TiAlN Coated

9RA0000A

THIS SET CONTAINS:

14mm - 9RA1400A, 18mm - 9RA1800A,

22mm - 9RA2200A



NEW

Solid Carbide Tipped Core Drill Cutters (Sluggers)

For cutting holes in various materials with high speed.



Vc: m/min

P						M				K				Ti			Ni			Cu				N				Syn			H			
1.1	1.2	1.3	1.4	1.5	1.6	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	4.3	5.1	5.2	5.3	6.1	6.2	6.3	6.4	7.1	7.2	7.3	7.4	8.1	8.2	8.3	9.1	9.2	9.3	9.4
35	30	30	25	20	15	20	15	10		40	40	30	25																					

Size	Cutter Length	Code	Price	Size	Cutter Length	Code	Price
------	---------------	------	-------	------	---------------	------	-------

Regular Length

12	35	9RC1200		30	35	9RC3000	
15	35	9RC1500		33	35	9RC3300	
20	35	9RC2000		43	35	9RC4300	
23	35	9RC2300		46	35	9RC4600	

Long Series

29	50	9RC2901		40	50	9RC4001	
33	50	9RC3301					

Not available once current stock is depleted

Note: Cutters do not include Pilot Pins.

Codes

9RC

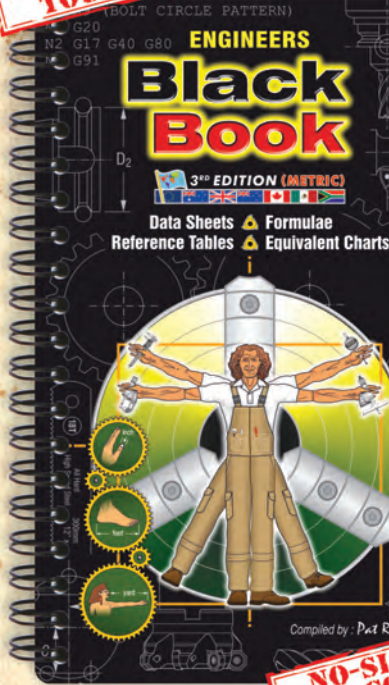
Properties

mm **HSS**



THE NEW ENGINEERS BLACK BOOK 3rd - EDITION

WORKSHOP TOUGH



NO-SLIP GRIP COVER

Code

Price

EHB0001

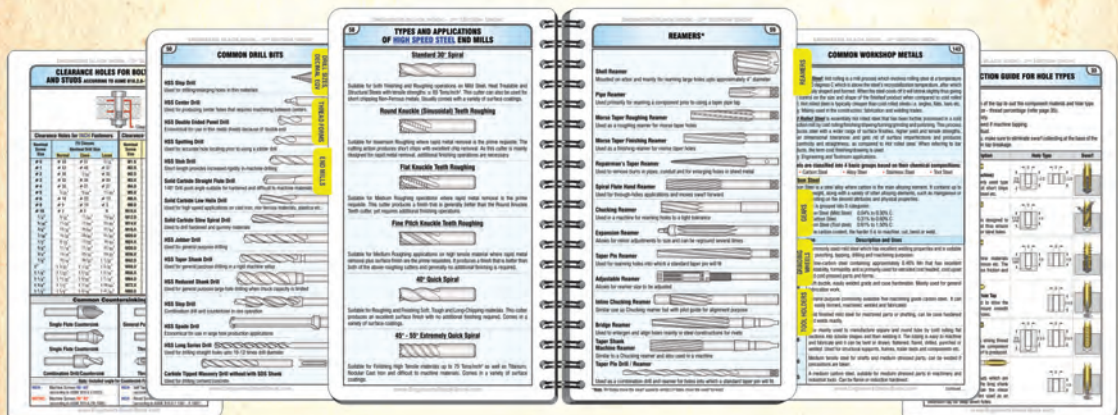
STILL HAS

- Our famous GREASE Proof & NO-GLARE pages! Handle with Greasy Hands all day long... the pages will always WIPE CLEAN !
- No Flimsy or Weak pages! No need to be careful ... these pages will still not tear !
- Still contains all the day to day relevant information you will need !
- Will always stay open unassisted with the Lay-flat binding format.
- Still in the pocketed sized format for portability.

WHAT'S NEW

- Includes a set of 28x Self Adhesive Index Tabs to help you bookmark your frequently used pages. You can now find the information you need even FASTER !
- 60 pages of new content, that is 35% greater than previous - 234 Pages in total.
- The outside covers are made from a new rubberized material for better Handling & Grip.
- Updated and Improved Index Searching.
- Extra Content Includes:

Reamer and Drill Bit Types, Taper Pins, T-slot sizing, Counterboring/Sinking, Extended Angles Conversions for Cutting Tapers, Keyways and Keyseats, Woodruff Keys, Retaining Rings, O-Rings, Flange Sizing, Common Workshop Metals, Adhesives, GD&T, Graph and Design Paper included at the back of the book.



EHB0001 is now also available in a LARGE EDITION!
Same content but in a larger 250mm High x 140mm Wide Book

NEW

Code

Price

EHB0001LRG

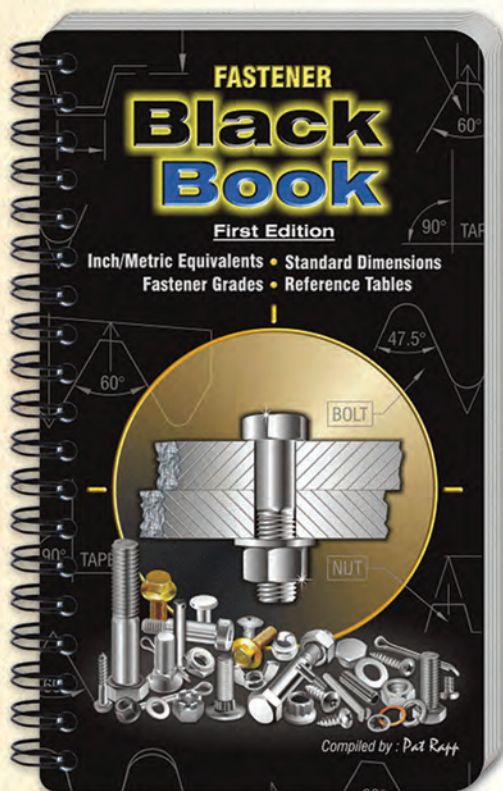


FASTENER Black Book



First Edition

Code	Price
EHB0002	



Inch / Metric Fasteners
ISO & DIN Specifications
Fastener Platings & Finishes
Pre-Loads & Tightening Torques
Thread Terminology & Classifications
Standard Grades
Tolerances & Markings
Thread Forms
Heads
Points
Materials
Coatings



Includes a FREE 6" X 3 1/2" METAL
THREAD PITCH IDENTIFICATION GAUGE
with every book!



from the publishers of the Best-Selling

ENGINEERS BLACK BOOK 3rd - EDITION

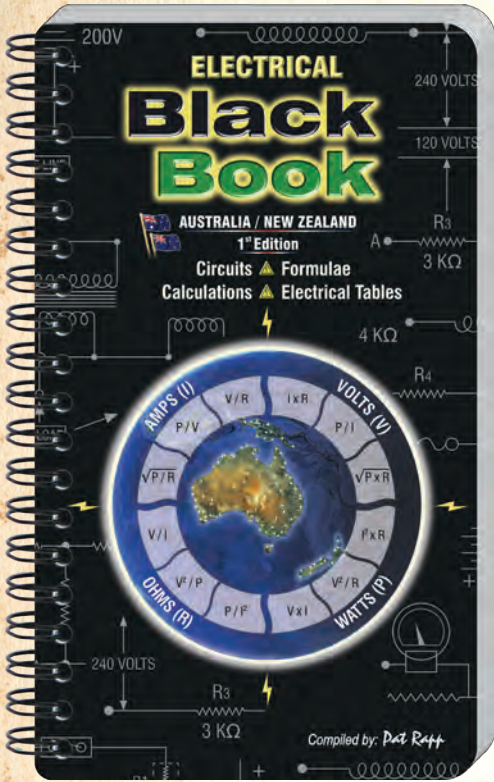
EHB0002 is now also available in a LARGE EDITION!
Same content but in a larger 250mm High x 140mm Wide Book

NEW	Code	Price
	EHB0002LRG	

from the publishers of the Best-Selling Engineers Black Book

THE ELECTRICAL BLACK BOOK

AUSTRALIA / NEW ZEALAND 1st EDITION



Code	Price
EHB0004	

- Electrical Safety
- Electrical Codes & Standards
- Electrical Basics
- Electricians Tools & Testers
- Laws of Electricity
- Electrical Formulae
- Resistors, Inductors, Impedance, Reactance & Electrical Circuits
- Electrical Conductors / Cables
- Electrical Plugs, Socket-outlets, Wiring diagrams & Switches
- Electrical Lamps, Bases, CFL, Grounding & Fuses
- LED Lighting, Fibre Optics & Data Cabling
- Transformers & Motors

THE DRILL POINT SHARPENING GAUGE



The DRILL POINT SHARPENING GAUGE is the tool most frequently used to check the drill point during the sharpening operation.

Overall Size: 80.00mm x 100.00mm
Material: 0.9mm Aluminium
Hole Sizes: 3.0, 4.0, 5.0, 6.0, 7.0, 8.0, 9.0, 10.0 (mm), 1/8, 5/32, 3/16, 7/32, 1/4, 9/32, 5/16, 3/8, (Fractional)
Point Angles: 60°, 90°, 118°, 130°, 135°, 140°

Code	Price
EHB0005	

This image shows a single sheet of white paper with horizontal blue ruling lines. The lines are evenly spaced and run across the width of the page. There are no margins, text, or other markings on the paper.

This image shows a single sheet of white paper with horizontal ruling lines. The lines are evenly spaced and run across the width of the page. There are no margins, text, or other markings on the paper.



This image shows a single sheet of white paper with horizontal ruling lines. The lines are evenly spaced and run across the width of the page. There are no margins, text, or other markings on the paper.

General Information

Metric Guide

INCH	METRIC	INCH	METRIC	INCH	METRIC	INCH	METRIC	INCH	METRIC	INCH	METRIC	INCH	METRIC
1/64	0.397	7/16	11.112	55/64	21.828	1.9/32	32.544	1.45/64	43.259	2.7/32	56.356	3.1/16	77.787
1/32	0.794	29/64	11.509	7/8	22.225	1.19/64	32.941	1.23/32	43.656	2.1/4	57.150	3.3/32	78.581
3/64	1.191	15/32	11.906	57/64	22.622	1.5/16	33.337	1.47/64	44.053	2.9/32	57.944	3.1/8	79.375
1/16	1.587	31/64	12.303	29/32	23.019	1.21/64	33.734	1.3/4	44.450	2.5/16	58.737	3.5/32	80.169
5/64	1.984	1/2	12.700	59/64	23.416	1.11/32	34.131	1.49/64	44.847	2.11/32	59.531	3.3/16	80.962
3/32	2.381	33/64	13.097	15/16	23.812	1.23/64	34.528	1.25/32	45.244	2.3/8	60.325	3.7/32	81.756
7/64	2.778	17/32	13.494	61/64	24.209	1.3/8	34.925	1.51/64	45.641	2.13/32	61.119	3.1/4	82.550
1/8	3.175	35/64	13.891	31/32	24.606	1.25/64	35.322	1.13/16	46.037	2.7/16	61.912	3.9/32	83.343
9/64	3.572	9/16	14.287	63/64	25.003	1.13/32	35.719	1.53/64	46.434	2.15/32	62.706	3.5/16	84.137
5/32	3.969	37/64	14.684	1"	25.400	1.27/64	36.116	1.27/32	46.831	2.1/2	63.500	3.11/32	84.931
11/64	4.366	19/32	15.081	1.1/64	25.797	1.7/16	36.512	1.55/64	47.228	2.17/32	64.294	3.3/8	85.725
3/16	4.762	39/64	15.478	1.1/32	26.194	1.29/64	36.909	1.7/8	47.625	2.9/16	65.087	3.13/32	86.519
13/64	5.159	5/8	15.875	1.3/64	26.591	1.15/32	37.306	1.57/64	48.022	2.19/32	65.881	3.7/16	87.312
7/32	5.556	41/64	16.272	1.1/16	26.987	1.31/64	37.703	1.29/32	48.419	2.5/8	66.675	3.15/32	88.106
15/64	5.953	21/32	16.669	1.5/64	27.384	1.1/2	38.100	1.59/64	48.816	2.21/32	67.469	3.1/2	88.900
1/4	6.350	43/64	17.066	1.3/32	27.781	1.33/64	38.497	1.15/16	49.212	2.11/16	68.262	3.9/16	90.487
17/64	6.747	11/16	17.462	1.7/64	28.178	1.17/32	38.894	1.61/64	49.609	2.23/32	69.056	3.5/8	92.075
9/32	7.144	45/64	17.859	1.1/8	28.575	1.35/64	39.291	1.31/32	50.006	2.3/4	69.850	3.11/16	93.662
19/64	7.541	23/32	18.256	1.9/64	28.972	1.9/16	39.687	1.63/64	50.403	2.25/32	70.644	3.3/4	95.250
5/16	7.937	47/64	18.653	1.5/32	29.369	1.37/64	40.084	2"	50.800	2.13/16	71.437	3.13/16	96.837
21/64	8.334	3/4	19.050	1.11/64	29.766	1.19/32	40.481	2.1/64	51.197	2.27/32	72.231	3.7/8	98.425
11/32	8.731	49/64	19.447	1.3/16	30.162	1.39/64	40.878	2.1/32	51.594	2.7/8	73.025	3.15/16	100.012
23/64	9.128	25/32	19.844	1.13/64	30.559	1.5/8	41.275	2.1/16	52.387	2.29/32	73.819	4"	101.600
3/8	9.525	51/64	20.241	1.7/32	30.956	1.41/64	41.672	2.3/32	53.181	2.15/16	74.612		
25/64	9.922	13/16	20.637	1.15/64	31.353	1.21/32	42.069	2.1/8	53.975	2.31/32	75.406		
13/32	10.319	53/64	21.034	1.1/4	31.750	1.43/64	42.466	2.5/32	54.769	3"	76.200		
27/64	10.716	27/32	21.431	1.17/64	32.147	1.11/16	42.862	2.3/16	55.562	3.1/32	76.994		

Drill Sizes for Tapping (for 75% thread depth)

METRIC (60° INCLUDED ANGLE) (Fluteless*)														
Size	Metric Coarse		Metric Fine		Size	Metric Coarse		Metric Fine		Size	Metric Coarse		Metric Fine	
	Pitch	Drill Size in mm	Pitch	Drill Size in mm		Pitch	Drill Size in mm	Pitch	Drill Size in mm		Pitch	Drill Size in mm	Pitch	Drill Size in mm
1	0.25	0.75	—	—	15	—	—	1.50	13.50	36	4.00	32.00	1.50	34.50
1.1	0.25	0.85	—	—	16	2.00	14.00	1.00	15.00	36	—	—	2.00	34.00
1.2	0.25	0.95	—	—	16	—	—	1.50	14.50	36	—	—	3.00	33.00
1.4	0.30	1.10	—	—	17	—	—	1.50	15.50	38	—	—	1.50	36.50
1.6	0.35	1.25	—	—	18	2.50	15.50	1.00	17.00	38	—	—	2.00	36.00
1.8	0.35	1.45	—	—	18	—	—	1.25	16.80	39	4.00	35.00	1.50	37.50
2	0.40	1.60 (1.80*)	0.25	1.75	18	—	—	1.50	16.50	39	—	—	2.00	37.00
2.2	0.45	1.75	0.25	1.95	18	—	—	2.00	16.00	39	—	—	3.00	36.00
2.5	0.45	2.05	0.35	2.15	20	2.50	17.50	1.00	19.00	40	—	—	1.50	38.50
3	0.50	2.50 (2.80*)	0.35	2.65	20	—	—	1.50	18.50	40	—	—	2.00	38.00
3.5	0.60	2.90 (3.20*)	0.35	3.15	20	—	—	2.00	18.00	40	—	—	3.00	37.00
4	0.70	3.30 (3.70*)	0.50	3.50	22	2.50	19.50	1.00	21.00	42	4.50	37.50	1.50	40.50
4.5	0.75	3.70 (4.20*)	0.50	4.00	22	—	—	1.50	20.50	42	—	—	2.00	40.00
5	0.80	4.20 (4.70*)	0.50	4.50	22	—	—	2.00	20.00	42	—	—	3.00	39.00
5	—	—	0.75	4.30	24	3.00	21.00	1.00	23.00	42	—	—	4.00	38.00
5.5	—	—	0.50	5.00	24	—	—	1.50	22.50	45	4.50	40.50	1.50	43.50
6	1.00	5.00 (5.60*)	0.75	5.25	24	—	—	2.00	22.00	45	—	—	2.00	43.00
7	1.00	6.00	0.75	6.25	25	—	—	1.00	24.00	45	—	—	3.00	42.00
8	1.25	6.80 (7.40*)	0.75	7.30	25	—	—	1.50	23.50	45	—	—	4.00	41.00
8	—	—	1.00	7.00	25	—	—	2.00	23.00	48	5.00	43.00	1.50	46.50
9	1.25	7.80	0.75	8.30	27	3.00	24.00	1.50	25.50	48	—	—	2.00	46.00
9	—	—	1.00	8.00	27	—	—	2.00	25.00	48	—	—	3.00	45.00
10	1.50	8.50 (9.30*)	0.75	9.30	28	—	—	1.50	26.50	48	—	—	4.00	44.00
10	—	—	1.00	9.00	28	—	—	2.00	26.00	50	—	—	1.50	48.50
10	—	—	1.25	8.75	30	3.50	26.50	1.00	29.00	50	—	—	2.00	48.00
11	1.50	9.50	1.00	10.00	30	—	—	1.50	28.50	50	—	—	3.00	47.00
11	—	—	1.25	9.80	30	—	—	2.00	28.00	52	5.00	47.00	1.50	50.50
12	1.75	10.20 (11.20*)	1.00	11.00	30	—	—	3.00	27.00	52	—	—	2.00	50.00
12	—	—	1.25	10.80	32	—	—	1.50	30.50	52	—	—	3.00	49.00
12	—	—	1.50	10.50	32	—	—	2.00	30.00	52	—	—	4.00	48.00
14	2.00	12.00	1.00	13.00	33	3.50	29.50	1.50	31.50	56	5.50	50.50	—	—
14	—	—	1.25	12.75	33	—	—	2.00	31.00	60	5.50	54.50	—	—
14	—	—	1.50	12.50	33	—	—	3.00	30.00	64	6.00	58.00	—	—
15	—	—	1.00	14.00	35	—	—	1.50	33.50	68	6.00	62.00	—	—



BRITISH STANDARD WHITWORTH THREADS (55° INCLUDED ANGLE)									
Size	BSW		BSF		BSB		BSP		BSPT
	TPI	Drill Size in mm	TPI	Drill Size in mm	TPI	Drill Size in mm	TPI	Drill Size in mm	Drill Size in mm
1/16"	60	1.20	—	—	—	—	—	—	—
3/32"	48	1.90	—	—	—	—	—	—	—
1/8"	40	2.55	—	—	—	—	28	8.80	8.60
5/32"	32	3.20	—	—	—	—	—	—	—
3/16"	24	3.70	32	4.00	—	—	—	—	—
7/32"	24	4.50	28	4.70	—	—	—	—	—
1/4"	20	5.10	26	5.40	26	5.30	19	11.80	11.50
9/32"	—	—	26	6.20	—	—	—	—	—
5/16"	18	6.50	22	6.80	26	6.90	—	—	—
3/8"	16	8.00	20	8.30	26	8.40	19	15.50	15.00
7/16"	14	9.30	18	9.80	26	10.00	—	—	—
1/2"	12	10.50	16	11.00	26	11.70	14	19.00	18.50
9/16"	12	12.20	16	12.70	—	—	—	—	—
5/8"	11	13.50	14	14.00	26	15.00	14	21.00	—
11/16"	11	15.20	14	15.50	—	—	—	—	—
3/4"	10	16.50	12	16.50	26	18.00	14	24.50	24.00
7/8"	9	19.50	11	19.50	—	—	14	28.50	—
1"	8	22.00	10	22.50	26	24.50	11	31.00	30.25
1.1/8"	7	25.00	9	25.50	—	—	—	—	—
1.1/4"	7	28.00	9	29.00	—	—	11	40.00	39.00
1.3/8"	—	—	8	31.80	—	—	—	—	—
1.1/2"	6	34.00	8	34.50	—	—	11	45.50	45.00
1.5/8"	—	—	8	38.00	—	—	—	—	—
1.3/4"	5	39.00	7	41.00	—	—	11	51.50	—
2"	4.5	45.00	7	47.00	—	—	11	57.00	56.50
2.1/4"	4	51.00	6	53.00	—	—	11	63.30	—
2.1/2"	4	57.00	6	59.00	—	—	11	72.80	—
2.3/4"	3.5	63.00	6	66.00	—	—	—	—	—
3"	3.5	69.00	5	71.00	—	—	11	85.50	—
3.1/4"	3.25	75.00	5	77.00	—	—	—	—	—
3.1/2"	3.25	81.00	4.5	83.00	—	—	—	—	—
3.3/4"	3	87.00	4.5	90.00	—	—	—	—	—
4"	3	93.00	4.5	96.00	—	—	—	—	—

UNIFIED NATIONAL THREADS (60° INCLUDED ANGLE)									
Size	Nominal Diameter	UNC		UNF		NPS		NPT	
		TPI	Drill Size in mm	TPI	Drill Size in mm	TPI	Drill Size in mm	TPI	Drill Size in mm
No.1	1.85	64	1.55	72	1.55	—	—	—	—
No.2	2.18	56	1.85	64	1.90	—	—	—	—
No.3	2.51	48	2.00	56	2.10	—	—	—	—
No.4	2.84	40	2.25	48	2.35	—	—	—	—
No.5	3.18	40	2.60	44	2.65	—	—	—	—
No.6	3.51	32	2.75	40	2.90	—	—	—	—
No.8	4.17	32	3.40	36	3.50	—	—	—	—
No.10	4.83	24	3.80	32	4.10	—	—	—	—
No.12	5.49	24	4.40	28	4.60	—	—	—	—
1/8"	—	—	—	—	—	27	9.10	27	8.40
1/4"	—	20	5.10	28	5.50	18	12.00	18	11.00
5/16"	—	18	6.60	24	6.90	—	—	—	—
3/8"	—	16	8.00	24	8.50	18	15.50	18	14.25
7/16"	—	14	9.40	20	9.80	—	—	—	—
1/2"	—	13	10.80	20	11.50	14	19.00	14	17.50
9/16"	—	12	12.20	18	12.80	—	—	—	—
5/8"	—	11	13.50	18	14.50	—	—	—	—
3/4"	—	10	16.50	16	17.50	14	24.50	14	23.00
7/8"	—	9	19.50	14	20.50	—	—	—	—
1"	—	8	22.00	12	23.50	11.5	30.50	11.5	29.00
1.1/8"	—	7	25.00	12	26.50	—	—	—	—
1.1/4"	—	7	28.00	12	29.50	11.5	39.40	11.5	37.50
1.3/8"	—	6	31.00	12	32.50	—	—	—	—
1.1/2"	—	6	34.00	12	36.00	11.5	45.50	11.5	43.50
1.3/4"	—	5	39.00	—	—	—	—	—	—
2"	—	4.5	45.00	—	—	11.5	57.50	11.5	55.50

BRITISH ASSOCIATION (47½° INCLUDED ANGLE)				
Size	Nominal Diameter	TPI	Drill Size in mm	
No.12	1.3	90.1	1.05	
No.10	1.7	72.6	1.40	
No.9	1.9	65.1	1.55	
No.8	2.2	59.1	1.80	
No.7	2.5	52.9	2.05	
No.6	2.8	47.9	2.30	
No.5	3.2	43.1	2.65	
No.4	3.6	38.3	3.00	
No.3	4.1	34.8	3.40	
No.2	4.7	31.3	3.90	
No.1	5.3	28.2	4.50	
No.0	6.0	25.4	5.10	

General Terms & Conditions of Sale

All deliveries of goods will be made in terms of our General Terms and Conditions of Sale, which are available in detail, on request.

No modifications or allowances will be accepted unless agreed to in writing by the Company.

Delivery Terms

All deliveries inside the Republic of South Africa will be free of charge. The Company however reserves the right to charge a fee for special deliveries of small quantities. For all deliveries outside the Republic of South Africa, the cost of delivery will be for the customer's account unless otherwise agreed to in writing by the Company.

Terms of Payment

All payments will be made in accordance with our General Terms and Conditions of Sale, and other terms agreed to in writing by the Company.

Special Tooling

Our delivery programme is based mainly on the standard tooling in this catalogue. Special tooling can be provided on request, based on other international standards or customer's specifications and drawings. Deliveries of such tooling will be subject to a quantity variation of +/- 10% of the order quantity, with a minimum quantity variation of one piece.

Request for tooling to customer specification will only be put into production against a signed copy of the customer's drawings and specifications, or a copy of our customer approval drawing. No special tooling orders can be cancelled or returned.

Note : All terms and conditions may be changed at the discretion of the Company.





OSG GROUP COMPANY



TOLERANCES in $\mu\text{m} = 1 \text{ micron (1/1000mm)}$

	Tol.	d11	e8	h6	h7	h8	h11	h12	js10	js14	js16	k10	k11	k12	H7	H11
DIAMETER OR WIDTH	≤3mm	-20 -80	-14 -28	0 -6	0 -10	0 -14	0 -60	0 -100	+20 -20	+125 -125	+300 -300	+40 0	+60 -0	+100 -0	+10 0	+60 0
	3 to 6mm	-30 -105	-20 -38	0 -8	0 -12	0 -18	0 -75	0 -120	+24 -24	+150 -150	+375 -375	+48 0	+75 -0	+120 -0	+12 0	+75 0
	6 to 10mm	-40 -130	-25 -47	0 -9	0 -15	0 -22	0 -90	0 -150	+29 -29	+180 -180	+450 -450	+58 0	+90 -0	+150 -0	+15 0	+90 0
	10 to 18mm	-50 -160	-32 -59	0 -11	0 -18	0 -27	0 -110	0 -180	+35 -35	+215 -215	+550 -550	+70 0	+110 -0	+180 -0	+18 0	+110 0
	18 to 30mm	-65 -195	-40 -73	0 -13	0 -21	0 -33	0 -130	0 -210	+42 -42	+260 -260	+650 -650	+84 0	+130 -0	+210 -0	+21 0	+130 0
	30 to 50mm	-80 -240	-50 -89	0 -16	0 -25	0 -39	0 -160	0 -250	+50 -50	+310 -310	+800 -800	+100 0	+160 -0	+250 -0	+25 0	+160 0
	50 to 80mm	-100 -290	-60 -106	0 -19	0 -30	0 -46	0 -190	0 -300	+60 -60	+370 -370	+950 -950	+120 0	+190 -0	+300 -0	+30 0	+190 0
	80 to 120mm	-120 -340	-72 -126	0 -22	0 -35	0 -54	0 -220	0 -350	+70 -70	+435 -435	+1100 -1100	+140 0	+220 -0	+350 -0	+35 0	+220 0



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