



Powder Metal Cutting Taps
Suitable for Super Duplex stainless steel

M-SFT-DUPLEX

Volume 5



50 new standard sizes available:
Metric & metric fine,
also with oil hole.

KEY FEATURES: M-SFT-DUPLEX



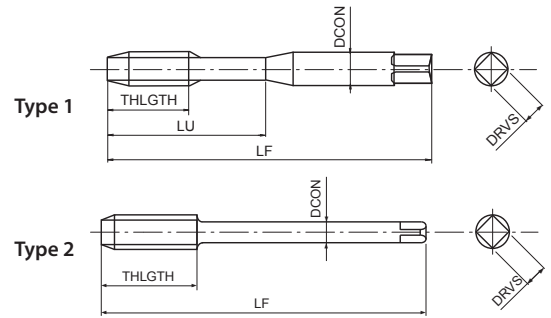
1 Improved rigidity:
optimized core diameter
more flutes than conventional item

2 Improved chip evacuation:
optimized high helix angle,
also with oil hole

3 Improved welding resistance:
TiN-coating is ideal for
SuperDuplex due to higher heat
resistance.

M-SFT-DUPLEX NEW SIZE

Threading | Cutting taps | Metric



- Powder metal spiral-fluted cutting tap for blind holes
- TiN-coating for higher heat resistance
- For difficult materials such as 304L, 316L, 15-5PH & 17-4PH, Super Duplex 1.4410, Inconel 625

| | | | | | | | |
|------------------------|------------------------------|-------------------------|-------------------|----------------------|---------------------------|-----------------------|----------------|
| P ○ C < 0,2% | P ○ 0,25 < C < 0,4 | P ○ C ≥ 0,45% | P ○ SCM | M ● INOX | S ● Inconel 625 | S ● Ti Gr.2 | |
| | | | | 3-15 Super Duplex | 2-3 15-5 PH | 3-6 17-4 PH | m/min |
| M | PM | TiN | 50° | ISO 2 6HX | C/2,5 | DIN 371 | DIN 376 |

| EDP | TD | TP | LF | THLGTH | LU | DCON | DRVS | NOF | Type | DIN |
|-----------------------------|-----|------|-----|--------|----|------|------|-----|------|-----|
| 48336125 | 2 | 0,4 | 45 | 3,2 | 10 | 2,8 | 2,1 | 2 | 1 | 371 |
| 48336133 <small>NEW</small> | 2,5 | 0,45 | 50 | 3,6 | 13 | 2,8 | 2,1 | 2 | 1 | 371 |
| 48336138 | 3 | 0,5 | 56 | 4 | 18 | 3,5 | 2,7 | 3 | 1 | 371 |
| 48336144 | 4 | 0,7 | 63 | 5,6 | 21 | 4,5 | 3,4 | 3 | 1 | 371 |
| 48336149 | 5 | 0,8 | 70 | 6,4 | 25 | 6 | 4,9 | 3 | 1 | 371 |
| 48336155 | 6 | 1 | 80 | 8 | 30 | 6 | 4,9 | 3 | 1 | 371 |
| 48336161 | 8 | 1,25 | 90 | 10 | 35 | 8 | 6,2 | 3 | 1 | 371 |
| 48336169 | 10 | 1,5 | 100 | 12 | 39 | 10 | 8 | 4 | 1 | 371 |
| 48336179 | 12 | 1,75 | 110 | 14 | - | 9 | 7 | 4 | 2 | 376 |
| 48336191 | 14 | 2 | 110 | 16 | - | 11 | 9 | 4 | 2 | 376 |
| 48336202 | 16 | 2 | 110 | 16 | - | 12 | 9 | 4 | 2 | 376 |
| 48336214 | 18 | 2,5 | 125 | 25 | - | 14 | 11 | 4 | 2 | 376 |
| 48336228 | 20 | 2,5 | 140 | 25 | - | 16 | 12 | 4 | 2 | 376 |
| 48336238 | 22 | 2,5 | 140 | 25 | - | 18 | 14,5 | 4 | 2 | 376 |
| 48336247 | 24 | 3 | 160 | 30 | - | 18 | 14,5 | 4 | 2 | 376 |

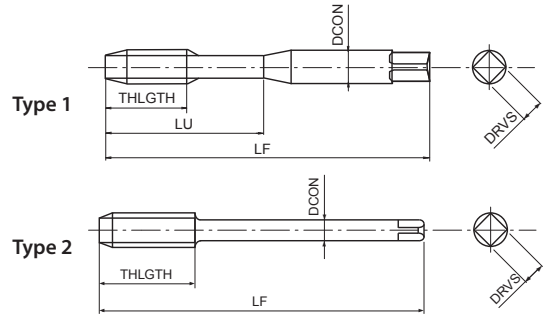
Threading | Cutting taps

Metric



M-OIL-SFT-DUPLEX NEW

Threading | Cutting taps | Metric



- Powder metal spiral-fluted cutting tap for blind holes
- TiN-coating for higher heat resistance
- For difficult materials such as 304L, 316L, 15-5PH & 17-4PH, Super Duplex 1.4410, Inconel 625
- Centre through coolant

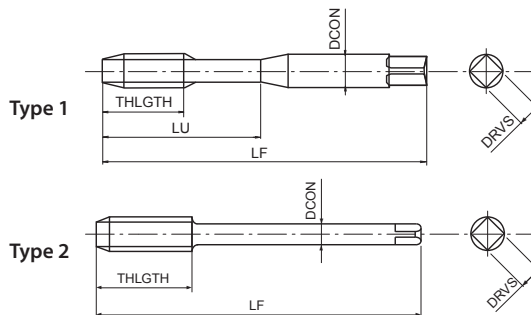
Threading | Cutting taps
Metric

| | | | | | | | | |
|------------------------|------------------------------|-------------------------|-------------------|--|---|---|----------------|----------------|
| P ○ C < 0,2% | P ○ 0,25 < C < 0,4 | P ○ C ≥ 0,45% | P ○ SCM | M ● INOX 3-15 Super Duplex | S ● Inconel 625 2-3 15-5 PH | S ● Ti Gr.2 3-6 17-4 PH | m/min | |
| M | PM | TiN | 50° | ISO 2 6HX | C/2,5 | DRVS | DIN 371 | DIN 376 |

| EDP | TD | TP | LF | THLGTH | LU | DCON | DRVS | NOF | Type | DIN |
|----------|----|------|-----|--------|----|------|------|-----|------|-----|
| 48380155 | 6 | 1 | 80 | 8 | 30 | 6 | 4,9 | 3 | 1 | 371 |
| 48380161 | 8 | 1,25 | 90 | 10 | 35 | 8 | 6,2 | 3 | 1 | 371 |
| 48380169 | 10 | 1,5 | 100 | 12 | 39 | 10 | 8 | 4 | 1 | 371 |
| 48380179 | 12 | 1,75 | 110 | 14 | - | 9 | 7 | 4 | 2 | 376 |
| 48380191 | 14 | 2 | 110 | 16 | - | 11 | 9 | 4 | 2 | 376 |
| 48380202 | 16 | 2 | 110 | 16 | - | 12 | 9 | 4 | 2 | 376 |
| 48380214 | 18 | 2,5 | 125 | 20 | - | 14 | 11 | 4 | 2 | 376 |
| 48380228 | 20 | 2,5 | 140 | 20 | - | 16 | 12 | 4 | 2 | 376 |
| 48380238 | 22 | 2,5 | 140 | 20 | - | 18 | 14,5 | 4 | 2 | 376 |
| 48380247 | 24 | 3 | 160 | 24 | - | 18 | 14,5 | 4 | 2 | 376 |
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M-LT-SFT-DUPLEX NEW

Threading | Cutting taps | Metric



- Powder metal spiral-fluted cutting tap for blind holes
- TiN-coating for higher heat resistance
- For difficult materials such as 304L, 316L, 15-5PH & 17-4PH, Super Duplex 1.4410, Inconel 625
- Long shank for deep reach threading & 3xD flute length

| | | | | | | | |
|------------------------|------------------------------|-------------------------|-------------------|----------------------|---------------------------|-----------------------|-------|
| P ○ C < 0,2% | P ○ 0,25 < C < 0,4 | P ○ C ≥ 0,45% | P ○ SCM | M ● INOX | S ● Inconel 625 | S ● Ti Gr.2 | |
| | | | | 3-15 Super Duplex | 2-3 15-5 PH | 3-6 17-4 PH | m/min |
| M | PM | TiN | 50° | ISO 2 6HX | C/2,5 | | |

| EDP | TD | TP | LF | THLGTH | LU | DCON | DRVS | NOF | Type |
|----------|-----|------|-----|--------|------|------|------|-----|------|
| 48381125 | 2 | 0,4 | 80 | 3,2 | 12 | 2,8 | 2,1 | 2 | 1 |
| 48381133 | 2,5 | 0,45 | 100 | 3,6 | 15,5 | 2,8 | 2,1 | 2 | 1 |
| 48381138 | 3 | 0,5 | 100 | 4 | 21 | 3,5 | 2,7 | 3 | 1 |
| 48381144 | 4 | 0,7 | 125 | 5,6 | 25 | 4,5 | 3,4 | 3 | 1 |
| 48381149 | 5 | 0,8 | 160 | 6,4 | 30 | 6 | 4,9 | 3 | 1 |
| 48381155 | 6 | 1 | 160 | 8 | 36 | 6 | 4,9 | 3 | 1 |
| 48381187 | 6 | 1 | 160 | 8 | - | 4,5 | 3,4 | 3 | 2 |
| 48381161 | 8 | 1,25 | 180 | 10 | 43 | 8 | 6,2 | 3 | 1 |
| 48381188 | 8 | 1,25 | 180 | 10 | - | 6 | 4,9 | 3 | 2 |
| 48381169 | 10 | 1,5 | 200 | 12 | 49 | 10 | 8 | 4 | 1 |
| 48381189 | 10 | 1,5 | 200 | 12 | - | 7 | 5,5 | 4 | 2 |
| 48381179 | 12 | 1,75 | 200 | 14 | - | 9 | 7 | 4 | 2 |
| 48381191 | 14 | 2 | 200 | 16 | - | 11 | 9 | 4 | 2 |
| 48381202 | 16 | 2 | 200 | 16 | - | 12 | 9 | 4 | 2 |
| 48381214 | 18 | 2,5 | 200 | 20 | - | 14 | 11 | 4 | 2 |
| 48381228 | 20 | 2,5 | 200 | 20 | - | 16 | 12 | 4 | 2 |

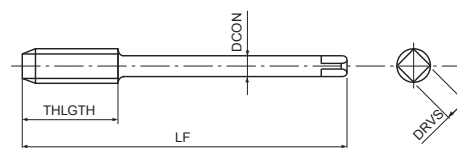
Threading | Cutting taps



Metric

M-SFT-DUPLEX NEW

Threading | Cutting taps | Metric Fine



- Powder metal spiral-fluted cutting tap for blind holes
- TiN-coating for higher heat resistance
- For difficult materials such as 304L, 316L, 15-5PH & 17-4PH, Super Duplex 1.4410, Inconel 625

Threading | Cutting taps

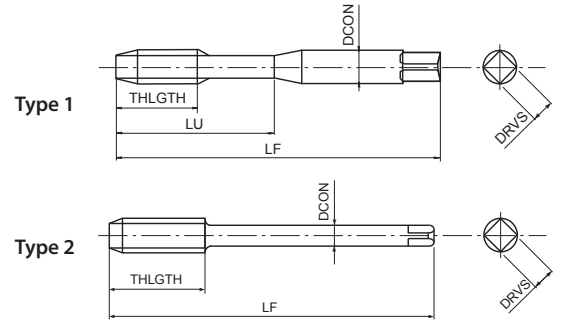
| | | | | | | | |
|------------------------|------------------------------|-------------------------|-------------------|----------------------|---------------------------|-----------------------|-------|
| P ○ C < 0,2% | P ○ 0,25 < C < 0,4 | P ○ C ≥ 0,45% | P ○ SCM | M ● INOX | S ● Inconel 625 | S ● Ti Gr.2 | |
| | | | | 3-15 Super Duplex | 2-3 15-5 PH | 3-6 17-4 PH | m/min |
| MF | PM | TiN | 50° | ISO 2 6HX | C/2,5 | DIN 374 | |

| EDP | TD | TP | LF | THLGTH | DCON | DRVS | NOF | DIN |
|----------|----|------|-----|--------|------|------|-----|-----|
| 48336156 | 6 | 0,75 | 80 | 8 | 4,5 | 3,4 | 3 | 374 |
| 48336157 | 6 | 0,5 | 80 | 8 | 4,5 | 3,4 | 3 | 374 |
| 48336162 | 8 | 1 | 90 | 10 | 6 | 4,9 | 3 | 374 |
| 48336163 | 8 | 0,75 | 80 | 10 | 6 | 4,9 | 3 | 374 |
| 48336170 | 10 | 1,25 | 100 | 12 | 7 | 5,5 | 4 | 374 |
| 48336171 | 10 | 1 | 90 | 12 | 7 | 5,5 | 4 | 374 |
| 48336180 | 12 | 1,5 | 100 | 14 | 9 | 7 | 4 | 374 |
| 48336181 | 12 | 1,25 | 100 | 14 | 9 | 7 | 4 | 374 |
| 48336182 | 12 | 1 | 100 | 14 | 9 | 7 | 4 | 374 |
| 48336192 | 14 | 1,5 | 100 | 16 | 11 | 9 | 4 | 374 |
| 48336203 | 16 | 1,5 | 100 | 16 | 12 | 9 | 4 | 374 |
| 48336216 | 18 | 1,5 | 110 | 20 | 14 | 11 | 4 | 374 |
| 48336230 | 20 | 1,5 | 125 | 20 | 16 | 12 | 4 | 374 |
| 48336240 | 22 | 1,5 | 125 | 20 | 18 | 14,5 | 4 | 374 |
| 48336250 | 24 | 1,5 | 140 | 24 | 18 | 14,5 | 4 | 374 |

Metric Fine

M-SFT-DUPLEX

Threading | Cutting taps | UNC



- Powder metal spiral-fluted cutting tap for blind holes
- TiN-coating for higher heat resistance
- For difficult materials such as 304L, 316L, 15-5PH & 17-4PH, Super Duplex 1.4410, Inconel 625

Threading | Cutting taps

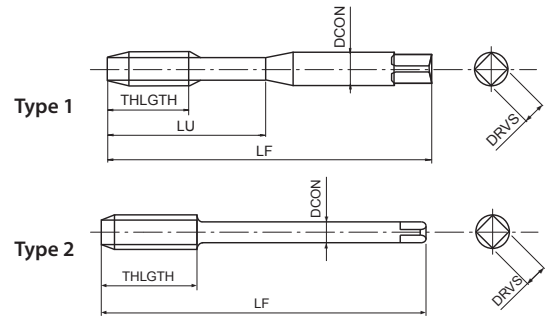
| | | | | | | | |
|----------------------|----------------------------|-----------------------|-----------------|-----------------------------|-------------------------|-----------------------|-------------------|
| P C < 0,2% | P 0,25 < C < 0,4 | P C ≥ 0,45% | P SCM | M INOX | S Inconel 625 | S Ti Gr.2 | |
| | | | | 3-15 Super Duplex | 2-3 15-5 PH | 3-6 17-4 PH | m/min |
| UNC | PM | TiN | 50° | ANSI 2BX | C/2,5 | | DIN 2184-1 |

| EDP | TD | TP | LF | THLGTH | LU | DCON | DRVS | NOF | Type | DIN |
|----------|------|----|-----|--------|----|------|------|-----|------|-----------|
| 48336453 | 2 | 56 | 45 | 3,6 | 11 | 2,8 | 2,1 | 2 | 1 | DIN2184-1 |
| 48336455 | 3 | 48 | 50 | 3,6 | 13 | 2,8 | 2,1 | 2 | 1 | DIN2184-1 |
| 48336457 | 4 | 40 | 56 | 5,1 | 18 | 3,5 | 2,7 | 2 | 1 | DIN2184-1 |
| 48336459 | 5 | 40 | 56 | 5,1 | 18 | 3,5 | 2,7 | 2 | 1 | DIN2184-1 |
| 48336461 | 6 | 32 | 56 | 6,4 | 20 | 4 | 3 | 2 | 1 | DIN2184-1 |
| 48336464 | 8 | 32 | 63 | 6,4 | 21 | 4,5 | 3,4 | 2 | 1 | DIN2184-1 |
| 48336466 | 10 | 24 | 70 | 8,5 | 25 | 6 | 4,9 | 2 | 1 | DIN2184-1 |
| 48336468 | 12 | 24 | 80 | 8,5 | 30 | 6 | 4,9 | 2 | 1 | DIN2184-1 |
| 48336471 | 1/4 | 20 | 80 | 10,2 | 30 | 7 | 5,5 | 3 | 1 | DIN2184-1 |
| 48336474 | 5/16 | 18 | 90 | 11,3 | 35 | 8 | 6,2 | 3 | 1 | DIN2184-1 |
| 48336479 | 3/8 | 16 | 100 | 12,7 | 39 | 10 | 8 | 4 | 1 | DIN2184-1 |
| 48336484 | 7/16 | 14 | 100 | 14,5 | - | 8 | 6,2 | 4 | 2 | DIN2184-1 |
| 48336489 | 1/2 | 13 | 110 | 15,6 | - | 9 | 7 | 4 | 2 | DIN2184-1 |
| 48336494 | 9/16 | 12 | 110 | 16,9 | - | 11 | 9 | 4 | 2 | DIN2184-1 |
| 48336501 | 5/8 | 11 | 110 | 18,5 | - | 12 | 9 | 4 | 2 | DIN2184-1 |
| 48336515 | 3/4 | 10 | 125 | 25,4 | - | 14 | 11 | 4 | 2 | DIN2184-1 |
| 48336526 | 7/8 | 9 | 140 | 28,2 | - | 18 | 14,5 | 4 | 2 | DIN2184-1 |
| 48336538 | 1 | 8 | 160 | 31,8 | - | 18 | 14,5 | 4 | 2 | DIN2184-1 |
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UNC

M-SFT-DUPLEX

Threading | Cutting taps | UNF



- Powder metal spiral-fluted cutting tap for blind holes
- TiN-coating for higher heat resistance
- For difficult materials such as 304L, 316L, 15-5PH & 17-4PH, Super Duplex 1.4410, Inconel 625

| | | | | | | | |
|------------------------|------------------------------|-------------------------|-------------------|----------------------|---------------------------|-----------------------|-------------------|
| P ○ C < 0,2% | P ○ 0,25 < C < 0,4 | P ○ C ≥ 0,45% | P ○ SCM | M ● INOX | S ● Inconel 625 | S ● Ti Gr.2 | |
| | | | | 3-15 Super Duplex | 2-3 15-5 PH | 3-6 17-4 PH | m/min |
| UNF | PM | TiN | 50° | ANSI 2BX | C/2,5 | DIN 2184-1 | DIN 2184-1 |

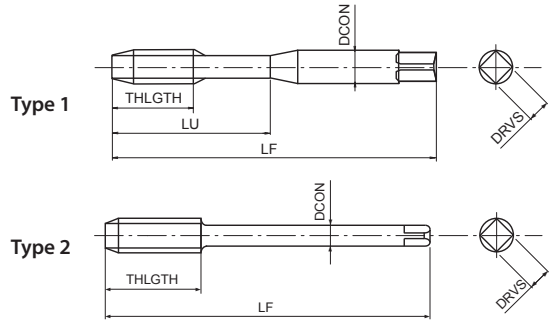
| EDP | TD | TP | LF | THLGTH | LU | DCON | DRVS | NOF | Type | DIN |
|----------|------|----|-----|--------|----|------|------|-----|------|-----------|
| 48336454 | 2 | 64 | 45 | 3,6 | 11 | 2,8 | 2,1 | 2 | 1 | DIN2184-1 |
| 48336456 | 3 | 56 | 50 | 3,6 | 13 | 2,8 | 2,1 | 2 | 1 | DIN2184-1 |
| 48336458 | 4 | 48 | 56 | 5,1 | 18 | 3,5 | 2,7 | 2 | 1 | DIN2184-1 |
| 48336460 | 5 | 44 | 56 | 5,1 | 18 | 3,5 | 2,7 | 2 | 1 | DIN2184-1 |
| 48336462 | 6 | 40 | 56 | 6,4 | 20 | 4 | 3 | 2 | 1 | DIN2184-1 |
| 48336465 | 8 | 36 | 63 | 6,4 | 21 | 4,5 | 3,4 | 2 | 1 | DIN2184-1 |
| 48336467 | 10 | 32 | 70 | 8,5 | 25 | 6 | 4,9 | 2 | 1 | DIN2184-1 |
| 48336469 | 12 | 28 | 80 | 8,5 | 30 | 6 | 4,9 | 2 | 1 | DIN2184-1 |
| 48336472 | 1/4 | 28 | 80 | 10,2 | 30 | 7 | 5,5 | 3 | 1 | DIN2184-1 |
| 48336476 | 5/16 | 24 | 90 | 11,3 | 35 | 8 | 6,2 | 3 | 1 | DIN2184-1 |
| 48336481 | 3/8 | 24 | 90 | 12,7 | 35 | 10 | 8 | 4 | 1 | DIN2184-1 |
| 48336486 | 7/16 | 20 | 100 | 14,5 | - | 8 | 6,2 | 4 | 2 | DIN2184-1 |
| 48336491 | 1/2 | 20 | 100 | 15,6 | - | 9 | 7 | 4 | 2 | DIN2184-1 |
| 48336496 | 9/16 | 18 | 100 | 16,9 | - | 11 | 9 | 4 | 2 | DIN2184-1 |
| 48336504 | 5/8 | 18 | 100 | 18,5 | - | 12 | 9 | 4 | 2 | DIN2184-1 |
| 48336517 | 3/4 | 16 | 110 | 25,4 | - | 14 | 11 | 4 | 2 | DIN2184-1 |
| 48336528 | 7/8 | 14 | 125 | 28,2 | - | 18 | 14,5 | 4 | 2 | DIN2184-1 |
| 48336539 | 1 | 12 | 140 | 31,8 | - | 18 | 14,5 | 4 | 2 | DIN2184-1 |

Threading | Cutting taps

UNF

M-SFT-DUPLEX

Threading | Cutting taps | UNJC



- Powder metal spiral-fluted cutting tap for blind holes
- TiN-coating for higher heat resistance
- For difficult materials such as 304L, 316L, 15-5PH & 17-4PH, Super Duplex 1.4410, Inconel 625

Threading | Cutting taps

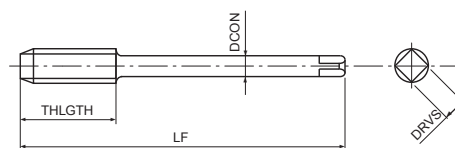
| | | | | | | | | | | |
|----------------------|----------------------------|-----------------------|-----------------|----------------------|-------------------------|---------------------|-------------------|-------------------|--|--|
| P C < 0,2% | P 0,25 < C < 0,4 | P C ≥ 0,45% | P SCM | M INOX | S Inconel 625 | S Ti Gr.2 | | | | |
| | | | | 3-15 Super Duplex | 2-3 15-5 PH | 3-6 17-4 PH | m/min | | | |
| UNJC | PM | TiN | 50° | ANSI 3BX | C/2,5 | | DIN 2184-1 | DIN 2184-1 | | |

| EDP | TD | TP | LF | THLGTH | LU | DCON | DRVS | NOF | Type | DIN |
|----------|------|----|-----|--------|----|------|------|-----|------|-----------|
| 48373457 | 4 | 40 | 56 | 5,1 | 18 | 3,5 | 2,7 | 2 | 1 | DIN2184-1 |
| 48373461 | 6 | 32 | 56 | 6,4 | 20 | 4 | 3 | 2 | 1 | DIN2184-1 |
| 48373464 | 8 | 32 | 63 | 6,4 | 21 | 4,5 | 3,4 | 2 | 1 | DIN2184-1 |
| 48373466 | 10 | 24 | 70 | 8,5 | 25 | 6 | 4,9 | 2 | 1 | DIN2184-1 |
| 48373468 | 12 | 24 | 80 | 8,5 | 30 | 6 | 4,9 | 2 | 1 | DIN2184-1 |
| 48373471 | 1/4 | 20 | 80 | 10,2 | 30 | 7 | 5,5 | 3 | 1 | DIN2184-1 |
| 48373474 | 5/16 | 18 | 90 | 11,3 | 35 | 8 | 6,2 | 3 | 1 | DIN2184-1 |
| 48373479 | 3/8 | 16 | 100 | 12,7 | 39 | 10 | 8 | 4 | 1 | DIN2184-1 |
| 48373484 | 7/16 | 14 | 100 | 14,5 | - | 8 | 6,2 | 4 | 2 | DIN2184-1 |
| 48373489 | 1/2 | 13 | 110 | 15,6 | - | 9 | 7 | 4 | 2 | DIN2184-1 |
| 48373494 | 9/16 | 12 | 110 | 16,9 | - | 11 | 9 | 4 | 2 | DIN2184-1 |
| 48373501 | 5/8 | 11 | 110 | 18,5 | - | 12 | 9 | 4 | 2 | DIN2184-1 |
| 48373515 | 3/4 | 10 | 125 | 25,4 | - | 14 | 11 | 4 | 2 | DIN2184-1 |
| 48373526 | 7/8 | 9 | 140 | 28,2 | - | 18 | 14,5 | 4 | 2 | DIN2184-1 |
| 48373538 | 1 | 8 | 160 | 31,8 | - | 18 | 14,5 | 4 | 2 | DIN2184-1 |

UNJC

M-SFT-DUPLEX

Threading | Cutting taps | G (BSP)



- Powder metal spiral-fluted cutting tap for blind holes
- TiN-coating for higher heat resistance
- For difficult materials such as 304L, 316L, 15-5PH & 17-4PH, Super Duplex 1.4410, Inconel 625

Threading | Cutting taps

| | | | | | | |
|----------------------|----------------------------|-----------------------|-----------------|----------------------|-------------------------|---------------------|
| P C < 0,2% | P 0,25 < C < 0,4 | P C ≥ 0,45% | P SCM | M INOX | S Inconel 625 | S Ti Gr.2 |
| | | | | 3-15 Super Duplex | 2-3 15-5 PH | 3-6 17-4 PH |
| G | PM | TiN | 50° | C/2,5 | | DIN 5156 |

| EDP | TD | TP | LF | THLGTH | DCON | DRVS | NOF | DIN |
|----------|-----|----|-----|--------|------|------|-----|------|
| 48336900 | 1/8 | 28 | 90 | 20 | 7 | 5,5 | 4 | 5156 |
| 48336000 | 1/4 | 19 | 100 | 22 | 11 | 9 | 4 | 5156 |
| 48336100 | 3/8 | 19 | 100 | 22 | 12 | 9 | 4 | 5156 |
| 48336200 | 1/2 | 14 | 125 | 25 | 16 | 12 | 4 | 5156 |
| 48336300 | 5/8 | 14 | 125 | 25 | 18 | 14,5 | 4 | 5156 |
| 48336400 | 3/4 | 14 | 140 | 28 | 20 | 16 | 4 | 5156 |
| 48336500 | 7/8 | 14 | 150 | 28 | 22 | 18 | 4 | 5156 |
| 48336600 | 1 | 11 | 160 | 30 | 25 | 20 | 4 | 5156 |
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G (BSP)



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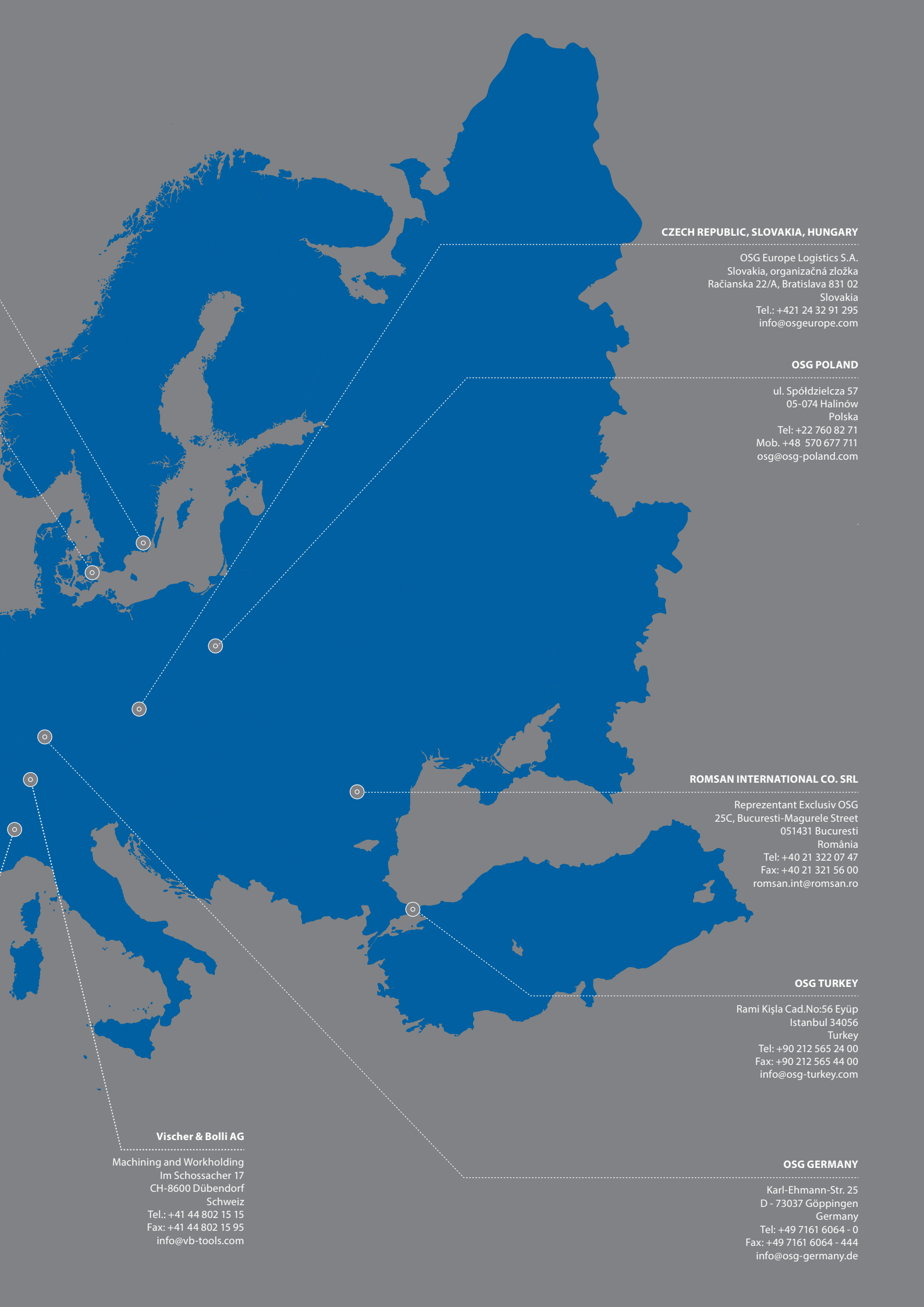
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