



***Der perfekte Allrounder***  
**The perfect Allrounder**

**NEW**  
LH / 6G /  
7G / 6H+0.1



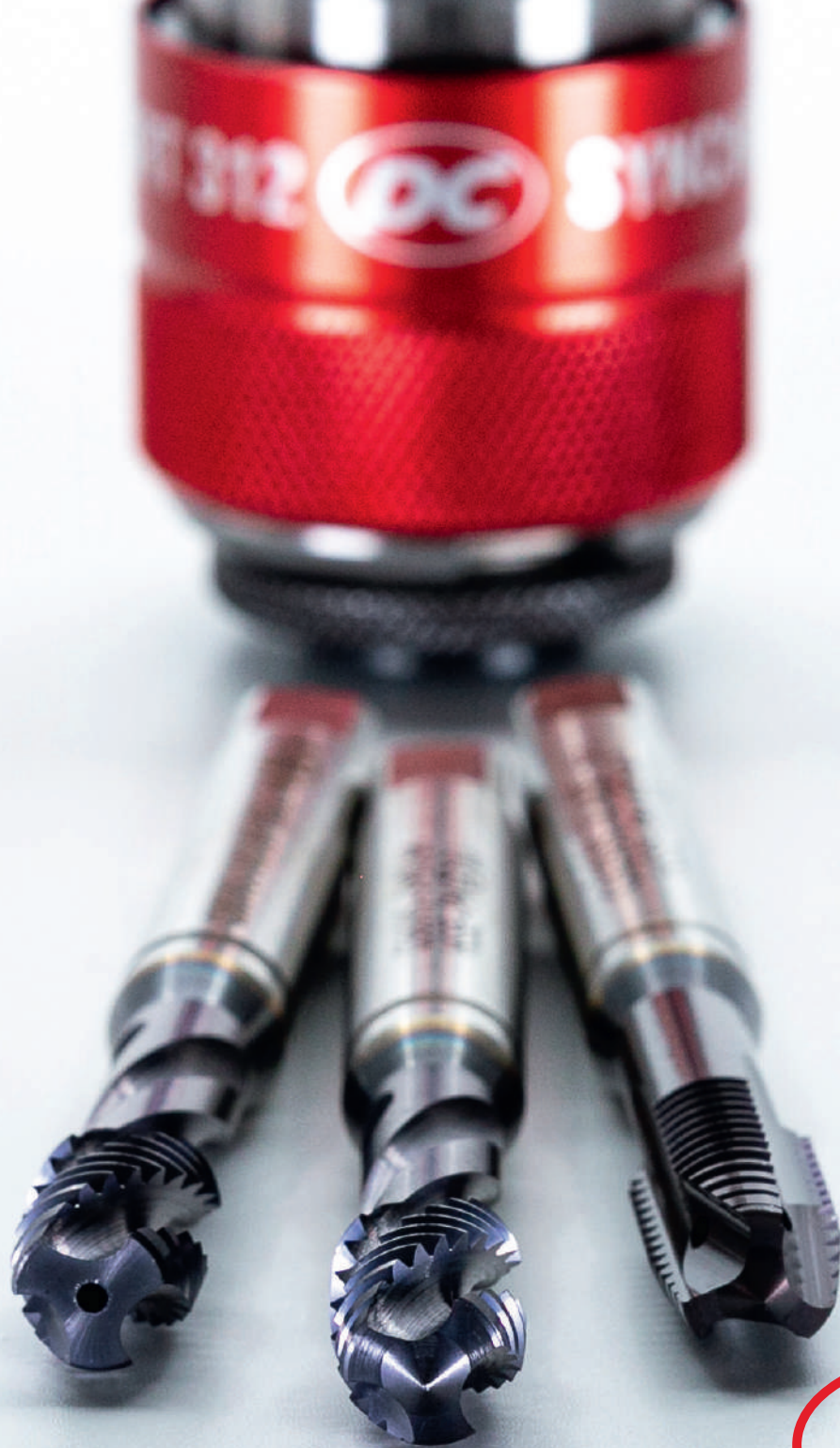
**QTAP**

DE-EN-ID QTAP.3



**THREADING SOLUTIONS**





THREADING SOLUTIONS






## VERFÜGBARKEIT DER ARTIKEL

- ID Lagerartikel
- ID Kurzfristig lieferbar






















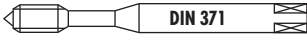

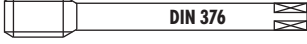
## AVAILABILITY OF THE ARTICLES

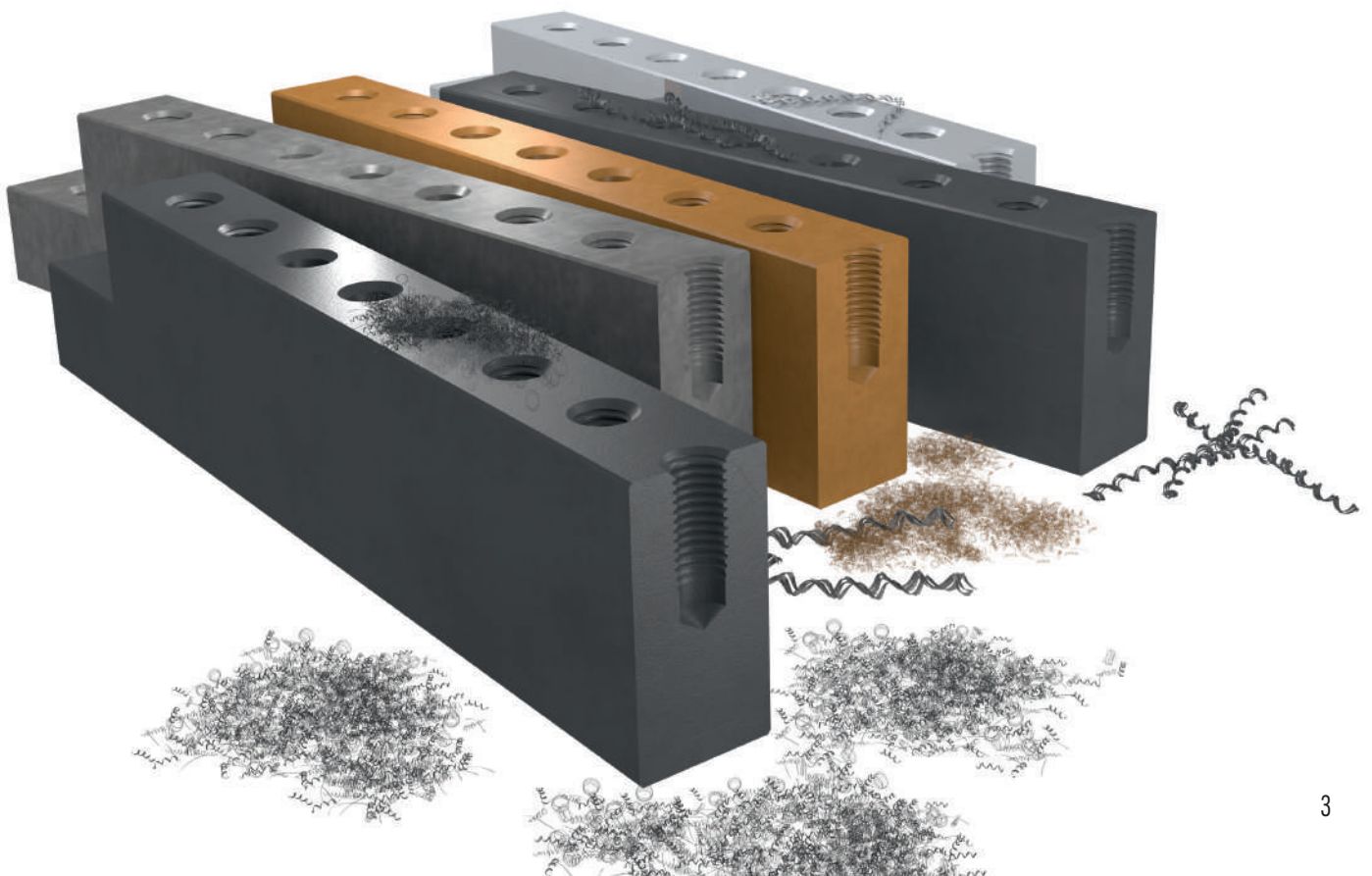
- ID Stock item
- ID Available at short notice

# REGISTER — REGISTER

|  | QTAP<br>QTAP  |  | QTAP<br>QTAP |            |    |   |   |          |    |   |   |          |    |          |    |          |    |  |   |          |     |          |            |          |            |          |            |    |  |
|--|---|---|--------------|------------|----|---|---|----------|----|---|---|----------|----|----------|----|----------|----|--|---|----------|-----|----------|------------|----------|------------|----------|------------|----|--|
| <b>M</b>   | <table border="0"> <tr><td>Q320VS-4</td><td>12</td><td>Q420VS-4</td><td>12</td></tr> <tr><td>Q323VS-4</td><td>12</td><td>Q423VS-4</td><td>12</td></tr> <tr><td>Q360VS-3</td><td>15</td><td>Q460VS-3</td><td>15</td></tr> <tr><td>Q363VS-3</td><td>15</td><td>Q463VS-3</td><td>15</td></tr> </table> | Q320VS-4  | 12           | Q420VS-4   | 12 | Q323VS-4  | 12  | Q423VS-4 | 12 | Q360VS-3  | 15  | Q460VS-3 | 15 | Q363VS-3 | 15 | Q463VS-3 | 15 | <b>EG UNF</b>  | <table border="0"> <tr><td>Q320VS-4</td><td>30</td><td>Q420VS-4</td><td>30</td></tr> <tr><td>Q360VS-3</td><td>31</td><td>Q460VS-3</td><td>31</td></tr> </table> | Q320VS-4 | 30  | Q420VS-4 | 30         | Q360VS-3 | 31         | Q460VS-3 | 31         |    |  |
| Q320VS-4   | 12  | Q420VS-4  | 12           |            |    |   |   |          |    |   |   |          |    |          |    |          |    |  |   |          |     |          |            |          |            |          |            |    |  |
| Q323VS-4   | 12  | Q423VS-4  | 12           |            |    |   |   |          |    |   |   |          |    |          |    |          |    |  |   |          |     |          |            |          |            |          |            |    |  |
| Q360VS-3   | 15  | Q460VS-3  | 15           |            |    |   |   |          |    |   |   |          |    |          |    |          |    |  |   |          |     |          |            |          |            |          |            |    |  |
| Q363VS-3   | 15  | Q463VS-3  | 15           |            |    |   |   |          |    |   |   |          |    |          |    |          |    |  |   |          |     |          |            |          |            |          |            |    |  |
| Q320VS-4   | 30  | Q420VS-4  | 30           |            |    |   |   |          |    |   |   |          |    |          |    |          |    |  |   |          |     |          |            |          |            |          |            |    |  |
| Q360VS-3   | 31  | Q460VS-3  | 31           |            |    |   |   |          |    |   |   |          |    |          |    |          |    |  |   |          |     |          |            |          |            |          |            |    |  |
| <b>BOXSETS</b>   | <table border="0"> <tr><td>Q320VS-4</td><td>11</td><td>Q360VS-3</td><td>11</td></tr> </table>   | Q320VS-4  | 11           | Q360VS-3   | 11 |  | <b>Synchron-Gewindeschneidfutter<br/>Tapping chucks</b> |          |    |   |   |          |    |          |    |          |    |  |   |          |     |          |            |          |            |          |            |    |  |
| Q320VS-4   | 11  | Q360VS-3  | 11           |            |    |   |   |          |    |   |   |          |    |          |    |          |    |  |   |          |     |          |            |          |            |          |            |    |  |
| <b>MF</b>  | <table border="0"> <tr><td>Q320VS-4</td><td>18</td><td>Q420VS-4</td><td>18</td></tr> <tr><td>Q323VS-4</td><td>18</td><td>Q423VS-4</td><td>18</td></tr> <tr><td>Q360VS-3</td><td>19</td><td>Q460VS-3</td><td>19</td></tr> <tr><td>Q363VS-3</td><td>19</td><td>Q463VS-3</td><td>19</td></tr> </table> | Q320VS-4  | 18           | Q420VS-4   | 18 | Q323VS-4  | 18  | Q423VS-4 | 18 | Q360VS-3  | 19  | Q460VS-3 | 19 | Q363VS-3 | 19 | Q463VS-3 | 19 | <table border="0"> <tr><td>SRT054-D12</td><td>33</td><td>ER8</td><td>33</td></tr> <tr><td>SRT312-D20</td><td>33</td><td>SRT312-D25</td><td>33</td><td>SRT520-D25</td><td>33</td></tr> </table> | SRT054-D12  | 33       | ER8 | 33       | SRT312-D20 | 33       | SRT312-D25 | 33       | SRT520-D25 | 33 |  |
| Q320VS-4   | 18  | Q420VS-4  | 18           |            |    |   |   |          |    |   |   |          |    |          |    |          |    |  |   |          |     |          |            |          |            |          |            |    |  |
| Q323VS-4   | 18  | Q423VS-4  | 18           |            |    |   |   |          |    |   |   |          |    |          |    |          |    |  |   |          |     |          |            |          |            |          |            |    |  |
| Q360VS-3   | 19  | Q460VS-3  | 19           |            |    |   |   |          |    |   |   |          |    |          |    |          |    |  |   |          |     |          |            |          |            |          |            |    |  |
| Q363VS-3   | 19  | Q463VS-3  | 19           |            |    |   |   |          |    |   |   |          |    |          |    |          |    |  |   |          |     |          |            |          |            |          |            |    |  |
| SRT054-D12   | 33  | ER8   | 33           |            |    |   |   |          |    |   |   |          |    |          |    |          |    |  |   |          |     |          |            |          |            |          |            |    |  |
| SRT312-D20   | 33  | SRT312-D25  | 33           | SRT520-D25 | 33 |   |   |          |    |   |   |          |    |          |    |          |    |  |   |          |     |          |            |          |            |          |            |    |  |
| <b>UNC</b>   | <table border="0"> <tr><td>Q320VS-4</td><td>20</td><td>Q420VS-4</td><td>20</td></tr> <tr><td>Q323VS-4</td><td>20</td><td>Q423VS-4</td><td>20</td></tr> <tr><td>Q360VS-3</td><td>21</td><td>Q460VS-3</td><td>21</td></tr> <tr><td>Q363VS-3</td><td>21</td><td>Q463VS-3</td><td>21</td></tr> </table> | Q320VS-4  | 20           | Q420VS-4   | 20 | Q323VS-4  | 20  | Q423VS-4 | 20 | Q360VS-3  | 21  | Q460VS-3 | 21 | Q363VS-3 | 21 | Q463VS-3 | 21 |  |   |          |     |          |            |          |            |          |            |    |  |
| Q320VS-4   | 20  | Q420VS-4  | 20           |            |    |   |   |          |    |   |   |          |    |          |    |          |    |  |   |          |     |          |            |          |            |          |            |    |  |
| Q323VS-4   | 20  | Q423VS-4  | 20           |            |    |   |   |          |    |   |   |          |    |          |    |          |    |  |   |          |     |          |            |          |            |          |            |    |  |
| Q360VS-3   | 21  | Q460VS-3  | 21           |            |    |   |   |          |    |   |   |          |    |          |    |          |    |  |   |          |     |          |            |          |            |          |            |    |  |
| Q363VS-3   | 21  | Q463VS-3  | 21           |            |    |   |   |          |    |   |   |          |    |          |    |          |    |  |   |          |     |          |            |          |            |          |            |    |  |
| <b>UNF</b>   | <table border="0"> <tr><td>Q320VS-4</td><td>22</td><td>Q420VS-4</td><td>22</td></tr> <tr><td>Q323VS-4</td><td>22</td><td>Q423VS-4</td><td>22</td></tr> <tr><td>Q360VS-3</td><td>23</td><td>Q460VS-3</td><td>23</td></tr> <tr><td>Q363VS-3</td><td>23</td><td>Q463VS-3</td><td>23</td></tr> </table> | Q320VS-4  | 22           | Q420VS-4   | 22 | Q323VS-4  | 22  | Q423VS-4 | 22 | Q360VS-3  | 23  | Q460VS-3 | 23 | Q363VS-3 | 23 | Q463VS-3 | 23 |   |   |          |     |          |            |          |            |          |            |    |  |
| Q320VS-4   | 22  | Q420VS-4  | 22           |            |    |   |   |          |    |   |   |          |    |          |    |          |    |  |   |          |     |          |            |          |            |          |            |    |  |
| Q323VS-4   | 22  | Q423VS-4  | 22           |            |    |   |   |          |    |   |   |          |    |          |    |          |    |  |   |          |     |          |            |          |            |          |            |    |  |
| Q360VS-3   | 23  | Q460VS-3  | 23           |            |    |   |   |          |    |   |   |          |    |          |    |          |    |  |   |          |     |          |            |          |            |          |            |    |  |
| Q363VS-3   | 23  | Q463VS-3  | 23           |            |    |   |   |          |    |   |   |          |    |          |    |          |    |  |   |          |     |          |            |          |            |          |            |    |  |
| <b>G</b>   | <table border="0"> <tr><td>Q420VS-4</td><td>24</td><td>Q423VS-4</td><td>24</td></tr> <tr><td>Q460VS-3</td><td>25</td><td>Q463VS-3</td><td>25</td></tr> </table>   | Q420VS-4  | 24           | Q423VS-4   | 24 | Q460VS-3  | 25  | Q463VS-3 | 25 |   | <p>Technischer Fragebogen<br/>Liefer- und Zahlungsbedingungen</p> <p><b>Weitere Informationen finden Sie unter</b><br/><a href="http://www.dcswiss.com">www.dcswiss.com</a></p> |          |    |          |    |          |    |  |   |          |     |          |            |          |            |          |            |    |  |
| Q420VS-4   | 24  | Q423VS-4  | 24           |            |    |   |   |          |    |   |   |          |    |          |    |          |    |  |   |          |     |          |            |          |            |          |            |    |  |
| Q460VS-3   | 25  | Q463VS-3  | 25           |            |    |   |   |          |    |   |   |          |    |          |    |          |    |  |   |          |     |          |            |          |            |          |            |    |  |
| <b>EG M</b>  | <table border="0"> <tr><td>Q320VS-4</td><td>26</td><td>Q420VS-4</td><td>26</td></tr> <tr><td>Q360VS-3</td><td>27</td><td>Q460VS-3</td><td>27</td></tr> </table>   | Q320VS-4  | 26           | Q420VS-4   | 26 | Q360VS-3  | 27  | Q460VS-3 | 27 |  |   |          |    |          |    |          |    |  |   |          |     |          |            |          |            |          |            |    |  |
| Q320VS-4   | 26  | Q420VS-4  | 26           |            |    |   |   |          |    |   |   |          |    |          |    |          |    |  |   |          |     |          |            |          |            |          |            |    |  |
| Q360VS-3   | 27  | Q460VS-3  | 27           |            |    |   |   |          |    |   |   |          |    |          |    |          |    |  |   |          |     |          |            |          |            |          |            |    |  |
| <b>EG UNC</b>  | <table border="0"> <tr><td>Q320VS-4</td><td>28</td><td>Q420VS-4</td><td>28</td></tr> <tr><td>Q360VS-3</td><td>29</td><td>Q460VS-3</td><td>29</td></tr> </table>   | Q320VS-4  | 28           | Q420VS-4   | 28 | Q360VS-3  | 29  | Q460VS-3 | 29 |   | <p>Technical questionnaire<br/>Delivery and payment conditions</p> <p><b>Further information are available on</b><br/><a href="http://www.dcswiss.com">www.dcswiss.com</a></p>  |          |    |          |    |          |    |  |   |          |     |          |            |          |            |          |            |    |  |
| Q320VS-4   | 28  | Q420VS-4  | 28           |            |    |   |   |          |    |   |   |          |    |          |    |          |    |  |   |          |     |          |            |          |            |          |            |    |  |
| Q360VS-3   | 29  | Q460VS-3  | 29           |            |    |   |   |          |    |   |   |          |    |          |    |          |    |  |   |          |     |          |            |          |            |          |            |    |  |

# PIKTOGRAMME — PICTOGRAPHS

|  |  |  |  |
|--|--|--|--|
|    | DC-"VS"-Verschleisschutzschicht für den allgemeinen Einsatz<br>DC "VS" wear-protective coating for general use |     | Gerade Nuten mit Schälanschnitt<br>Straight flutes with spiral point                         |
|    | HSSE-PM<br>HSSE-PM   |     | Spiralnuten mit 40° Rechtsdrall<br>40° right-hand spiral flutes                              |
|    | HSSE<br>HSSE   |     | Spiralnuten mit 40° Linksdrall<br>40° left-hand spiral flutes                                |
|    | Linksgewinde<br>Left-hand thread   |     | Durchgangsloch, langspanende Werkstoffe<br>Through hole, long chipping materials             |
|    | Toleranzklasse ISO 2 6H<br>Tolerance class ISO 2 6H  |     | Sackloch < 2.5 x D, langspanende Werkstoffe<br>Blind hole < 2.5 x D, long chipping materials |
|    | Toleranzklasse ISO 2 6H + 0.1 mm<br>Tolerance class ISO 2 6H + 0.1 mm  |     | 2 - 3 Gewindegänge, Anschnitt Form C<br>2 - 3 chamfered threads, lead form C                 |
|    | Toleranzklasse ISO 3 6G<br>Tolerance class ISO 3 6G  |     | 3.5 - 5.5 Gewindegänge, Anschnitt Form B<br>3.5 - 5.5 chamfered threads, lead form B         |
|    | Toleranzklasse 7G<br>Tolerance class 7G  |     | Kernlochdurchmesser<br>Core hole diameter  |
|   | Für synchrones Gewindeschneiden<br>For Rigid Tapping   |    | Anzahl Spannuten (Z)<br>Number of flutes (Z)   |
|  | Für klassisches Gewindeschneiden<br>For Classic Tapping  |   | EG-Gewinde (für Drahteinsatzgewinde)<br>Thread EG (for wire screw thread inserts)            |
|  | Innenkühlung mit stirnseitigem Schmiermittelaustritt<br>Internal coolant with frontal outflow                  |  | Verstärkter Schaft gemäss DIN 371<br>Reinforced shank as per DIN 371                         |
|  | Innenkühlung mit seitlichem Schmiermittelaustritt 45°<br>Internal coolant with radial outflow 45°              |  | Durchfallender Schaft gemäss DIN 376<br>Reduced shank as per DIN 376                         |





## THREADING SOLUTIONS

# MEHRWERT SCHAFFEN DURCH TECHNOLOGIE UND DIENSTLEISTUNGEN

**Mit 80 Jahren Erfahrung in der Gewindetechnologie gehört die DC SWISS SA zu den weltweit führenden Herstellern von hoch qualitativen Gewindewerkzeugen.**

*Der stetig steigende Bedarf der Industrie an Gewindewerkzeugen kann nur mit technologischen Lösungen gedeckt werden. DC-Gewindewerkzeuge garantieren hohe Präzision und einen sicheren Fertigungsprozess.*

*Unsere weltweite Präsenz mit entsprechender Kundennähe und Betreuung durch unsere Gewindespezialisten gewährleisten die Herstellung hoch präziser Gewinde.*

*Konstante Forschung nach neuen technischen Lösungen mit fortwährenden Investitionen in den neusten Stand der Technik und hoch qualifizierte Mitarbeitende machen uns zu Ihrem idealen Partner für alle Gewindeverbindungen.*

# CREATING VALUE THROUGH TECHNOLOGY & SERVICES

**With 80 years of experience in threading technology, DC SWISS SA is one of the world's leading manufacturers of high-quality precision threading tools.**

*The increasing demand of the industry on threading tools can only be met with technological solutions.*

*DC threading tools guarantee high performance and a safe manufacturing process.*

*Our worldwide presence, customer proximity and our threading specialists assure the manufacture of high-precision threads. Constant research in new technical solutions and continuous investments in state of the art technology and highly qualified human resources make us your perfect partner for all threaded connections.*

*Dieser Allzweck-Gewindebohrer mit perfekter Spankontrolle setzt neue Maßstäbe im NC-Gewindschneidprozess.*

DC SWISS SA steht für  
**FUNKTIONALITÄT,  
VIELSEITIGKEIT & LEISTUNG**

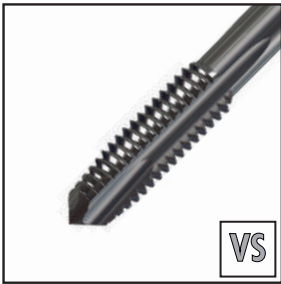
This multi-purpose tap with perfect chip control sets new rules in the NC-tapping process.

DC SWISS SA stands for  
**FUNCTIONALITY,  
UNIVERSALITY & PERFORMANCE**



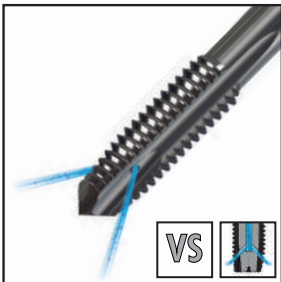
# SPEZIFIZIERUNGEN — SPECIFICATIONS

## Q.20VS



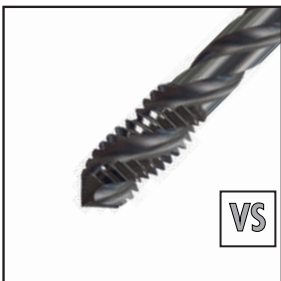
- Für Durchgangslöcher
- Mit Schälanschnitt
- Optimierte Schneidengeometrie und Schneidkanten
- DC-"VS"-Verschleisschutzschicht für den allgemeinen Einsatz  
\*\*\* \*\*
- For through holes
- Spiral point
- Geometry and cutting edges optimised
- DC "VS" wear-protective coating for general use

## Q.23VS



- Für Durchgangslöcher
- Mit Schälanschnitt
- Optimierte Schneidengeometrie und Schneidkanten
- DC-"VS"-Verschleisschutzschicht für den allgemeinen Einsatz
- Innenkühlung mit seitlichem Schmiermittelaustritt  
\*\*\* \*\*
- For through holes
- Spiral point
- Geometry and cutting edges optimised
- DC "VS" wear-protective coating for general use
- Internal coolant with radial outflow

## Q.60VS

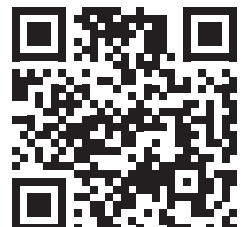


- Für Sacklöcher
- Mit starken Spiralnuten
- Optimierte Schneidengeometrie und Schneidkanten
- DC-"VS"-Verschleisschutzschicht für den allgemeinen Einsatz  
\*\*\* \*\*
- For blind holes
- Spiral flutes
- Geometry and cutting edges optimised
- DC "VS" wear-protective coating for general use

## Q.63VS



- Für Sacklöcher
- Mit starken Spiralnuten
- Optimierte Schneidengeometrie und Schneidkanten
- DC-"VS"-Verschleisschutzschicht für den allgemeinen Einsatz
- Innenkühlung mit stirnseitigem Schmiermittelaustritt  
\*\*\* \*\*
- For blind holes
- Spiral flutes
- Geometry and cutting edges optimised
- DC "VS" wear-protective coating for general use
- Internal coolant with frontal outflow

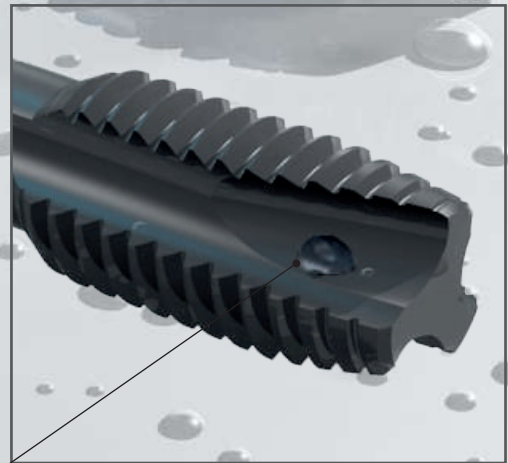


## SPEZIFIZIERUNGEN — SPECIFICATIONS

**PERFEKTE INTERAKTION ZWISCHEN SCHNEIDENGEOMETRIE,  
SCHNEIDKANTEN UND DER NEUEN VS-BESCHICHTUNG**  
**PERFECT INTERACTION BETWEEN GEOMETRY,  
CUTTING EDGES AND THE NEW VS COATING**

**SPEZIELLES BASIS-MATERIAL**  
**SPECIFIC BASIC MATERIAL**

**HÖHERE LEISTUNG DANK INNENKÜHLUNG**  
**INCREASED PERFORMANCE THANKS TO  
INTERNAL COOLANT**



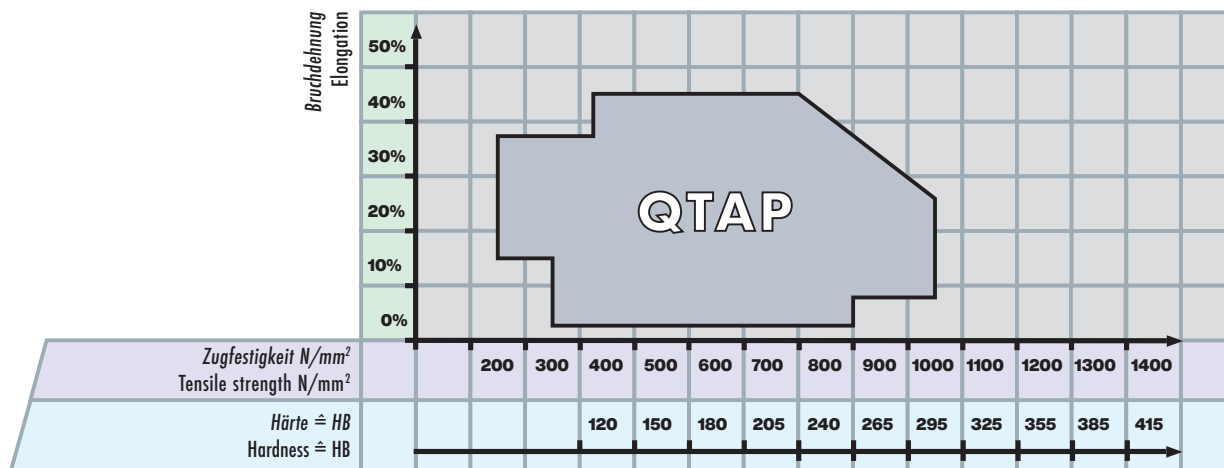
**Der DC-QTAP kann für verschiedenste Werkstoffe eingesetzt werden, wie für Kohlenstoffstähle, Vergütungsstähle, rostfreie Stähle, Aluminium, Guss, Messing.**

*Die innovative geometrische Konstruktion in Kombination mit den perfekten Schneidkanten und der neuen VS-Beschichtung erlaubt die Bearbeitung verschiedenster Werkstoffe und vielfältige Anwendungen.*

**The DC QTAP cuts a wide range of materials – carbon steels, alloy steels, stainless steels, aluminium, cast iron, brass alloys.**

*The innovative geometric design in combination with the perfect cutting edges and the new VS coating allows to handle various materials and applications.*

# ANWENDUNGSTABELLE QTAP – APPLICATION CHART QTAP



## DC -Anwendungsgruppen

## DC Material classification

| Werkstoff-Gruppen<br>Material groups                | Werkstoffbezeichnung  | Material designation  | Härte<br>Hardness<br>(HB) | Festigkeit<br>Tensile<br>strength<br>R <sub>m</sub> (N/mm <sup>2</sup> ) | Dehnung<br>Elongation<br>A (%) |
|---|---|---|---------------------------|--|--------------------------------|
| 10 Stahl<br>Steels                                  | 11 Automatenstahl   | Free-cutting steels   | < 200                     | < 700  | < 10                           |
|   | 12 Baustahl, Einsatzstahl                                     | Structural, cementation steels                              | < 200                     | < 700  | < 30                           |
|   | 13 Kohlenstoffstahl   | Carbon steels   | < 300                     | < 1000   | < 20                           |
|   | 14 Stahl legiert < 850 N/mm <sup>2</sup>                      | Alloy steels < 850 N/mm <sup>2</sup>                        | < 250                     | < 850  | < 30                           |
|   | 15 Stahl legiert / vergütet > 850 - < 1150 N/mm <sup>2</sup>  | Alloy steels hard. / temp. > 850 - < 1150 N/mm <sup>2</sup> | > 250                     | > 850  | < 30                           |
|   | 16 Hochfester Stahl ≤ 44 HRC                                  | High tensile alloy steels ≤ 44 HRC                          | > 250                     | > 850  | < 12                           |
|   | 17 Stahl vergütet > 44 - ≤ 54 HRC                             | Alloy steels tempered > 44 - ≤ 54 HRC                       | > 410                     | > 1400   | < 2                            |
|   | 18 Stahl gehärtet > 54 - ≤ 63 HRC                             | Alloy steels hardened > 54 - ≤ 63 HRC                       | > 560                     | > 1980   | < 2                            |
| 20 Rostfreier Stahl<br>Stainless steels             | 21 Rostfreier Stahl, geschwefelt                              | Free machining stainless steels                             | < 250                     | < 850  | < 25                           |
|   | 22 Austenitisch   | Austenitic stainless steels                                 | < 250                     | < 850  | > 20                           |
|   | 23 Ferritisch, martensitisch < 850 N/mm <sup>2</sup>          | Ferritic and martensitic < 850 N/mm <sup>2</sup>            | < 250                     | < 850  | > 20                           |
|   | 24 Ferritisch, martensitisch > 850 - < 1150 N/mm <sup>2</sup> | Ferritic and martensitic > 850 - < 1150 N/mm <sup>2</sup>   | > 250                     | > 850  | > 15                           |
| 30 Guss<br>Cast iron                                | 31 Grauguss   | Cast iron   | < 250                     | < 850  | < 10                           |
|   | 32 Kugelgraphitguss, Temperguss                               | Spheroidal graphite + malleable cast iron                   | < 250                     | < 850  | > 10                           |
| 40 Titan<br>Titanium                                | 41 Reintitan  | Pure titanium   | < 250                     | < 850  | > 20                           |
|   | 42 Titanlegierung   | Titanium alloys   | > 250                     | > 850  | < 20                           |
| 50 Nickel<br>Nickel                                 | 51 Nickellegierung 1 ≤ 850 N/mm <sup>2</sup>                  | Nickel alloys 1 ≤ 850 N/mm <sup>2</sup>                     | < 250                     | < 850  | > 25                           |
|   | 52 Nickellegierung 2 > 850 - ≤ 1150 N/mm <sup>2</sup>         | Nickel alloys 2 > 850 - ≤ 1150 N/mm <sup>2</sup>            | > 250                     | > 850  | < 25                           |
|   | 53 Nickellegierung 3 > 1150 - ≤ 1600 N/mm <sup>2</sup>        | Nickel alloys 3 > 1150 - ≤ 1600 N/mm <sup>2</sup>           | > 340                     | > 1150   | < 20                           |
| 60 Kupfer<br>Copper                                 | 61 Reinkupfer (Elektrolytkupfer)                              | Pure copper (electrolytic copper)                           | < 120                     | < 400  | > 12                           |
|   | 62 Messing, Bronze, Rotguss (kurzspanend)                     | Short chip brass, phosphor bronze, gun metal                | < 200                     | < 700  | < 12                           |
|   | 63 Messing (langspanend)                                      | Long chip brass   | < 200                     | < 700  | > 12                           |
|   | 64 Messing bleifrei   | Lead free brass   | < 220                     | < 700  | > 15                           |
| 70 Aluminium<br>Magnesium<br>Aluminium<br>Magnesium | 71 Al unlegiert   | Al unalloyed  | < 100                     | < 350  | > 15                           |
|   | 72 Al legiert Si < 1.5 %                                      | Al alloyed Si < 1.5 %                                       | < 150                     | < 500  | > 15                           |
|   | 73 Al legiert Si > 1.5 % - < 10 %                             | Al alloyed Si > 1.5 % - < 10 %                              | < 120                     | < 400  | < 15                           |
|   | 74 Al legiert Si > 10 %, Mg-Legierungen                       | Al alloyed Si > 10 %, Mg-alloys                             | < 120                     | < 400  | < 10                           |
| 80 Kunststoff<br>Plastic compounds                  | 81 Thermoplaste   | Thermoplastics  | -                         | -  | -                              |
|   | 82 Duroplaste   | Duroplastics  | -                         | -  | -                              |
|   | 83 Faserverstärkte Kunststoffe                                | Glass fibre reinforced plastics                             | -                         | -  | -                              |
| 90 Edelmetalle<br>Precious metals                   | 91 Gelbgold   | Yellow gold   | -                         | -  | -                              |
|   | 92 Rotgold  | Red gold  | -                         | -  | -                              |
|   | 93 Weissgold  | White gold  | -                         | -  | -                              |
|   | 94 Silber   | Silver  | -                         | -  | -                              |

Optimal mit Schneidöl  
Optimal with cutting oil

Geeignet mit Schneidöl  
Suitable with cutting oil


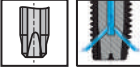














Optimal mit Emulsion  
Optimal with emulsion

Geeignet mit Emulsion  
Suitable with emulsion



# Inhaltsverzeichnis — Maschinengewindebohrer QTAP

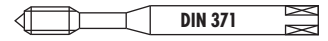
## Directory — Machine taps QTAP







|                             |                | QTAP   |   |  |   |   |   |  |   |
|-----------------------------|----------------|--|---|--|---|---|---|--|---|
| Merkmale<br>Characteristics |                |  VS |   |  VS |   |  R40 VS |   |  R40 VS |   |
| Typ<br>Type                 |                | Q320VS-4   | Q420VS-4  | Q323VS-4   | Q423VS-4  | Q360VS-3  | Q460VS-3  | Q363VS-3   | Q463VS-3  |
|                             |                |     |  |     |  |          |  |         |  |
| Lochart<br>Hole type        |                |     |   |     |   |        |   |         |   |
| M ISO 2 6H                  | ISO DIN 13     | 12   | 12  | 12   | 12  | 15  | 15  | 15   | 15  |
| M ISO 3 6G                  | ISO DIN 13     | 13   |   |  |   | 16  | 16  |  |   |
| M 7G                        | ISO DIN 13     | 14   |   |  |   | 17  | 17  |  |   |
| M 6H + 0.1mm                | ISO DIN 13     | 14   |   |  |   | 17  |   |  |   |
| M ISO 2 6H<br>LH            | ISO DIN 13     | 13   | 13  |  |   | 16  | 16  |  |   |
| MF ISO 2 6H                 | ISO DIN 13     | 18   | 18  | 18   | 18  | 19  | 19  | 19   | 19  |
| UNC 2B                      | ASME B1.1      | 20   | 20  | 20   | 20  | 21  | 21  | 21   | 21  |
| UNF 2B                      | ASME B1.1      | 22   | 22  | 22   | 22  | 23  | 23  | 23   | 23  |
| G                           | DIN EN ISO 228 |  | 24  |  | 24  |   | 25  |  | 25  |
| EG M 6H mod                 | ISO DIN 8140   | 26   | 26  |  |   | 27  | 27  |  |   |
| EG UNC 3B                   | ASME B18.29.1  | 28   | 28  |  |   | 29  | 29  |  |   |
| EG UNF 3B                   | ASME B18.29.1  | 30   | 30  |  |   | 31  | 31  |  |   |
|                             |                | <b>BOXSET</b>  |   |  |   | <b>BOXSET</b>   |   |  |   |
| M ISO 2 6H                  | ISO DIN 13     | 11   |   |  |   | 11  |   |  |   |

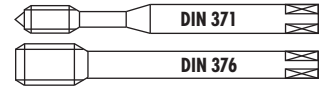
**Gewindebohrer-Sortimente — QTAP**  
**Tap assortments — QTAP**



PM



|  |  |
|--|--|
| <p><b>BOXSET</b></p>   | <p><b>D5893</b></p>  |
| <p><b>Q320VS-4</b></p>  <p><b>M3, M4, M5, M6, M8, M10</b></p>      |    |
| <p>No<br/>D5893</p>  | <p><b>ID</b></p>   |
| <p>M3 - M10</p>  | <p>● 197104</p>  |
| <p><b>BOXSET</b></p>   | <p><b>D5897</b></p>  |
| <p><b>Q360VS-3</b></p>  <p><b>M3, M4, M5, M6, M8, M10</b></p>  |  |
| <p>No<br/>D5897</p>  | <p><b>ID</b></p>   |
| <p>M3 - M10</p>  | <p>● 197105</p>  |



# QTAP

**Q320VS-4**



VS

**Q420VS-4**



VS

**Q323VS-4**

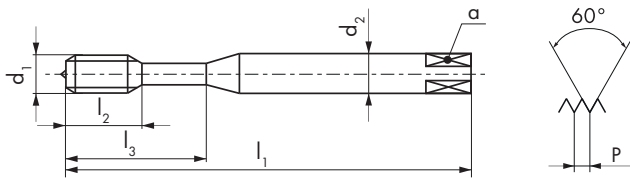


VS

**Q423VS-4**



VS



**Q320VS-4**

**Q420VS-4**

**Q323VS-4**

**Q423VS-4**

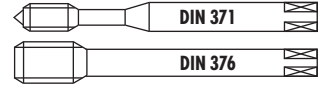


| $\emptyset d_1$<br>M | P<br>mm | $l_1$<br>mm | $l_2$<br>mm | $l_3$<br>mm | $d_2$<br>mm | a<br>mm |   |      |
|----------------------|---------|-------------|-------------|-------------|-------------|---------|---|------|
| * 2                  | 0.4     | 45          | 8           | 12          | 2.8         | 2.1     | 2 | 1.6  |
| 2.5                  | 0.45    | 50          | 10          | 14.5        | 2.8         | 2.1     | 3 | 2.05 |
| 3                    | 0.5     | 56          | 12          | 18          | 3.5         | 2.7     | 3 | 2.5  |
| 4                    | 0.7     | 63          | 14          | 21          | 4.5         | 3.4     | 3 | 3.3  |
| 5                    | 0.8     | 70          | 15          | 25          | 6           | 4.9     | 3 | 4.2  |
| 6                    | 1       | 80          | 17          | 30          | 6           | 4.9     | 3 | 5    |
| 8                    | 1.25    | 90          | 20          | 35          | 8           | 6.2     | 3 | 6.8  |
| 10                   | 1.5     | 100         | 22          | 39          | 10          | 8       | 3 | 8.5  |
| 12                   | 1.75    | 110         | 24          |             | 9           | 7       | 3 | 10.2 |
| 14                   | 2       | 110         | 28          |             | 11          | 9       | 3 | 12   |
| 16                   | 2       | 110         | 30          |             | 12          | 9       | 3 | 14   |
| 20                   | 2.5     | 140         | 36          |             | 16          | 12      | 4 | 17.5 |
| 24                   | 3       | 160         | 39          |             | 18          | 14.5    | 4 | 21   |

| ID       | ID       | ID       | ID       |
|----------|----------|----------|----------|
| ● 199365 |          |          |          |
| ● 199366 |          |          |          |
| ● 195494 |          | ● 195505 |          |
| ● 195495 |          | ● 195506 |          |
| ● 195496 |          | ● 195507 |          |
| ● 195497 |          | ● 195508 |          |
| ● 195498 |          | ● 195509 |          |
| ● 195499 |          | ● 195510 |          |
|          | ● 195500 |          | ● 195511 |
|          | ● 195501 |          | ● 195512 |
|          | ● 195502 |          | ● 195513 |
|          | ● 195503 |          | ● 195514 |
|          | ● 195504 |          | ● 195515 |

\* Q320VS-3





# QTAP

Q320VS-4 LH



VS

LH

11 12 13 14

15 21 22 23

24 31 32 51

Q420VS-4 LH



VS

LH

52 61 62 63

64 71 72 73

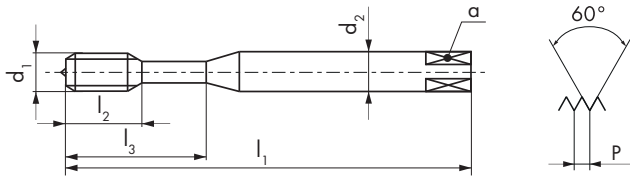
74 81 82 83

Q320VS-4



VS

91 92 94



Q320VS-4 LH

Q420VS-4 LH

Q320VS-4



NEW





NEW



NEW



| $\emptyset d_1$<br>M | P<br>mm | $l_1$<br>mm | $l_2$<br>mm | $l_3$<br>mm | $d_2$<br>mm | a<br>mm |  |  6H | ID       | ID       | ID       | 6H<br>+ mm |
|----------------------|---------|-------------|-------------|-------------|-------------|---------|---|--|----------|----------|----------|------------|
| * 2                  | 0.4     | 45          | 8           | 12          | 2.8         | 2.1     | 2   | 1.6  |          |          | ● 210292 | 0.019      |
| 2.5                  | 0.45    | 50          | 10          | 14.5        | 2.8         | 2.1     | 3   | 2.05   |          |          | ● 210293 | 0.020      |
| 3                    | 0.5     | 56          | 12          | 18          | 3.5         | 2.7     | 3   | 2.5  |          |          | ● 210294 | 0.020      |
| 4                    | 0.7     | 63          | 14          | 21          | 4.5         | 3.4     | 3   | 3.3  | ● 210278 |          | ● 210295 | 0.022      |
| 5                    | 0.8     | 70          | 15          | 25          | 6           | 4.9     | 3   | 4.2  | ● 210279 |          | ● 210296 | 0.024      |
| 6                    | 1       | 80          | 17          | 30          | 6           | 4.9     | 3   | 5  | ● 210280 |          | ● 210297 | 0.026      |
| 8                    | 1.25    | 90          | 20          | 35          | 8           | 6.2     | 3   | 6.8  | ● 210281 |          | ● 210298 | 0.028      |
| 10                   | 1.5     | 100         | 22          | 39          | 10          | 8       | 3   | 8.5  | ● 210282 |          | ● 210299 | 0.032      |
| 12                   | 1.75    | 110         | 24          |             | 9           | 7       | 3   | 10.2   |          | ● 210283 |          |            |
| 16                   | 2       | 110         | 30          |             | 12          | 9       | 3   | 14   |          | ● 210284 |          |            |

\* Q320VS-3





# QTAP

Q320VS-4



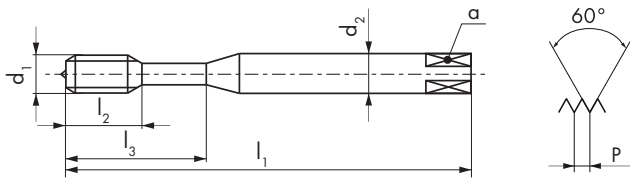
VS

Q320VS-4



VS

- 11 12 13 14
- 15 21 22 23
- 24 31 32 51
- 52 61 62 63
- 64 71 72 73
- 74 81 82 83
- 91 92 94



Q320VS-4

Q320VS-4



NEW



NEW



| $\emptyset d_1$<br>M | P<br>mm | $l_1$<br>mm | $l_2$<br>mm | $l_3$<br>mm | $d_2$<br>mm | a<br>mm |   | $\emptyset 6H$<br>mm |
|----------------------|---------|-------------|-------------|-------------|-------------|---------|---|----------------------|
| 3                    | 0.5     | 56          | 12          | 18          | 3.5         | 2.7     | 3 | 2.5                  |
| 4                    | 0.7     | 63          | 14          | 21          | 4.5         | 3.4     | 3 | 3.3                  |
| 5                    | 0.8     | 70          | 15          | 25          | 6           | 4.9     | 3 | 4.2                  |
| 6                    | 1       | 80          | 17          | 30          | 6           | 4.9     | 3 | 5                    |
| 8                    | 1.25    | 90          | 20          | 35          | 8           | 6.2     | 3 | 6.8                  |
| 10                   | 1.5     | 100         | 22          | 39          | 10          | 8       | 3 | 8.5                  |

ID 6H  
+ mm

ID

- 210300 0.036
- 210301 0.041
- 210302 0.044
- 210303 0.050
- 210304 0.052
- 210305 0.060

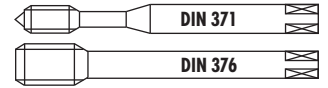
- 210322
- 210323
- 210324
- 210325
- 210326
- 210327



≤ Ø 16 > Ø 16

PM

HSSE



# QTAP

**Q360VS-3**



VS

**Q460VS-3**



VS

**Q363VS-3**



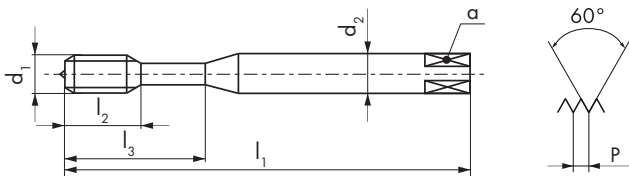
VS

**Q463VS-3**



VS

- 11 12 13 14
- 15 21 22 23
- 24 31 32 51
- 52 61 62 63
- 64 71 72 73
- 74 81 82 83
- 91 92 94



**Q360VS-3**

**Q460VS-3**

**Q363VS-3**

**Q463VS-3**



| Ø d <sub>1</sub><br>M | P<br>mm | l <sub>1</sub><br>mm | l <sub>2</sub><br>mm | l <sub>3</sub><br>mm | d <sub>2</sub><br>mm | a<br>mm |   |      |
|-----------------------|---------|----------------------|----------------------|----------------------|----------------------|---------|---|------|
| 2                     | 0.4     | 45                   | 7                    | 12                   | 2.8                  | 2.1     | 2 | 1.6  |
| 2.5                   | 0.45    | 50                   | 9                    | 14.5                 | 2.8                  | 2.1     | 2 | 2.05 |
| 3                     | 0.5     | 56                   | 5.5                  | 18                   | 3.5                  | 2.7     | 3 | 2.5  |
| 4                     | 0.7     | 63                   | 7.5                  | 21                   | 4.5                  | 3.4     | 3 | 3.3  |
| 5                     | 0.8     | 70                   | 9                    | 25                   | 6                    | 4.9     | 3 | 4.2  |
| 6                     | 1       | 80                   | 11                   | 30                   | 6                    | 4.9     | 3 | 5    |
| 8                     | 1.25    | 90                   | 12.5                 | 35                   | 8                    | 6.2     | 3 | 6.8  |
| 10                    | 1.5     | 100                  | 14                   | 39                   | 10                   | 8       | 3 | 8.5  |
| 12                    | 1.75    | 110                  | 14                   |                      | 9                    | 7       | 3 | 10.2 |
| 14                    | 2       | 110                  | 14                   |                      | 11                   | 9       | 3 | 12   |
| 16                    | 2       | 110                  | 18                   |                      | 12                   | 9       | 3 | 14   |
| 20                    | 2.5     | 140                  | 24                   |                      | 16                   | 12      | 3 | 17.5 |
| 24                    | 3       | 160                  | 27                   |                      | 18                   | 14.5    | 4 | 21   |

ID

ID

ID

ID

● 199367

● 199368

● 195516

● 195527

● 195517

● 195528

● 195518

● 195529

● 195519

● 195530

● 195520

● 195531

● 195521

● 195532

● 195522 ● 195533

● 195523 ● 195534

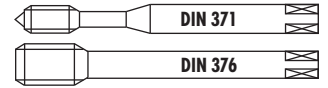
● 195524 ● 195535

● 195525 ● 195536

● 195526 ● 195537



PM



# QTAP

Q360VS-3 LH



VS

LH

Q460VS-3 LH



VS

LH

Q360VS-3



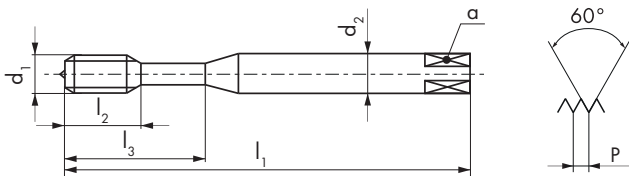
VS

Q460VS-3



VS

- 11 12 13 14
- 15 21 22 23
- 24 31 32 51
- 52 61 62 63
- 64 71 72 73
- 74 81 82 83
- 91 92 94



Q360VS-3 LH    Q460VS-3 LH    Q360VS-3    Q460VS-3



NEW



NEW



NEW



NEW



<2.5 x D



<2.5 x D



<2.5 x D



<2.5 x D



2.5 x P



2.5 x P



2.5 x P



2.5 x P



ISO 2 6H



ISO 2 6H



ISO 3 6G

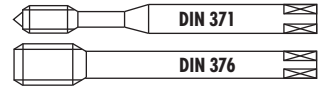


ISO 3 6G

| $\emptyset d_1$<br>M | P<br>mm | $l_1$<br>mm | $l_2$<br>mm | $l_3$<br>mm | $d_2$<br>mm | a<br>mm |   | $\phi$ 6H | ID       | ID       | ID       | 6H<br>+ mm | ID       | 6H<br>+ mm |
|----------------------|---------|-------------|-------------|-------------|-------------|---------|---|-----------|----------|----------|----------|------------|----------|------------|
| 2                    | 0.4     | 45          | 7           | 12          | 2.8         | 2.1     | 2 | 1.6       |          |          | ● 210306 | 0.019      |          |            |
| 2.5                  | 0.45    | 50          | 9           | 14.5        | 2.8         | 2.1     | 2 | 2.05      |          |          | ● 210307 | 0.020      |          |            |
| 3                    | 0.5     | 56          | 5.5         | 18          | 3.5         | 2.7     | 3 | 2.5       |          |          | ● 210308 | 0.020      |          |            |
| 4                    | 0.7     | 63          | 7.5         | 21          | 4.5         | 3.4     | 3 | 3.3       | ● 210285 |          | ● 210309 | 0.022      |          |            |
| 5                    | 0.8     | 70          | 9           | 25          | 6           | 4.9     | 3 | 4.2       | ● 210286 |          | ● 210310 | 0.024      |          |            |
| 6                    | 1       | 80          | 11          | 30          | 6           | 4.9     | 3 | 5         | ● 210287 |          | ● 210311 | 0.026      |          |            |
| 8                    | 1.25    | 90          | 12.5        | 35          | 8           | 6.2     | 3 | 6.8       | ● 210288 |          | ● 210312 | 0.028      |          |            |
| 10                   | 1.5     | 100         | 14          | 39          | 10          | 8       | 3 | 8.5       | ● 210289 |          | ● 210313 | 0.032      |          |            |
| 12                   | 1.75    | 110         | 14          |             | 9           | 7       | 3 | 10.2      |          | ● 210290 |          |            | ● 210314 | 0.034      |
| 16                   | 2       | 110         | 18          |             | 12          | 9       | 3 | 14        |          | ● 210291 |          |            |          |            |



PM



# QTAP

Q360VS-3



VS

Q460VS-3



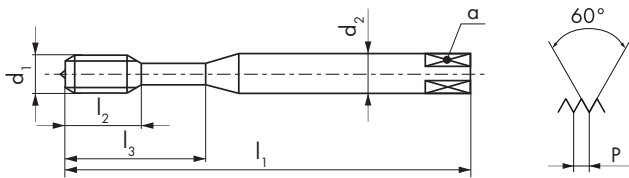
VS

Q360VS-3



VS

- 11 12 13 14
- 15 21 22 23
- 24 31 32 51
- 52 61 62 63
- 64 71 72 73
- 74 81 82 83
- 91 92 94



Q360VS-3

Q460VS-3

Q360VS-3



NEW



NEW



NEW



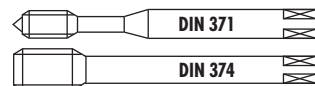
7G

7G

6H  
+0.1 mm

| $\emptyset d_1$<br>M | P<br>mm | $l_1$<br>mm | $l_2$<br>mm | $l_3$<br>mm | $d_2$<br>mm | a<br>mm |   |      | 6H |
|----------------------|---------|-------------|-------------|-------------|-------------|---------|---|------|----|
| 3                    | 0.5     | 56          | 5.5         | 18          | 3.5         | 2.7     | 3 | 2.5  |    |
| 4                    | 0.7     | 63          | 7.5         | 21          | 4.5         | 3.4     | 3 | 3.3  |    |
| 5                    | 0.8     | 70          | 9           | 25          | 6           | 4.9     | 3 | 4.2  |    |
| 6                    | 1       | 80          | 11          | 30          | 6           | 4.9     | 3 | 5    |    |
| 8                    | 1.25    | 90          | 12.5        | 35          | 8           | 6.2     | 3 | 6.8  |    |
| 10                   | 1.5     | 100         | 14          | 39          | 10          | 8       | 3 | 8.5  |    |
| 12                   | 1.75    | 110         | 14          |             | 9           | 7       | 3 | 10.2 |    |

| ID       | 6H<br>+ mm | ID       | 6H<br>+ mm | ID       |
|----------|------------|----------|------------|----------|
| ● 210315 | 0.036      |          |            | ● 210328 |
| ● 210316 | 0.041      |          |            | ● 210329 |
| ● 210317 | 0.044      |          |            | ● 210330 |
| ● 210318 | 0.050      |          |            | ● 210331 |
| ● 210319 | 0.052      |          |            | ● 210332 |
| ● 210320 | 0.060      |          |            | ● 210333 |
|          |            | ● 210321 | 0.066      |          |



## QTAP

**Q320VS-4**



VS

**Q420VS-4**



VS

**Q323VS-4**



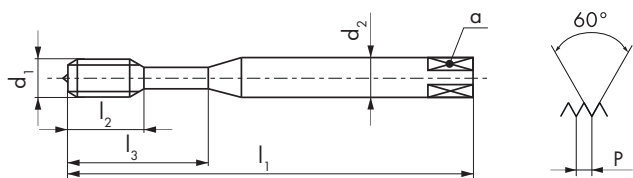
VS

**Q423VS-4**



VS

- 11 12 13 14
- 15 21 22 23
- 24 31 32 51
- 52 61 62 63
- 64 71 72 73
- 74 81 82 83
- 91 92 94



**Q320VS-4**

**Q420VS-4**

**Q323VS-4**

**Q423VS-4**

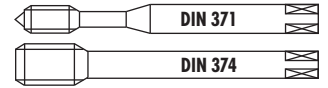


| $\emptyset d_1$<br>MF | P<br>mm | $l_1$<br>mm | $l_2$<br>mm | $l_3$<br>mm | $d_2$<br>mm | a<br>mm |   |  | ID       | ID       | ID       | ID       |
|-----------------------|---------|-------------|-------------|-------------|-------------|---------|---|--|----------|----------|----------|----------|
| 6                     | 0.75    | 80          | 17          | 30          | 6           | 4.9     | 3 |  | ● 197661 |          | ● 197684 |          |
| 8                     | 1       | 90          | 20          | 35          | 8           | 6.2     | 3 |  | ● 197662 |          | ● 197685 |          |
| 10                    | 1       | 100         | 22          | 39          | 10          | 8       | 3 |  | ● 197663 |          | ● 197686 |          |
| 12                    | 1       | 100         | 24          |             | 9           | 7       | 3 |  |          | ● 197664 |          | ● 197687 |
| 12                    | 1.5     | 100         | 24          |             | 9           | 7       | 3 |  |          | ● 197665 |          | ● 197688 |
| 14                    | 1.5     | 100         | 24          |             | 11          | 9       | 3 |  |          | ● 197666 |          | ● 197689 |
| 16                    | 1.5     | 100         | 26          |             | 12          | 9       | 3 |  |          | ● 197667 |          | ● 197690 |
| 18                    | 1.5     | 110         | 26          |             | 14          | 11      | 4 |  |          | ● 197668 |          | ● 197691 |
| 20                    | 1.5     | 125         | 28          |             | 16          | 12      | 4 |  |          | ● 197669 |          | ● 197692 |



≤ Ø 16 > Ø 16

PM HSSE



## QTAP

Q360VS-3



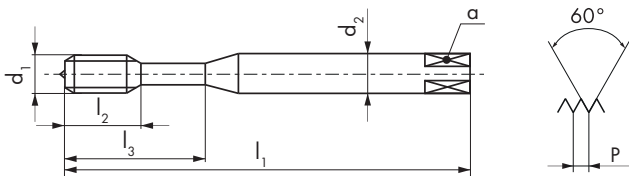
Q460VS-3



Q363VS-3



Q463VS-3





Q360VS-3

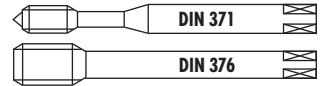
Q460VS-3

Q363VS-3

Q463VS-3



| Ø d <sub>1</sub><br>MF | P<br>mm | l <sub>1</sub><br>mm | l <sub>2</sub><br>mm | l <sub>3</sub><br>mm | d <sub>2</sub><br>mm | a<br>mm |  |  | ID       | ID       | ID       | ID       |
|------------------------|---------|----------------------|----------------------|----------------------|----------------------|---------|---|---|----------|----------|----------|----------|
| 4                      | 0.5     | 63                   | 7.5                  | 21                   | 4.5                  | 3.4     | 3   | 3.5   | ● 197670 |          | ● 197693 |          |
| 5                      | 0.5     | 70                   | 9                    | 25                   | 6                    | 4.9     | 3   | 4.5   | ● 197671 |          | ● 197694 |          |
| 6                      | 0.75    | 80                   | 11                   | 30                   | 6                    | 4.9     | 3   | 5.25  | ● 197672 |          | ● 197695 |          |
| 8                      | 1       | 90                   | 12.5                 | 35                   | 8                    | 6.2     | 3   | 7   | ● 197673 |          | ● 197696 |          |
| 10                     | 1       | 100                  | 14                   | 39                   | 10                   | 8       | 3   | 9   | ● 197674 |          | ● 197697 |          |
| 12                     | 1       | 100                  | 14                   |                      | 9                    | 7       | 3   | 11  |          | ● 197675 |          | ● 197698 |
| 12                     | 1.5     | 100                  | 14                   |                      | 9                    | 7       | 3   | 10.5  |          | ● 197676 |          | ● 197699 |
| 14                     | 1.5     | 100                  | 14                   |                      | 11                   | 9       | 3   | 12.5  |          | ● 197677 |          | ● 197700 |
| 16                     | 1.5     | 100                  | 14                   |                      | 12                   | 9       | 4   | 14.5  |          | ● 197678 |          | ● 197701 |
| 18                     | 1.5     | 110                  | 18                   |                      | 14                   | 11      | 4   | 16.5  |          | ● 197679 |          | ● 197702 |
| 20                     | 1.5     | 125                  | 20                   |                      | 16                   | 12      | 4   | 18.5  |          | ● 197680 |          | ● 197703 |
| 22                     | 1.5     | 125                  | 20                   |                      | 18                   | 14.5    | 4   | 20.5  |          | ● 197681 |          | ● 197704 |
| 24                     | 1.5     | 140                  | 22                   |                      | 18                   | 14.5    | 4   | 22.5  |          | ● 197682 |          | ● 197705 |
| 24                     | 2       | 140                  | 22                   |                      | 18                   | 14.5    | 4   | 22  |          | ● 197683 |          | ● 197706 |



## QTAP

Q320VS-4



Q420VS-4



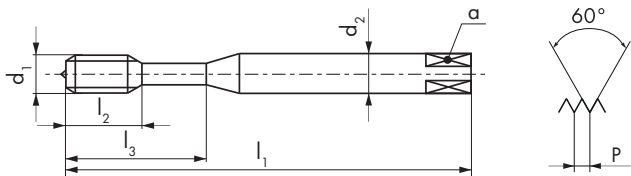
Q323VS-4



Q423VS-4



- 11 12 13 14
- 15 21 22 23
- 24 31 32 51
- 52 61 62 63
- 64 71 72 73
- 74 81 82 83
- 91 92 94



Q320VS-4

Q420VS-4

Q323VS-4

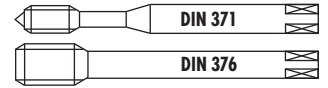
Q423VS-4



| $\emptyset'' d_1$<br>UNC | P<br>TPI | $d_1$<br>mm | $l_1$<br>mm | $l_2$<br>mm | $l_3$<br>mm | $d_2$<br>mm | $a$<br>mm |   |      | ID       | ID       | ID       | ID       |
|--------------------------|----------|-------------|-------------|-------------|-------------|-------------|-----------|---|------|----------|----------|----------|----------|
| 6                        | 32       | 3.5         | 56          | 13          | 20          | 4           | 3         | 3 | 2.75 | ● 196275 |          | ● 196320 |          |
| 8                        | 32       | 4.16        | 63          | 14          | 21          | 4.5         | 3.4       | 3 | 3.4  | ● 196276 |          | ● 196321 |          |
| 10                       | 24       | 4.82        | 70          | 15          | 25          | 6           | 4.9       | 3 | 3.8  | ● 196277 |          | ● 196322 |          |
| 1/4                      | 20       | 6.35        | 80          | 17          | 30          | 7           | 5.5       | 3 | 5.1  | ● 196278 |          | ● 196323 |          |
| 5/16                     | 18       | 7.93        | 90          | 20          | 35          | 8           | 6.2       | 3 | 6.5  | ● 196279 |          | ● 196324 |          |
| 3/8                      | 16       | 9.52        | 100         | 22          | 39          | 10          | 8         | 3 | 8    | ● 196280 |          | ● 196325 |          |
| 1/2                      | 13       | 12.7        | 110         | 24          |             | 9           | 7         | 3 | 10.8 |          | ● 196281 |          | ● 196326 |
| 5/8                      | 11       | 15.87       | 110         | 30          |             | 12          | 9         | 3 | 13.6 |          | ● 196282 |          | ● 196327 |
| 3/4                      | 10       | 19.05       | 125         | 33          |             | 14          | 11        | 4 | 16.6 |          | ● 196283 |          | ● 196328 |
| 7/8                      | 9        | 22.22       | 140         | 36          |             | 18          | 14.5      | 4 | 19.5 |          | ● 196284 |          | ● 196329 |
| 1                        | 8        | 25.4        | 160         | 39          |             | 18          | 14.5      | 4 | 22.3 |          | ● 196285 |          | ● 196330 |



≤ Ø 16 > Ø 16



## QTAP

**Q360VS-3**



**Q460VS-3**



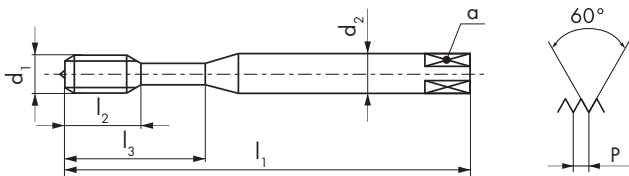
**Q363VS-3**



**Q463VS-3**



- 11 12 13 14
- 15 21 22 23
- 24 31 32 51
- 52 61 62 63
- 64 71 72 73
- 74 81 82 83
- 91 92 94



**Q360VS-3**

**Q460VS-3**

**Q363VS-3**

**Q463VS-3**



**2B**

**2B**

**2B**

**2B**

| Ø" d <sub>1</sub><br>UNC | P<br>TPI | d <sub>1</sub><br>mm | l <sub>1</sub><br>mm | l <sub>2</sub><br>mm | l <sub>3</sub><br>mm | d <sub>2</sub><br>mm | a<br>mm |   |      |
|--------------------------|----------|----------------------|----------------------|----------------------|----------------------|----------------------|---------|---|------|
| 6                        | 32       | 3.5                  | 56                   | 6.5                  | 20                   | 4                    | 3       | 3 | 2.75 |
| 8                        | 32       | 4.16                 | 63                   | 7.5                  | 21                   | 4.5                  | 3.4     | 3 | 3.4  |
| 10                       | 24       | 4.82                 | 70                   | 9                    | 25                   | 6                    | 4.9     | 3 | 3.8  |
| 1/4                      | 20       | 6.35                 | 80                   | 11                   | 30                   | 7                    | 5.5     | 3 | 5.1  |
| 5/16                     | 18       | 7.93                 | 90                   | 12.5                 | 35                   | 8                    | 6.2     | 3 | 6.5  |
| 3/8                      | 16       | 9.52                 | 100                  | 14                   | 39                   | 10                   | 8       | 3 | 8    |
| 7/16                     | 14       | 11.11                | 100                  | 14                   |                      | 8                    | 6.2     | 3 | 9.3  |
| 1/2                      | 13       | 12.7                 | 110                  | 14                   |                      | 9                    | 7       | 3 | 10.8 |
| 5/8                      | 11       | 15.87                | 110                  | 18                   |                      | 12                   | 9       | 3 | 13.6 |
| 3/4                      | 10       | 19.05                | 125                  | 21                   |                      | 14                   | 11      | 3 | 16.6 |
| 7/8                      | 9        | 22.22                | 140                  | 24                   |                      | 18                   | 14.5    | 3 | 19.5 |
| 1                        | 8        | 25.4                 | 160                  | 27                   |                      | 18                   | 14.5    | 4 | 22.3 |

**ID**

**ID**

**ID**

**ID**

● 196286

● 196331

● 196287

● 196332

● 196288

● 196333

● 196289

● 197622

● 196290

● 197623

● 196291

● 197624

● 196292 ● 197625

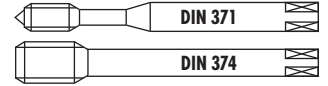
● 196293 ● 197626

● 196294 ● 197627

● 196295 ● 197628

● 196296 ● 197629

● 196297 ● 197630



# QTAP

**Q320VS-4**



VS

**Q420VS-4**



VS

**Q323VS-4**



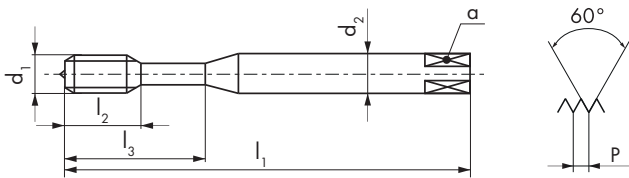
VS

**Q423VS-4**



VS

- 11 12 13 14
- 15 21 22 23
- 24 31 32 51
- 52 61 62 63
- 64 71 72 73
- 74 81 82 83
- 91 92 94



**Q320VS-4**

**Q420VS-4**

**Q323VS-4**

**Q423VS-4**



**2B**

**2B**

**2B**

**2B**

| Ø" d <sub>1</sub><br>UNF | P<br>TPI | d <sub>1</sub><br>mm | l <sub>1</sub><br>mm | l <sub>2</sub><br>mm | l <sub>3</sub><br>mm | d <sub>2</sub><br>mm | a<br>mm |   |      |
|--------------------------|----------|----------------------|----------------------|----------------------|----------------------|----------------------|---------|---|------|
| 10                       | 32       | 4.82                 | 70                   | 15                   | 25                   | 6                    | 4.9     | 3 | 4.05 |
| 1/4                      | 28       | 6.35                 | 80                   | 17                   | 30                   | 7                    | 5.5     | 3 | 5.5  |
| 5/16                     | 24       | 7.93                 | 90                   | 20                   | 35                   | 8                    | 6.2     | 3 | 6.9  |
| 3/8                      | 24       | 9.52                 | 100                  | 22                   | 39                   | 10                   | 8       | 3 | 8.5  |
| 7/16                     | 20       | 11.11                | 100                  | 19                   |                      | 8                    | 6.2     | 3 | 9.8  |
| 1/2                      | 20       | 12.7                 | 100                  | 24                   |                      | 9                    | 7       | 3 | 11.4 |

**ID**

**ID**

**ID**

**ID**

● 196298

● 197631

● 196299

● 197632

● 196300

● 197633

● 196301

● 197634

● 196302

● 197635

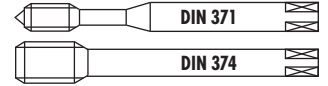
● 196303

● 197636



≤ Ø 16 > Ø 16

PM HSSE



# QTAP

**Q360VS-3**



**Q460VS-3**



**Q363VS-3**



**Q463VS-3**



- 11 12 13 14
- 15 21 22 23
- 24 31 32 51
- 52 61 62 63
- 64 71 72 73
- 74 81 82 83
- 91 92 94

**Q360VS-3**

**Q460VS-3**

**Q363VS-3**

**Q463VS-3**

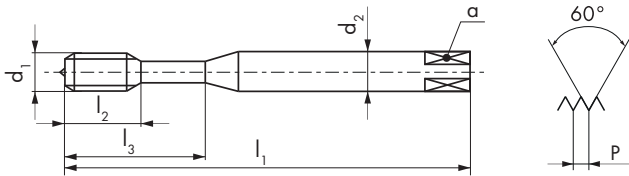


**2B**

**2B**

**2B**

**2B**



| Ø" d <sub>1</sub><br>UNF | P<br>TPI | d <sub>1</sub><br>mm | l <sub>1</sub><br>mm | l <sub>2</sub><br>mm | l <sub>3</sub><br>mm | d <sub>2</sub><br>mm | a<br>mm |   |      |
|--------------------------|----------|----------------------|----------------------|----------------------|----------------------|----------------------|---------|---|------|
| 10                       | 32       | 4.82                 | 70                   | 9                    | 25                   | 6                    | 4.9     | 3 | 4.05 |
| 1/4                      | 28       | 6.35                 | 80                   | 11                   | 30                   | 7                    | 5.5     | 3 | 5.5  |
| 5/16                     | 24       | 7.93                 | 90                   | 12.5                 | 35                   | 8                    | 6.2     | 3 | 6.9  |
| 3/8                      | 24       | 9.52                 | 100                  | 14                   | 39                   | 10                   | 8       | 3 | 8.5  |
| 7/16                     | 20       | 11.11                | 100                  | 14                   |                      | 8                    | 6.2     | 3 | 9.8  |
| 1/2                      | 20       | 12.7                 | 100                  | 14                   |                      | 9                    | 7       | 3 | 11.4 |
| 5/8                      | 18       | 15.87                | 100                  | 14                   |                      | 12                   | 9       | 3 | 14.5 |
| 3/4                      | 16       | 19.05                | 125                  | 18                   |                      | 14                   | 11      | 4 | 17.5 |

**ID**

**ID**

**ID**

**ID**

● 196304

● 197637

● 196305

● 197638

● 196306

● 197639

● 196307

● 197640

● 196308

● 197641

● 196309

● 197642

● 196310

● 197643

● 196311

● 197644



# QTAP

Q420VS-4



VS

11 12 13 14

15 21 22 23

24 31 32 51

52 61 62 63

Q423VS-4



VS

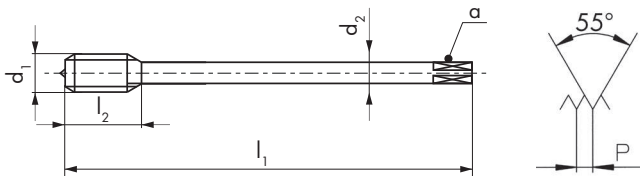
64 71 72 73

74 81 82 83

91 92 94

Q420VS-4

Q423VS-4



| $\frac{\text{Ø}''}{G}$ | $d_1$ | P     | $d_1$ | $l_1$ | $l_2$ | $d_2$ | a  |      |   | ID     | ID |        |
|------------------------|-------|-------|-------|-------|-------|-------|----|------|---|--------|----|--------|
|                        |       | TPI   | mm    | mm    | mm    | mm    | mm |      |   |        |    |        |
| 1/8                    | 28    | 9.72  | 90    | 22    | 7     | 5.5   | 3  | 8.75 | ● | 196312 | ●  | 197645 |
| 1/4                    | 19    | 13.15 | 100   | 20    | 11    | 9     | 3  | 11.6 | ● | 196313 | ●  | 197646 |
| 3/8                    | 19    | 16.66 | 100   | 20    | 12    | 9     | 3  | 15.2 | ● | 196314 | ●  | 197647 |
| 1/2                    | 14    | 20.95 | 125   | 22    | 16    | 12    | 4  | 18.9 | ● | 196315 | ●  | 197648 |

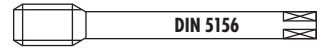
# G

## DIN EN ISO 228 (BSP)



≤ Ø 16 > Ø 16

PM HSSE



# QTAP

Q460VS-3



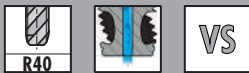
11 12 13 14

15 21 22 23

24 31 32 51

52 61 62 63

Q463VS-3



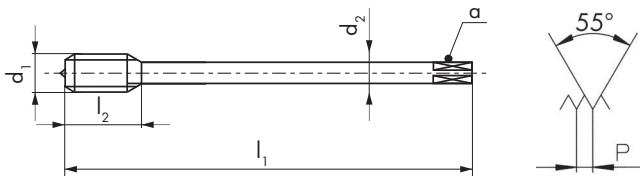
64 71 72 73

74 81 82 83

91 92 94

Q460VS-3

Q463VS-3

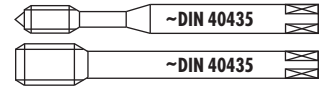


| Ø" d <sub>1</sub><br>G | P<br>TPI | d <sub>1</sub><br>mm | l <sub>1</sub><br>mm | l <sub>2</sub><br>mm | d <sub>2</sub><br>mm | a<br>mm |   |      |
|------------------------|----------|----------------------|----------------------|----------------------|----------------------|---------|---|------|
| 1/8                    | 28       | 9.72                 | 90                   | 14                   | 7                    | 5.5     | 3 | 8.75 |
| 1/4                    | 19       | 13.15                | 100                  | 14                   | 11                   | 9       | 3 | 11.6 |
| 3/8                    | 19       | 16.66                | 100                  | 14                   | 12                   | 9       | 4 | 15.2 |
| 1/2                    | 14       | 20.95                | 125                  | 20                   | 16                   | 12      | 4 | 18.9 |

ID

ID

- |          |          |
|----------|----------|
| ● 196316 | ● 197649 |
| ● 196317 | ● 197650 |
| ● 196318 | ● 197651 |
| ● 196319 | ● 197652 |



## QTAP

Q320VS-4



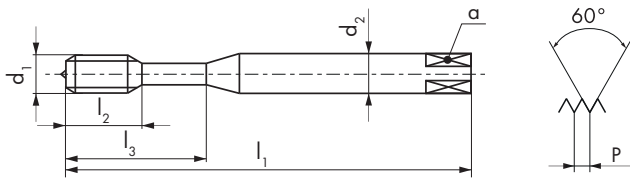
VS

Q420VS-4



VS

- 11 12 13 14
- 15 21 22 23
- 24 31 32 51
- 52 61 62 63
- 64 71 72 73
- 74 81 82 83
- 91 92 94



Q320VS-4

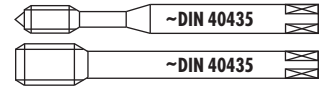
Q420VS-4



| Ø d <sub>1</sub><br>EG M | P<br>mm | d <sub>1</sub><br>mm | l <sub>1</sub><br>mm | l <sub>2</sub><br>mm | l <sub>3</sub><br>mm | d <sub>2</sub><br>mm | α<br>mm |   |      | ID       | ID       |
|--------------------------|---------|----------------------|----------------------|----------------------|----------------------|----------------------|---------|---|------|----------|----------|
| 2                        | 0.4     | 2.52                 | 50                   | 10                   |                      | 2.8                  | 2.1     | 3 | 2.1  | ● 204622 |          |
| 2.5                      | 0.45    | 3.08                 | 56                   | 12                   | 18                   | 3.5                  | 2.7     | 3 | 2.65 | ● 204623 |          |
| 3                        | 0.5     | 3.65                 | 56                   | 13                   | 20                   | 4                    | 3       | 3 | 3.15 | ● 204624 |          |
| 4                        | 0.7     | 4.91                 | 70                   | 15                   | 25                   | 6                    | 4.9     | 3 | 4.2  | ● 204625 |          |
| 5                        | 0.8     | 6.04                 | 80                   | 17                   | 30                   | 6                    | 4.9     | 3 | 5.25 | ● 204626 |          |
| 6                        | 1       | 7.3                  | 80                   | 17                   | 30                   | 7                    | 5.5     | 3 | 6.3  | ● 204627 |          |
| 8                        | 1.25    | 9.62                 | 100                  | 22                   | 39                   | 10                   | 8       | 3 | 8.4  | ● 204628 |          |
| 10                       | 1.5     | 11.94                | 100                  | 24                   |                      | 9                    | 7       | 3 | 10.4 |          | ● 204629 |
| 12                       | 1.75    | 14.27                | 110                  | 28                   |                      | 11                   | 9       | 3 | 12.5 |          | ● 204630 |
| 16                       | 2       | 18.59                | 125                  | 33                   |                      | 14                   | 11      | 4 | 16.6 |          | ● 204631 |



≤ Ø 16 > Ø 16



## QTAP

Q360VS-3



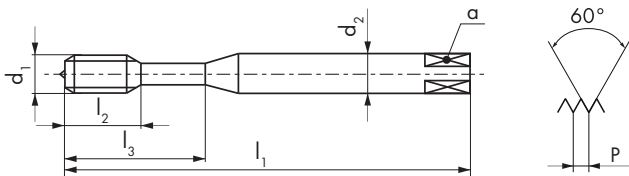
- 11 12 13 14
- 15 21 22 23
- 24 31 32 51
- 52 61 62 63
- 64 71 72 73
- 74 81 82 83
- 91 92 94

Q460VS-3



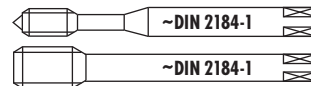
Q360VS-3

Q460VS-3



| Ø d <sub>1</sub><br>EG M | P<br>mm | d <sub>1</sub><br>mm | l <sub>1</sub><br>mm | l <sub>2</sub><br>mm | l <sub>3</sub><br>mm | d <sub>2</sub><br>mm | α<br>mm |   |      | ID       | ID       |
|--------------------------|---------|----------------------|----------------------|----------------------|----------------------|----------------------|---------|---|------|----------|----------|
| 2                        | 0.4     | 2.52                 | 50                   | 9                    |                      | 2.8                  | 2.1     | 2 | 2.1  | ● 204632 |          |
| 2.5                      | 0.45    | 3.08                 | 56                   | 5.5                  | 18                   | 3.5                  | 2.7     | 3 | 2.65 | ● 204633 |          |
| 3                        | 0.5     | 3.65                 | 56                   | 6.5                  | 20                   | 4                    | 3       | 3 | 3.15 | ● 204634 |          |
| 4                        | 0.7     | 4.91                 | 70                   | 9                    | 25                   | 6                    | 4.9     | 3 | 4.2  | ● 204635 |          |
| 5                        | 0.8     | 6.04                 | 80                   | 11                   | 30                   | 6                    | 4.9     | 3 | 5.25 | ● 204636 |          |
| 6                        | 1       | 7.3                  | 80                   | 11                   | 30                   | 7                    | 5.5     | 3 | 6.3  | ● 204637 |          |
| 8                        | 1.25    | 9.62                 | 100                  | 14                   | 39                   | 10                   | 8       | 3 | 8.4  | ● 204638 |          |
| 10                       | 1.5     | 11.94                | 100                  | 14                   |                      | 9                    | 7       | 3 | 10.4 |          | ● 204639 |
| 12                       | 1.75    | 14.27                | 110                  | 14                   |                      | 11                   | 9       | 3 | 12.5 |          | ● 204640 |
| 14                       | 2       | 16.59                | 110                  | 18                   |                      | 12                   | 9       | 3 | 14.6 |          | ● 204641 |
| 16                       | 2       | 18.59                | 125                  | 21                   |                      | 14                   | 11      | 3 | 16.6 |          | ● 204642 |

# EG UNC ASME B18.29.1



## QTAP

Q320VS-4



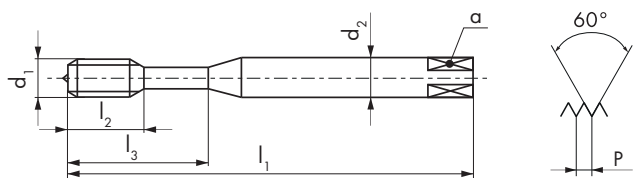
VS

Q420VS-4



VS

- 11 12 13 14
- 15 21 22 23
- 24 31 32 51
- 52 61 62 63
- 64 71 72 73
- 74 81 82 83
- 91 92 94



Q320VS-4

Q420VS-4



| Ø" d <sub>1</sub><br>EG UNC | P<br>TPI | d <sub>1</sub><br>mm | l <sub>1</sub><br>mm | l <sub>2</sub><br>mm | l <sub>3</sub><br>mm | d <sub>2</sub><br>mm | a<br>mm |   |      |
|-----------------------------|----------|----------------------|----------------------|----------------------|----------------------|----------------------|---------|---|------|
| 4                           | 40       | 3.67                 | 56                   | 13                   | 20                   | 4                    | 3       | 3 | 3.05 |
| 6                           | 32       | 4.53                 | 70                   | 15                   | 25                   | 6                    | 4.9     | 3 | 3.75 |
| 8                           | 32       | 5.19                 | 70                   | 15                   | 25                   | 6                    | 4.9     | 3 | 4.45 |
| 1/4                         | 20       | 8                    | 90                   | 20                   | 35                   | 8                    | 6.2     | 3 | 6.7  |
| 5/16                        | 18       | 9.77                 | 100                  | 22                   | 39                   | 10                   | 8       | 3 | 8.4  |
| 3/8                         | 16       | 11.58                | 110                  | 24                   |                      | 9                    | 7       | 3 | 10   |
| 1/2                         | 13       | 15.23                | 110                  | 30                   |                      | 12                   | 9       | 3 | 13.3 |

ID

ID

● 204643

● 204644

● 204645

● 204646

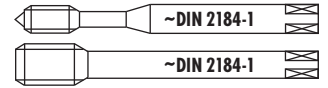
● 204647

● 204648

● 204649

# EG UNC

ASME B18.29.1



## QTAP

Q360VS-3



VS

Q460VS-3



VS

- 11 12 13 14
- 15 21 22 23
- 24 31 32 51
- 52 61 62 63
- 64 71 72 73
- 74 81 82 83
- 91 92 94

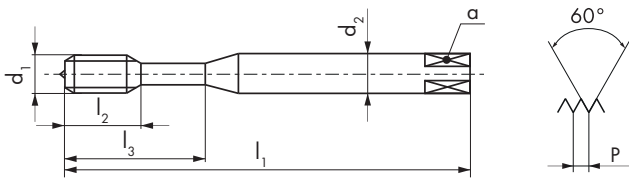
Q360VS-3

Q460VS-3



3B

3B



| $\emptyset'' d_1$<br>EG UNC | P<br>TPI | $d_1$<br>mm | $l_1$<br>mm | $l_2$<br>mm | $l_3$<br>mm | $d_2$<br>mm | $\alpha$<br>mm |   |      |
|-----------------------------|----------|-------------|-------------|-------------|-------------|-------------|----------------|---|------|
| 4                           | 40       | 3.67        | 56          | 6.5         | 20          | 4           | 3              | 3 | 3.05 |
| 6                           | 32       | 4.53        | 70          | 9           | 25          | 6           | 4.9            | 3 | 3.75 |
| 8                           | 32       | 5.19        | 70          | 9           | 25          | 6           | 4.9            | 3 | 4.45 |
| 10                          | 24       | 6.2         | 80          | 11          | 30          | 7           | 5.5            | 3 | 5.1  |
| 1/4                         | 20       | 8           | 90          | 12.5        | 35          | 8           | 6.2            | 3 | 6.7  |
| 5/16                        | 18       | 9.77        | 100         | 14          | 39          | 10          | 8              | 3 | 8.4  |
| 3/8                         | 16       | 11.58       | 110         | 14          |             | 9           | 7              | 3 | 10   |
| 1/2                         | 13       | 15.23       | 110         | 18          |             | 12          | 9              | 3 | 13.3 |

ID

ID

● 204650

● 204651

● 204652

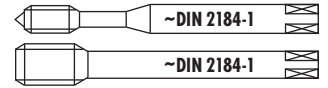
● 204653

● 204654

● 204655

● 204656

● 204657



## QTAP

Q320VS-4



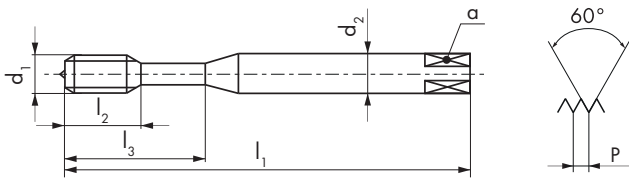
VS

Q420VS-4



VS

- 11 12 13 14
- 15 21 22 23
- 24 31 32 51
- 52 61 62 63
- 64 71 72 73
- 74 81 82 83
- 91 92 94



Q320VS-4

Q420VS-4



3B

3B

| Ø" d <sub>1</sub><br>EG UNF | P<br>TPI | d <sub>1</sub><br>mm | l <sub>1</sub><br>mm | l <sub>2</sub><br>mm | l <sub>3</sub><br>mm | d <sub>2</sub><br>mm | a<br>mm |   |      |
|-----------------------------|----------|----------------------|----------------------|----------------------|----------------------|----------------------|---------|---|------|
| 6                           | 40       | 4.33                 | 63                   | 14                   | 21                   | 4.5                  | 3.4     | 3 | 3.7  |
| 8                           | 36       | 5.08                 | 70                   | 15                   | 25                   | 6                    | 4.9     | 3 | 4.4  |
| 10                          | 32       | 5.85                 | 80                   | 17                   | 30                   | 6                    | 4.9     | 3 | 5.1  |
| 1/4                         | 28       | 7.52                 | 90                   | 20                   | 35                   | 8                    | 6.2     | 3 | 6.65 |
| 5/16                        | 24       | 9.31                 | 90                   | 20                   | 35                   | 9                    | 7       | 3 | 8.2  |
| 3/8                         | 24       | 10.89                | 100                  | 19                   |                      | 8                    | 6.2     | 3 | 9.8  |
| 1/2                         | 20       | 14.35                | 100                  | 24                   |                      | 11                   | 9       | 3 | 13.1 |

ID

ID

● 204658

● 204659

● 204660

● 204661

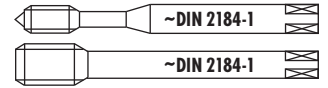
● 204662

● 204663

● 204664

# EG UNF

ASME B18.29.1



## QTAP

Q360VS-3



Q460VS-3



- 11 12 13 14
- 15 21 22 23
- 24 31 32 51
- 52 61 62 63
- 64 71 72 73
- 74 81 82 83
- 91 92 94

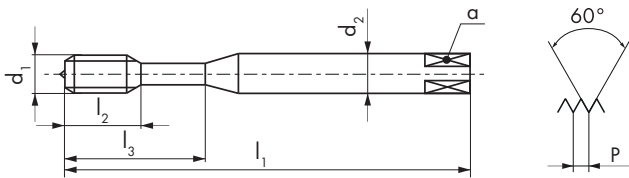
Q360VS-3

Q460VS-3



3B

3B



| Ø" d <sub>1</sub><br>EG UNF | P<br>TPI | d <sub>1</sub><br>mm | l <sub>1</sub><br>mm | l <sub>2</sub><br>mm | l <sub>3</sub><br>mm | d <sub>2</sub><br>mm | a<br>mm |   |      |
|-----------------------------|----------|----------------------|----------------------|----------------------|----------------------|----------------------|---------|---|------|
| 6                           | 40       | 4.33                 | 63                   | 7.5                  | 21                   | 4.5                  | 3.4     | 3 | 3.7  |
| 8                           | 36       | 5.08                 | 70                   | 9                    | 25                   | 6                    | 4.9     | 3 | 4.4  |
| 10                          | 32       | 5.85                 | 80                   | 11                   | 30                   | 6                    | 4.9     | 3 | 5.1  |
| 1/4                         | 28       | 7.52                 | 90                   | 12.5                 | 35                   | 8                    | 6.2     | 3 | 6.65 |
| 5/16                        | 24       | 9.31                 | 90                   | 12.5                 | 35                   | 9                    | 7       | 3 | 8.2  |
| 3/8                         | 24       | 10.89                | 100                  | 19                   |                      | 8                    | 6.2     | 3 | 9.8  |
| 1/2                         | 20       | 14.35                | 100                  | 14                   |                      | 11                   | 9       | 3 | 13.1 |

ID

ID

● 204665

● 204666

● 204667

● 204668

● 204669

● 204670

● 204671

## SYNCHRON-GEWINDESCHNEIDFUTTER — SYNCHRO TAPPING CHUCKS

**Der QTAP funktioniert mit einem Längenausgleichsfutter genauso gut wie mit unserem Synchron-Gewindeschneidfutter mit Axial-Stossdämpfer.**

DC SWISS SA offeriert eine spezifische Gesamtlösung, den aktuellen Bearbeitungsmethoden angepasst: ein Gewindeschneidfutter Typ SRT, Soft-Rigid-Tapping mit "Axial-Stossdämpfer", geeignet für Schnellwechselsysteme, welches praktisch den gesamten Druck, der beim Umschalten der Spindel auf die Schneidkanten des Gewindebohrers ausgeübt wird, ausgleicht. Dadurch wird eine erhebliche Standzeiterhöhung erzielt!



**The QTAP works just as well with a linear compensating spindle as with our Synchro tapping chuck with axial shock absorber.**

DC SWISS SA offers a specific global solution adapted to this modern machining method; a tapping chuck with axial shock absorber, type SRT, Soft Rigid Tapping. This tapping chuck, suitable for quick change systems, is able to absorb the axial pressure applied to the cutting edges while the spindle reverses, and therefore increases the tap life.

# SRT Synchron-Gewindeschneidfutter mit Axial-Stossdämpfer

## Tapping chucks with axial shock absorber



Uniquement pour taraudage synchrone  
Nur für Synchronbearbeitung  
Only for rigid tapping  
Solo per maschiatura sincrona  
Solo para roscado sincronizado

| DIN 1835 B   | SRT054-D12                 | ER8                        |                            |
|--|----------------------------|----------------------------|----------------------------|
| <h1>SRT nano</h1>  |                            |                            |                            |
| <p><b>SRT054</b></p>   |                            | <p><b>D9865-</b></p>       |                            |
|  | <b>D</b><br>mm             | <b>D<sub>1</sub></b><br>mm | <b>D<sub>2</sub></b><br>mm |
| <b>M0.5 - M4</b>   | 12                         | 20                         | 12                         |
|  | <b>L</b><br>mm             | <b>L<sub>1</sub></b><br>mm | <b>L<sub>2</sub></b><br>mm |
|  | 33                         | 59                         | 75                         |
|  | <b>ID</b>                  |                            |                            |
|  | ● 127413                   |                            |                            |
| <b>No</b>  | <b>D<sub>2</sub></b><br>mm | <b>L<sub>3</sub></b><br>mm | <b>d<sub>2</sub></b><br>mm |
| <b>ER8-0300</b>  | 8.5                        | 13.5                       | 3                          |
| <b>ER8-0350</b>  | 8.5                        | 13.5                       | 3.5                        |
| <b>ER8-0400</b>  | 8.5                        | 13.5                       | 4                          |
| <b>ER8-0450</b>  | 8.5                        | 13.5                       | 4.5                        |
|  | <b>ID</b>                  |                            |                            |
|  | ● 118897                   |                            |                            |
|  | ● 118898                   |                            |                            |
|  | ● 118899                   |                            |                            |
|  | ● 118900                   |                            |                            |
| DIN 1835 B   | SRT312-D20                 | SRT312-D25                 | SRT520-D25                 |
| <h1>SRT short</h1>   |                            |                            |                            |
|  |                            |                            |                            |
|  | <b>D<sub>1</sub></b><br>mm | <b>D<sub>2</sub></b><br>mm | <b>L</b><br>mm             |
| <b>M3 - M12</b>  | 39                         | 20                         | 47                         |
| <b>M3 - M12</b>  | 39                         | 25                         | 53                         |
| <b>M5 - M20</b>  | 56                         | 25                         | 53                         |
|  | <b>L<sub>1</sub></b><br>mm |                            |                            |
|  | 86                         | S1                         |                            |
|  | 90                         | S1                         |                            |
|  | 110                        | S2                         |                            |
|  | <b>ID</b>                  |                            |                            |
|  | ● 162832                   |                            |                            |
|  | ● 162831                   |                            |                            |
|  | ● 162833                   |                            |                            |
| <p><i>Weitere Typen und Ausführungen auf Anfrage.</i><br/>Further types and executions on request.</p> |                            |                            |                            |



THREADING SOLUTIONS



**QTAP | ACTING  
THREADING**



**FORDERN SIE  
IHREN GEDRUCKTEN  
KATALOG TC & TM AN!  
CLAIM YOUR PRINTED  
CATALOGUE TC & TM!**



Angebotsanfrage

Versuchsergebnis

Beanstandung

**Vertretung:** \_\_\_\_\_  
**Kunde:** \_\_\_\_\_  
**Tel.- /Fax-Nr.:** \_\_\_\_\_

**Kontaktperson:** \_\_\_\_\_  
**E-Mail:** \_\_\_\_\_  
**Datum:** \_\_\_\_\_

**1. Werkzeug-Typ:** \_\_\_\_\_  
**Besonderheit:** \_\_\_\_\_

**Abmessung:** \_\_\_\_\_  
**Toleranzklasse:** \_\_\_\_\_

**2. Werkstoffgruppe:** \_\_\_\_\_  
**Werkstoff-Nr.:** \_\_\_\_\_  
**Norm:** \_\_\_\_\_

**Härte:** \_\_\_\_\_ N/mm<sup>2</sup> / HB / HRC  
**Bruchdehnung:** \_\_\_\_\_ %

**3. Gewinde:**  Sackloch  Durchgangsloch  
**Kernloch-Ø:** \_\_\_\_\_  
**Aufbohrungs-Ø:** \_\_\_\_\_

**Gewindelänge:** \_\_\_\_\_ mm  
**Tiefe:** \_\_\_\_\_ mm  
**Tiefe:** \_\_\_\_\_ mm

**4. Schnittgeschwindigkeit (V<sub>c</sub>):** \_\_\_\_\_ m/min \_\_\_\_\_ 1/min  
**Vorschub (f):** \_\_\_\_\_ %

**5. Maschine:** \_\_\_\_\_  
**Arbeitsrichtung:**  horizontal  vertikal  
**Synchro-Gewindeschneiden:**  Soft-Rigidfutter  Spannzanze  Weldon  Schrumpffutter

Innenkühlung  
 Längenausgleich  
 Ausklinkbar  
 Rutschkupplung  
 Automat. Umschaltung

**6. Schmierung:**  Emulsion  Schneidöl  Luft  MMS  
**Produkt:** \_\_\_\_\_

**7. Grund des Werkzeugwechsels:**  Werkzeugverschleiss  
 Gewinde nicht korrekt (kontrolliert mit Lehre)  
 Maschinenfehler

Werkzeugbruch  
 Zahnausbrüche im Anschnittbereich  
 Zahnausbrüche im Führungsgewinde

**8. Standzeitvergleich:**  
**Vergleichswerkzeug:** \_\_\_\_\_  
**Resultat und Befund:** \_\_\_\_\_

**Bemerkungen:** \_\_\_\_\_  
 \_\_\_\_\_

# TECHNICAL QUESTIONNAIRE

# Thread cutting and thread forming

Enquiry

Test result

Complaint

**Agency:** \_\_\_\_\_  
**Customer:** \_\_\_\_\_  
**Phone or fax:** \_\_\_\_\_

**Contact:** \_\_\_\_\_  
**E-mail:** \_\_\_\_\_  
**Date:** \_\_\_\_\_

**1. Tool type:** \_\_\_\_\_ **Thread size:** \_\_\_\_\_  
**Particularity:** \_\_\_\_\_ **Class of tolerance:** \_\_\_\_\_

**2. Material group:** \_\_\_\_\_  
**Material N°:** \_\_\_\_\_ **Hardness:** \_\_\_\_\_ N/mm<sup>2</sup> / HB / HRC  
**Norm:** \_\_\_\_\_ **Elongation:** \_\_\_\_\_ %

**3. Thread:**  blind hole  through hole **Threaded length:** \_\_\_\_\_ mm  
**Core hole Ø:** \_\_\_\_\_ **Depth:** \_\_\_\_\_ mm  
**Counter-bore Ø:** \_\_\_\_\_ **Depth:** \_\_\_\_\_ mm

**4. Cutting speed (V<sub>c</sub>):** \_\_\_\_\_ m/min \_\_\_\_\_ 1/min  
**Feed (f):** \_\_\_\_\_ %

**5. Machine:** \_\_\_\_\_  internal coolant  
**Working position:**  horizontal  vertical  
**Rigid Tapping:**  "Soft Rigid Tapping"  collet  Weldon  hot / cold shrunk  
**Tapping spindle:**  axial compensation  de-clutching  reversible  sliding clutch

**6. Lubricant:**  emulsion  cutting oil  air  mist  
**Product:** \_\_\_\_\_

**7. Tool change reason:**  tool wear  tool breakage  
 thread not correct (checked with thread plug gauge)  tooth breakage in the chamfer lead  
 machine error  tooth breakage in the guiding thread

**8. Efficiency comparison:**  
**Tool under test:** \_\_\_\_\_  
**Performance and observations:** \_\_\_\_\_

**Remarks:** \_\_\_\_\_  
\_\_\_\_\_

# LIEFER- UND ZAHLUNGSBEDINGUNGEN

## **Bestellungen**

Bestellungen, die nicht ab Lager ausgeliefert werden können, sind von uns zu bestätigen.

Artikel, die nicht mehr standardmässig hergestellt werden, obwohl sie im Katalog aufgeführt sind, müssen als Spezialanfertigung angeboten und berechnet werden.

Aufträge können nur nach gegenseitiger schriftlicher Abmachung annulliert werden.

## **Angebote und Auftragsbestätigungen**

Die zu unseren Angeboten gehörenden Beschreibungen und Unterlagen, wie Gewichts- und Massangaben, Abbildungen und Zeichnungen, sind durch die ständige Weiterentwicklung nur annähernd massgebend, sofern sie nicht als verbindlich bezeichnet sind.

## **Preise**

Unsere Preise verstehen sich exklusive MWSt, für Lieferung ab Werk, ausschliesslich Verpackung, Versandkosten und Versicherung.

Im Falle einer Preiserhöhung behalten wir uns das Recht vor, bereits bestätigte Werkzeuge zu den neuen Preisen zu verrechnen.

## **Zahlungen**

Unsere Rechnungen sind innert 30 Tagen netto zahlbar. Bei Zielüberschreitungen werden Verzugszinsen nach dem jeweils gültigen Diskontsatz verrechnet. Die Kosten für Lieferungen per Nachnahme, Wechselspesen, usw. gehen zu Lasten des Käufers.

## **Eigentumsvorbehalt**

Wir behalten uns das Eigentum an der jeweils gelieferten Ware bis zur vollständigen Bezahlung des Kaufpreises, einschliesslich aller Nebenkosten, vor.

## **Versand**

Erfolgt auf Rechnung und Gefahr des Bestellers.

## **Lieferfristen**

Die Lieferfristen werden jeweils sorgfältig ermittelt, sind jedoch stets ohne Gewähr. Bei Überschreitung der bestätigten Lieferfrist lehnen wir Verzugsstrafen oder sonstige Schadenersatzforderungen, sowie Rücktritt von Bestellungen, grundsätzlich ab.

## **Spezialanfertigungen**

Bei allen Lieferungen von Spezialwerkzeugen behalten wir uns das Recht einer Über- oder Unterschreitung der Bestellmenge um bis zu 15 %, bei kleinen Mengen um 1 bis 2 Stück, vor.

## **Garantie**

Werkzeuge, die wir als fehlerhaft anerkennen, werden gratis ersetzt. Dies jedoch ohne jegliche weitere Entschädigung.

## **Beanstandungen**

Beanstandungen müssen spätestens innert 14 Tagen nach Erhalt der Ware schriftlich angebracht werden.

## **Zeichnungen und Abbildungen**

Es ist untersagt, Zeichnungen und Abbildungen zu kopieren oder Dritten zugänglich zu machen.

Angaben in unserem Katalog, auf Zeichnungen und in anderen Dokumenten können sich infolge technischer Weiterentwicklung und eventueller neuer Normen ändern. Sie sind deshalb nicht verbindlich.

## **Notstandsbedingungen**

In Fällen von höherer Gewalt, teilweisem oder totalem Unterbruch unserer Fabrikation, behalten wir uns das Recht vor, von eingegangenen Lieferverpflichtungen ganz oder teilweise zurückzutreten.

## **Erfüllungsort und Gerichtsstand**

Für alle sich aus dem Vertragsverhältnis ergebenden Streitigkeiten ist das Amtsgericht Moutier (Schweiz) zuständig.

Streitigkeiten unterstehen ausschliesslich dem Schweizerischen Obligationenrecht.

## DELIVERY AND PAYMENT CONDITIONS

|  |  |
|--|--|
| <b>Orders</b>                          | Orders, which cannot be delivered from stock, will be acknowledged. Items, which do not belong any more to our standard programme, although still featured in the catalogue, will be invoiced as «specials». Orders may only be cancelled by mutual written agreement.                       |
| <b>Quotations and acknowledgements</b> | For reasons of constant development in this field, all descriptions mentioned in our quotations, annexed documents, weight indications, measurements as well as illustrations and drawings are approximate indications. These technical data have binding value only if expressly specified. |
| <b>Prices</b>                          | Our prices are quoted for deliveries ex works Malleray, excluding VAT, packing, insurance, freight, customs' and legalisation duties. Should prices increase, we reserve the right to invoice tools already acknowledged at the new prices.  |
| <b>Payment</b>                         | Payments must be made in advance or against irrevocable and confirmed documentary credit to be opened in our favour with a Swiss bank. All banking commissions and charges have to be borne by the buyer.  |
| <b>Right of ownership</b>              | We reserve the right of ownership of all goods supplied until the sales price, plus all incidental charges, have fully been paid.  |
| <b>Despatch</b>                        | Deliveries take place at the purchaser's risk.   |
| <b>Delivery</b>                        | Confirmed delivery dates are non-binding. We will do our utmost to maintain them. However, we cannot accept responsibility of direct or consequential losses due to delayed deliveries.  |
| <b>Special orders</b>                  | For all special tools we reserve the right to over or under supply the ordered quantity by up to 15 %, or on small quantities by 1 or 2 pieces.  |
| <b>Guarantee</b>                       | Tools recognised to be defective by DC will be replaced free of charge, but without prejudice.   |
| <b>Complaints</b>                      | Complaints will be considered only within 15 days after receipt of the goods.  |
| <b>Drawings and sketches</b>           | The reproduction or transmission of drawings and other documents to a third party are prohibited.<br>The information (drawings and prints) in our catalogue is for guidance only and is not binding.   |
| <b>Special conditions</b>              | In the case of partial or total disruption of our production; we reserve the right to partially or totally cancel our delivery commitments.  |
| <b>Tribunal</b>                        | All disputes are subject to Swiss Law. The seat of court of law will be Moutier (Switzerland).   |



dcswiss.com



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*Gewindewerkzeuge können durch technisches Versagen oder durch Fahrlässigkeit brechen oder zersplittern und die Gesundheit des Mitarbeitenden gefährden. Befolgen Sie daher die gesetzlichen Sicherheits- und Gesundheitsvorschriften. Zudem ist das Tragen der Schutzbrille unerlässlich.*

*Das Schleifen von Gewindewerkzeugen verursacht gefährlichen Staub und darf nur unter gewissenhaftesten Sicherheitsrichtlinien verrichtet werden.*

### **WARNING**

Thread tools can break or shatter either through technical failure or negligence, and can endanger the health of the operator. Always obey the safety and health regulations, also the wearing of safety glasses is compulsory.

The grinding of threading tools causes hazardous particles, and must be performed only under most rigorous safety standards.

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