

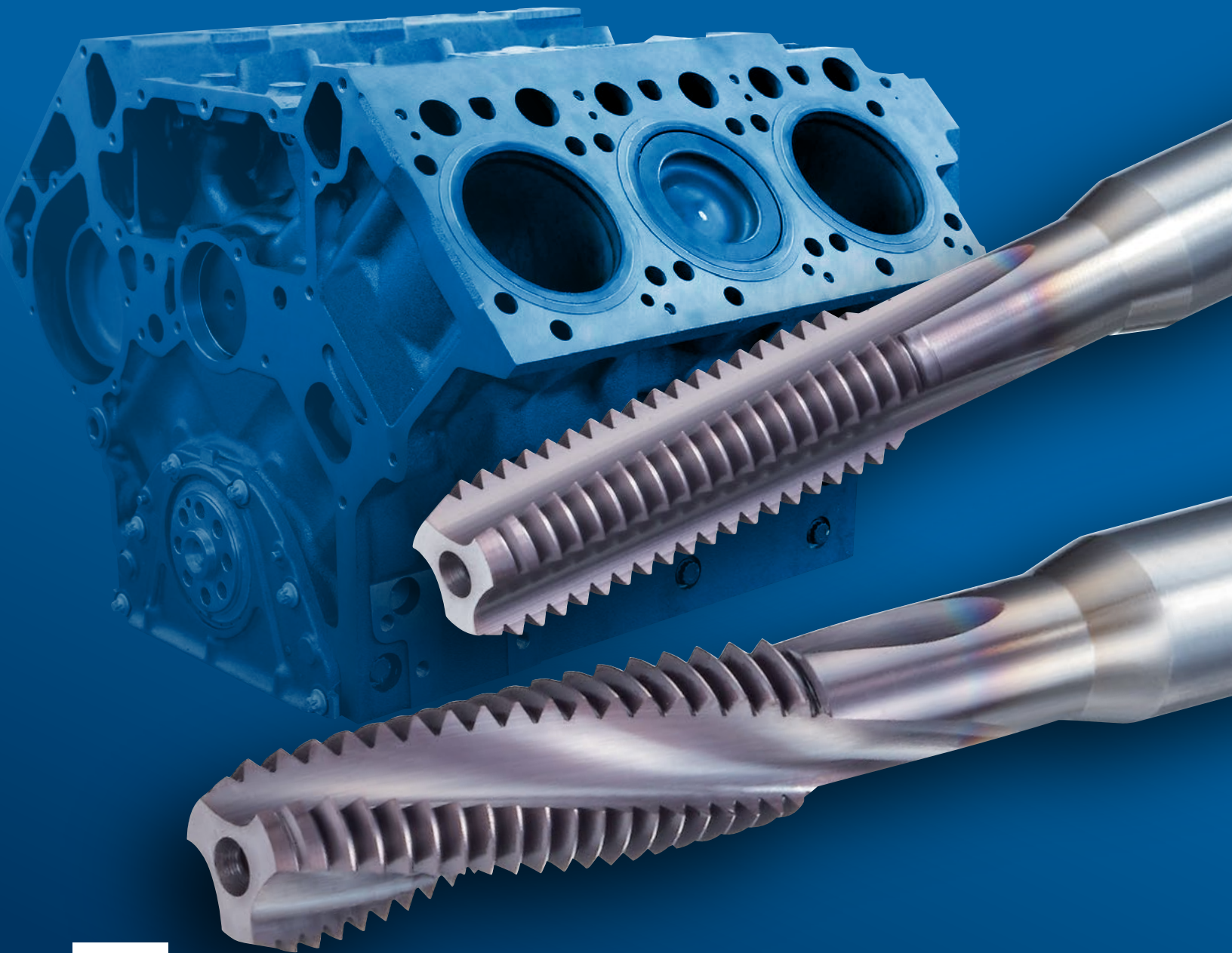


OSG's A Brand

Vol 1

A-Carbide Taps

A-CSF • A-CHT



For more information
scan the QR code to visit:
osgtool.com/a-csf

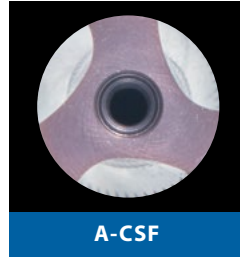


A Brand A-CSF & A-CHT

Features & Benefits

Larger Coolant Hole

1.3 Times More Coolant Flow



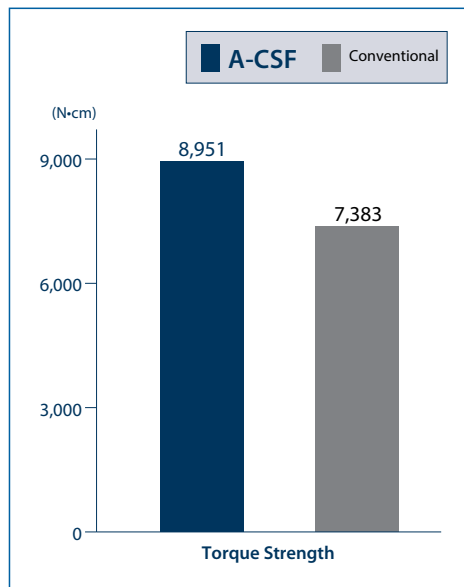
Larger Oil Hole Design

for excellent coolant flow

Ideal for Cast Iron

Rigid Design Prevents Tool Breakage

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



*Cutting Torque 650N-cm

Bright

for greater performance in non-ferrous materials.

Ultra-Fine Grain Carbide

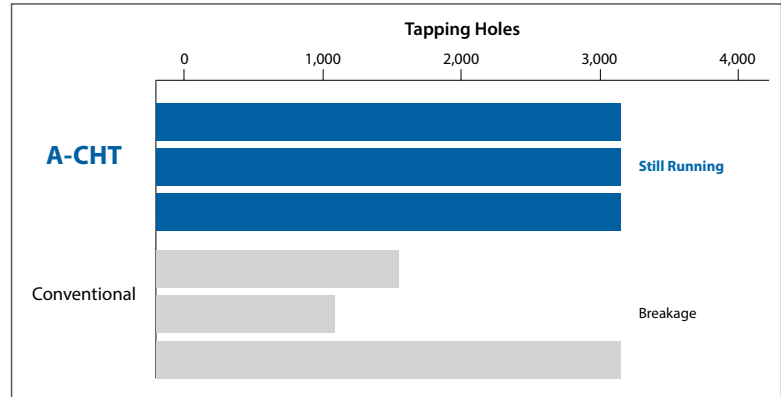
for high wear resistance and toughness



Stable and Consistent Performance

Stable Machining in Ductile Cast Iron

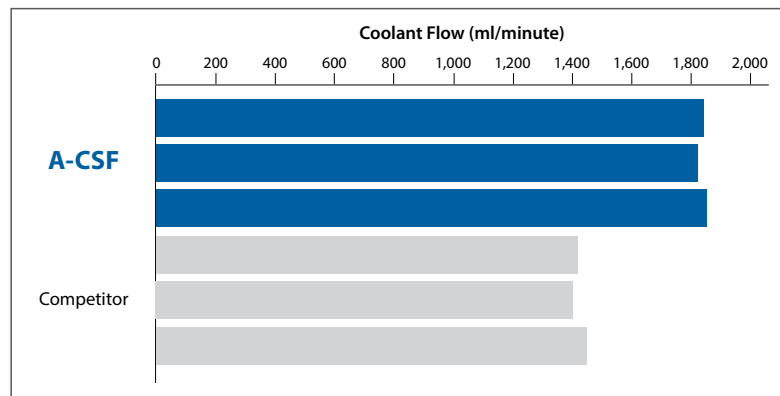
Tool	A-CHT	Conventional
Size	ØM6 x 1	
Drill Hole Size	Ø5mm x 15mm (Blind)	
Work Material	Ductile Cast Iron	
Tapping Depth	12mm (2xD)	
Cutting Speed	100 SFM (1,600 RPM)	
Coolant	Water Soluble Chlorine-Free (10%) (Internal)	
Machine	Horizontal Machining Center (Synchronized)	



Exceptional Coolant Flow

Coolant Flow Amount by Time

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



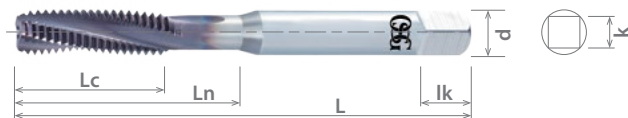
A Brand A-CSF

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



List 16605

A-CSF, Coolant - Through, DIN Overall Length, Modified Bottom (2.5P), Bottom (1.5P)



Units: Inch

Tap Size	Thread Limit	No. of Flutes	EDP Number		DIN Overall Length	Thread Length	Neck Length	Shank Dia.	Square Width	Square Length
			Bottom (1.5P)	Mod Bottom (2.5P)						
			Bright	Bright						
1/4 - 20 UNC	H5	3	1660500100	1660500000	3.140	0.598	1.181	0.255	0.191	0.313
1/4 - 28 UNF	H4		1660500300	1660500200						
5/16 - 18 UNC	H5		1660500500	1660500400	3.540	0.665	1.377	0.318	0.238	0.375
3/8 - 16 UNC			1660500700	1660500600	3.930	0.751		0.381	0.286	0.438
7/16 - 14 UNC			1660500900	1660500800		0.858	-	0.322	0.242	0.406
1/2 - 13 UNC			1660501100	1660501000	4.330	0.921	-	0.367	0.275	0.438

Packed: 1 pc.

EDP's listed above are stocked standard, other coatings available upon request.

Specify treatment at time of order.

Note: Reduce SFM 50% - 75% while using external coolant.



Work Material																			
List No.	P					M			K	N		S		H					
	Carbon Steels			Alloy Steels	Die Steels	Stainless Steels			Cast Iron	Aluminum		Nickel Alloy	Titanium	Hardened Steels					
	Low	Med.	High			300	400	17-4 PH		6061	Casting			Inconel	6Al4V (30 HRC)	~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC
16605	1010	1035	1065	4140															
SFM	1018	1045		4340					15-50	30-330	30-330								

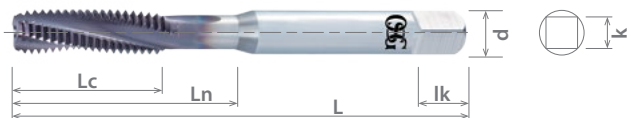
○ good ⊗ best



List 16600



A-CSF, Coolant - Through, DIN Overall Length, Modified Bottom (2.5P), Bottom (1.5P)



Units: mm

Tap Size	Thread Limit	No. of Flutes	EDP Number		DIN Overall Length	Thread Length	Neck Length	Shank Dia.	Square Width	Square Length
			Bottom (1.5P)	Mod Bottom (2.5P)						
			Bright	Bright						
M5 x 0.8	D4	3	1660000000	1660000100	70.00	10.00	25.00	4.928	3.86	6.4
M6 x 1.0	D5		1660000200	1660000300	80.00	12.00	31.00	6.477	4.85	7.9
M8 x 1.25			1660000400	1660000500	90.00	15.00	35.00	8.077	6.05	9.5
M10 x 1.5	D6		1660000600	1660000700	100.00	18.00	39.00	9.677	7.26	11.1
M10 x 1.25	D5		1660000800	1660000900						
M12 x 1.75	D6		1660001000	1660001100	110.00	21.00	-	9.322	6.98	

Packed: 1 pc.

EDP's listed above are stocked standard, other coatings available upon request.

Specify treatment at time of order.

Note: Reduce SFM 50% - 75% while using external coolant.



Work Material																		
List No.	P					M			K	N		S		H				
	Carbon Steels			Alloy Steels	Die Steels	Stainless Steels			Cast Iron	Aluminum		Nickel Alloy	Titanium	Hardened Steels				
	Low	Med.	High			300	400	17-4 PH		6061	7075			Casting	Inconel	6Al4V (30 HRC)	~35 HRC	35-45 HRC
16600									⊙	⊙	⊙							
SFM									15-50	30-330	30-330							

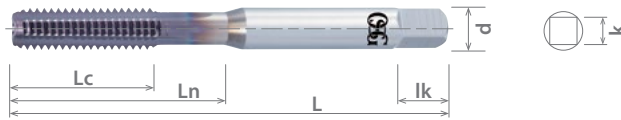
⊙ good ⊗ best





List 16615

A-CHT, Coolant-Through, DIN Overall Length, Bottom (1.5P)



Units: Inch

Tap Size	Thread Limit	No. of Flutes	EDP Number		DIN Overall Length	Thread Length	Neck Length	Shank Dia.	Square Width	Square Length
			Bottom (1.5P)	Bright						
			L	Lc	Ln	d	k	Ik		
12 - 24 UNC	H3	3	1661500200	3.150	0.500	0.945	0.220	0.165	0.281	
12 - 28 UNF			1661500300							
1/4 - 20 UNC			1661500400							
1/4 - 28 UNF	H5		1661500500		0.598	1.181	0.255	0.191	0.313	
5/16 - 18 UNC	H5	4	1661500600	3.543	0.665	1.378	0.318	0.238	0.375	
5/16 - 24 UNF	H4		1661500700							
3/8 - 16 UNC	H5		1661500800							
3/8 - 24 UNF	H4		1661500900		0.752		0.381	0.286	0.438	
7/16 - 14 UNC	H5	4	1661501000	3.937	0.858	-	0.323	0.242	0.406	
7/16 - 20 UNF			1661501100							
1/2 - 13 UNC			1661501200							
1/2 - 20 UNF			1661501300		0.921		0.367	0.275	0.438	
5/8 - 11 UNC			1661501400		1.091		0.480	0.563	0.360	
5/8 - 18 UNF			1661501500		3.937					

Packed: 1 pc.

EDP's listed above are stocked standard, other coatings available upon request.

Specify treatment at time of order.

Note: Reduce SFM 50% - 75% while using external coolant.



Work Material																			
List No.	P					M			K	N		S		H					
	Carbon Steels			Alloy Steels	Die Steels	Stainless Steels			Cast Iron	Aluminum		Nickel Alloy	Titanium	Hardened Steels					
	Low	Med.	High			300	400	17-4 PH		6061	Casting			Inconel	6Al4V (30 HRC)	~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC
16615	1010	1035	1065	4140															
SFM	1018	1045		4340				15-50	30-330	30-330									

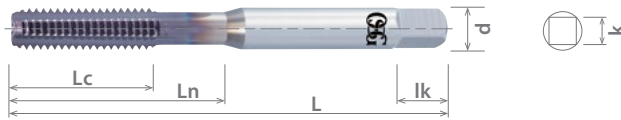
○ good ⊗ best



List 16610



A-CHT, Coolant-Through, DIN Overall Length, Bottom (1.5P)



Units: mm

Tap Size	Thread Limit	No. of Flutes	EDP Number	DIN Overall Length	Thread Length	Neck Length	Shank Dia.	Square Width	Square Length
			Bottom (1.5P)						
			Bright	L	Lc	Ln	d	k	lk
M5 x 0.8	D4	3	1661000000	70.00	10.00	25.00	4.93	3.86	6.35
M6 x 1.0			1661000100	80.00	12.00	31.00	6.48	4.85	7.92
M8 x 1.25	D5	3	1661000200	90.00	15.00	35.00	8.08	6.05	9.52
M10 x 1.5			1661000300	100.00	18.00	39.00	9.68	7.26	11.11
M10 x 1.25	1661000400								
M12 x 1.75	D6	4	1661000500	110.00	21.00	-	9.32	6.98	8.2
M12 x 1.5			1661000600	100.00					
M12 x 1.25	D7	4	1661000700	100.00	24.00	-	10.897	12.70	9.1
M14 x 2.0			1661000800	110.00					
M14 x 1.5	D7	4	1661000900	100.00	24.00	-	10.897	12.70	9.1
M16 x 2.0			1661001000	110.00					
M16 x 1.5			1661001100	100.00			12.192	14.29	9.1

Packed: 1 pc.
 EDP's listed above are stocked standard, other coatings available upon request.
 Specify treatment at time of order.
 Note: Reduce SFM 50% - 75% while using external coolant.



Work Material																			
List No.	P					M			K	N		S		H					
	Carbon Steels			Alloy Steels	Die Steels	Stainless Steels			Cast Iron	Aluminum		Nickel Alloy	Titanium	Hardened Steels					
	Low	Med.	High			300	400	17-4 PH		6061	Casting			Inconel	6Al4V (30 HRC)	~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC
1010	1035	1065	4140																
1018	1045		4340																
16610								☉	☉	☉									
SFM								15-50	30-330	30-330									

○ good ☉ best





shaping your dreams

 **Safe use of cutting tools**

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

FOR MORE INFORMATION CONTACT US

800-837-2223 • osgtool.com

