

X PERFORMER FORMING (XPF) TAP SERIES

1 Low-torque spec with specially designed threading

2 V-Coating: extreme wear resistance

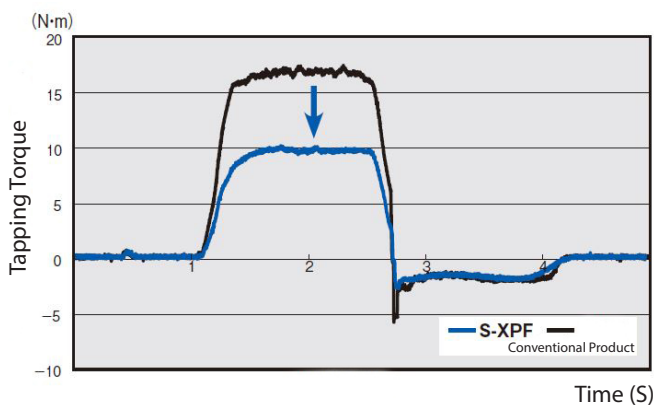
3 Size range from M1 to M45



XPF IS DIFFERENT FROM OTHERS!



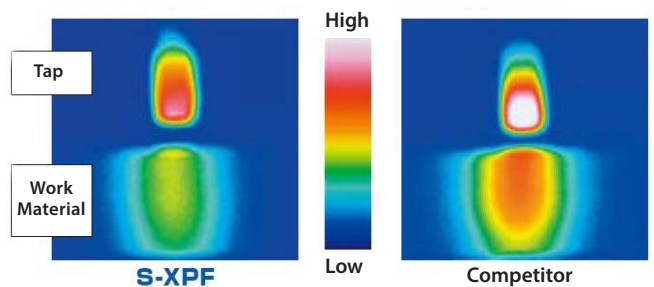
Reducing approx. **40%** of machining torque



**Restraining
Burrs**

Reducing approx. **20%** of heat generation

A thermograph image taken immediately after tapping



* To photograph the process, machining was carried out by applying paste instead of using coolant. However, during normal machining, coolant should be used.

**Resistance
improved**

Minimum Quantity Lubrication

XPF has a high durability even machining with chlorine-free coolant. S-OIL-XPF is also suitable for MQL machining operation.

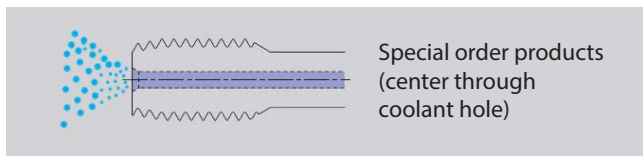


Deciding cutting speed

Does low cutting speed contribute to long tool life? It doesn't apply to XPF. Slow speed tapping, which generates less heat, causes bigger cutting resistance and tool wear. Cutting speed should be adjusted properly to find the most appropriate cutting speed for tool life.

Comparison of durability by the difference in cutting speed

Tool	S-OIL-XPF M8 x 1,25
Work Material	S50C
Hole Size	Ø 7,4 x 23 mm (Blind)
Tapping Length	18 mm (2,3D) (Blind)
Cutting Speed	10~40 m/min
Coolant	MQL 50cc/h (Internal)
Machine	Horizontal Machining Center



Cutting Speed	Tapping Holes				
	1.000	2.000	3.000	4.000	5.000
10m/min	2.500 (Holes)				Excessive Wear
	3.000 (Holes)				Excessive Wear
20m/min	4.500 (Holes)				Excessive Wear
	4.375 (Holes)				GP-OUT
30m/min	3.806 (Holes)				Excessive Rubbing Noise
	3.355 (Holes)				GP-OUT
40m/min	1.606 (Holes)				GP-OUT
	812 (Holes)				GP-OUT

Choosing the Appropriate Coolant

High lubricant water-soluble coolant is highly recommended as well as non-soluble coolant. Water-soluble coolant must be used for high speed cutting. Non-soluble coolant can be used is only 20m/min or below.

Machining Holder and Work Holding

Please select the appropriate equipment depending on the maximum torque, torque curve, and others of the machine. XPF generates lower torque, as compared with the conventional forming taps.

Calculation for torque

XPF achieves 30% reduction of torque, according to the calculation. The tapping data on page 3 shows 40% reduction of torque in synergy with appropriate cutting speed. Please refer to the following table for large diameter tapping and the formula for calculating torque.

Calculated machining torque of large diameter taps by work materials

Thread Size	Pitch Diameter	Coefficient of Work Material					
		2	4	8	11	12	14
		AC	ADC	Bs	SS400	S45C	SCM (~35HRC)
M18 X 2,5	16,376	14	28	56	77	84	98
M18 X 1,5	17,026	5	11	21	29	32	37
M20 X 2,5	18,376	16	32	63	87	95	110
M20 X 1,5	19,026	6	12	24	32	35	41
M22 X 2,5	20,376	17	35	70	96	105	122
M22 X 1,5	21,026	6	13	26	36	39	45
M24 X 3,0	22,051	27	54	109	150	163	191
M24 X 1,5	23,026	7	14	28	39	43	50
M27 X 3,0	25,051	31	62	124	170	186	217
M30 X 3,5	27,727	47	93	187	256	280	326
M33 X 3,5	30,727	52	103	207	284	310	362
M36 X 4,0	33,402	73	147	293	404	440	514
M42 X 4,5	39,077	109	217	435	597	652	760
M45 X 4,5	42,077	117	234	468	643	702	819

* Please note that this shows the theoretical values of machining torques in case of the external supply of water-soluble coolant
 * It does not guarantee the actual torque.

Following formulas are used for calculating torque

Torque calculation for forming Tap

Conventional forming taps

$$T = 0,09806 \times K \times E \times P^2$$

T : Torque

K : Coefficient of work material

E : Pitch diameter

P : Pitch

XPF series

$$T = 0,06864 \times K \times E \times P^2$$

In case of M30 X 3,5 working on SCM440

$$T = 0,06864 \times 14 \times 27,727 \times 3,5^2 = 326 \text{ N/m}$$

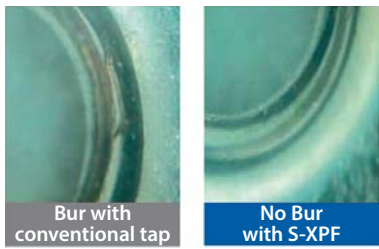
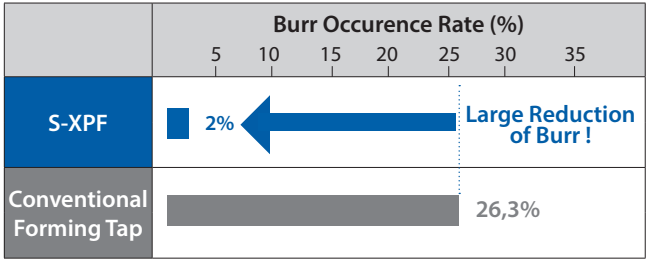
The above formulas are the guideline in case of the external supply of water-soluble coolant. Please note that the actual torque changes depending on the work environment.

Work Material	Coefficient
Aluminium Alloy	2
Aluminium Die Casting	3~4
Brass	6~8
Mild Steel	10~11
Carbon Steel	11~12
Alloy Steel (Hardened Steel)	13~14

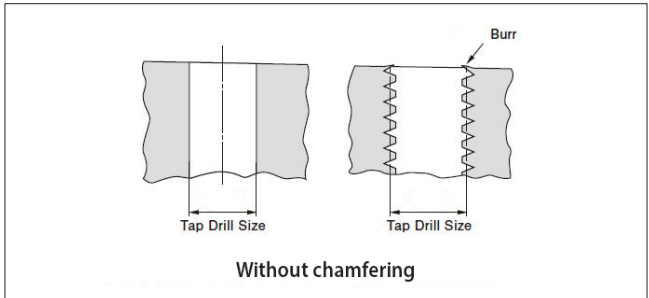
Countermeasure for burr

Comparing with the conventional forming taps, XPF reduces burr with low-torque spec.

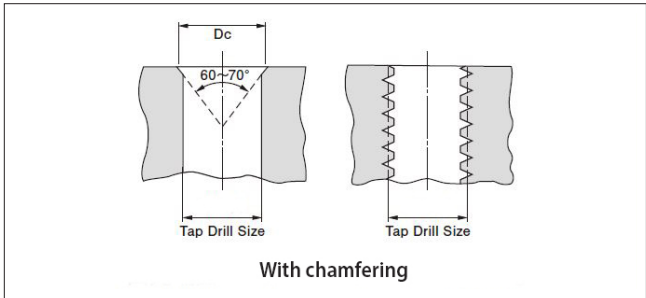
Tool	S-XPF M3x0,5 4P	Conv. Forming Tap
Work Material	Brass	
Hole Size	Ø 2,76 x 3mm (Through)	
Tapping Length	3mm (Through)	
Cutting Speed	(N/A)	
Coolant	Non-Water Soluble	
Machine	Specialized Machine	



Recommending 60° for the chamfer



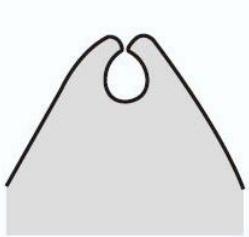
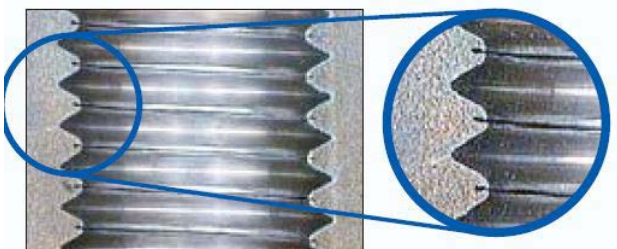
Forming tap forms the screw thread by plastic deformation. Therefore, without having chamfering, burr is made on the edge of the hole. To prevent burr, chamfering with 60° is highly recommended



If 118° of chamfering is required for drilling, burr is prevented by setting the diameter of chamfering to screw size + 2 pitches
(Example: M10x1,5 ⇒ 10mm (1,5x2)=13mm)

Shape of complete thread and it's difference

The formed thread has a small slit at the crest.



Forming taps are even 35HRC

Tool	S-XPf M6x1 4P
Work Material	SCM440 (35HRC)
Hole Size	Ø5,51~Ø5,52 x 16mm (Through)
Tapping Length	16mm (Through)
Cutting Speed	15m/min (796 min ⁻¹)
Coolant	Water Soluble Chlorine Free (External)
Machine	Horizontal Machine Center

	Tapping Holes			
	200	400	600	800
S-XPf	664 (Holes)			
	579 (Holes)			
Conventional Product	170 (Holes)			
	223 (Holes)			
Competitor Product	136 (Holes)			
	117 (Holes)			

Thread-rolling process of M45 is no longer a dream

Tool	S-XPf M45x4,5 2P
Work Material	SS400
Hole Size	Ø42,65~Ø42,68 x 45,5mm (Blind)
Tapping Length	36mm (0,8D) (Blind)
Cutting Speed	5m/min (133 min ⁻¹)
Coolant	Water Soluble Chlorine Free (External)
Machine	Horizontal Machine Center



Torque for above machining process is equivalent to 674N·M.
Water-soluble coolant and paste are also appropriate for this case.

Achieving high efficiency with MQL

Tool	S-OIL-XPf M12x1,75 2P	Conventional Forming Tap
Work Material	SCM420	
Hole Size	Ø11,1x45mm (Blind)	
Tapping Length	36mm (3D) (Blind)	
Cutting Speed	40m/min (1.062 min ⁻¹)	
Coolant	MQL (Internal)	Water Soluble Chlorine Free (External)
Machine	Horizontal Machine Center	

	Tapping Holes	
	5	10
S-OIL-XPf	8 (Holes) Still Running	
Conventional Forming Tap	0 (Hole)	

17 times the durability of cutting taps !

Tool	S-XPF M6x1 2P		Spiral fluted Tap M6x1
Work Material	S45C (90HRB)		
Hole Size	Ø5,55x25m- m(Through)	Ø5x15mm(Through)	
Tapping Length	18mm (3D) (Blind)	12mm (2D) (Blind)	
Cutting Speed	15m/min (796 min ⁻¹)	10m/min (530 min ⁻¹)	
Coolant	Water Soluble Chlorine Free (10%)		
Machine	Horizontal Machine Center		

	Tapping Length (m)						
	20	40	60	80	100	120	140
S-XPF	113m Excessive Wear						
	119,2m Excessive Wear						
Spiral Fluted Tap	7,2m GP-OUT						
	6,2m GP-OUT						

Ideal for work material especially for small diameter threads

Tool	S-XPF M1x0,25 2P			
Work Material	SCM440 Chrome Molyb- denum Alloy	SUS420 (30HRC) Stainless Steel	SPCC Cold Rolled Steel	C2801P Brass
Hole Size	Ø0,89 ~ 0,90 x 4mm (Through)			
Tapping Length	2mm (2D) (Blind)			
Cutting Speed	5m/min (1.590 min ⁻¹)		10m/min (3.180 min ⁻¹)	
Coolant	Water Soluble Chlorine Free (10%)			
Machine	Vertical Machine Center			

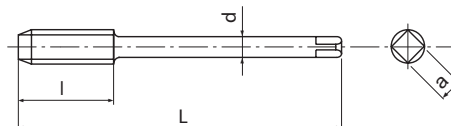
	Tapping Holes	
	5.000	10.000
SCM440	3.307 (Holes)	Breakage
SUS420	10.000 (Holes)	Still Running
SPCC	10.000 (Holes)	Still Running
C2801P	10.000 (Holes)	Still Running

Internally-fed coolant improve tool life

Tool	S-OIL-XPF M10x1,5 2P	
Work Material	SCM440 (35HRC)	
Hole Size	Ø9,3x24mm (Through)	
Tapping Length	20mm (2D) (Blind)	
Cutting Speed	20m/min	
Coolant	Water Soluble Chlorine Free (5%)	
Machine	Horizontal Machine Center	

	Tapping Holes		
	1.000	2.000	3.000
Internal S-OIL-XPF	2.704 (Holes) Ex. Rubbing Noise		
	2.950 (Holes) Ex.Wear		
Competitor	421 (Holes) Breakage		
	200 (Holes) Excessive Wear		
External Conventional Product	1 (Hole) Excessive Wear		
	1 (Hole) Excessive Wear		

Threading | Forming taps | Metric



- | | | | | | | | | |
|--|--|--|--|--|--|--|--|-------|
| P  | P  | P  | P  | M  | N  | N  | H  | |
| C < 0,2% | 0,25 < C < 0,4 | C > 0,45% | SCM | INOX | AI | AC,ADC | 25-35 HRC | |
| 15-40 | 15-40 | 15-30 | 15-30 | 8-20 | 20-50 | 20-40 | 5-20 | m/min |

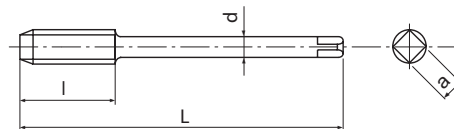
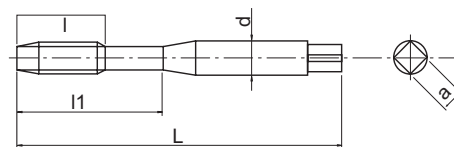


Threading | Forming taps



Metric

Threading | Forming taps | Metric



- ## Threading | Forming taps

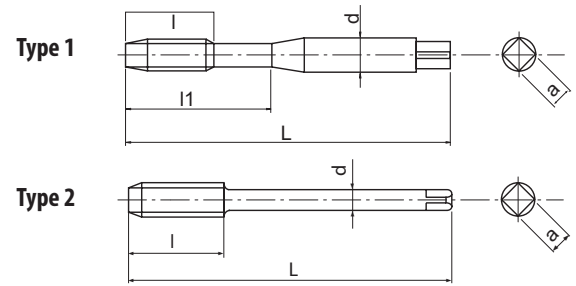
m/min



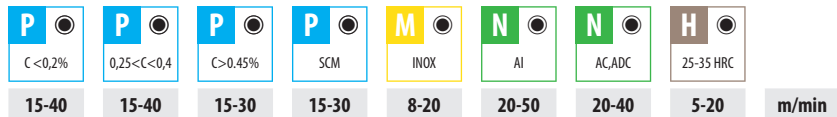
DIN 2174

Metric

Threading | Forming taps | Metric



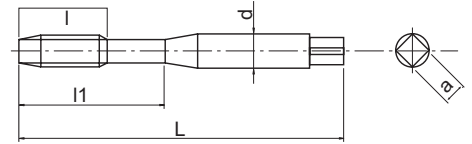
- First choice in quality and performance
- HSSE forming tap for through & blind holes
- Multilayer TiCN coating
- For general steels, stainless steels, aluminium
- For 6G internal thread tolerance, side through coolant

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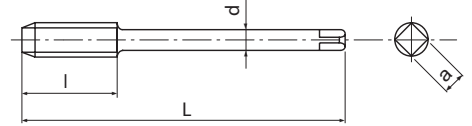
Threading | Forming taps | Metric



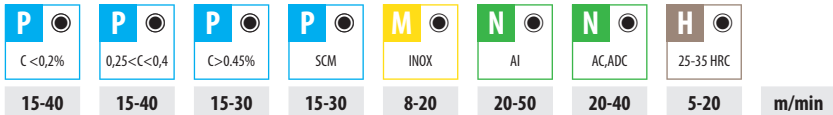
Type 1



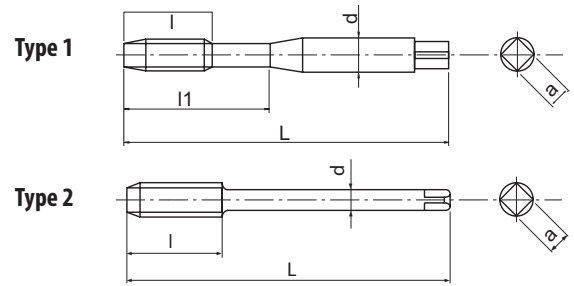
Type 2



- First choice in quality and performance
- HSSE forming tap for through & blind holes
- Multilayer TiCN coating
- For general steels, stainless steels, aluminium
- For 7G internal thread tolerance

[illegible]

Threading | Forming taps | Metric

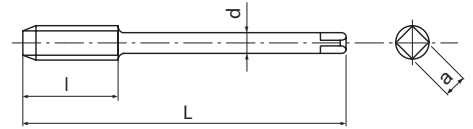
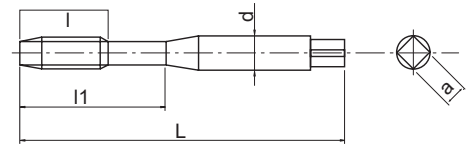


- First choice in quality and performance
- HSSE forming tap for through & blind holes
- Multilayer TiCN coating
- For general steels, stainless steels, aluminium
- Oversized tap for 6H +0,1mm thread tolerance

P 	P 	P 	P 	M 	N 	N 	H 	
C < 0,2%	0,25 < C < 0,4	C > 0,45%	SCM	INOX	AI	AC,ADC	25-35 HRC	
15-40	15-40	15-30	15-30	8-20	20-50	20-40	5-20	m/min

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Threading | Forming taps | Metric



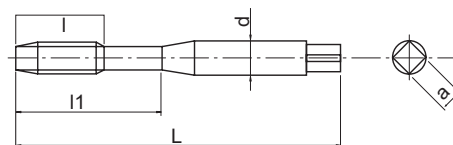
- ## Threading | Forming taps

Metric

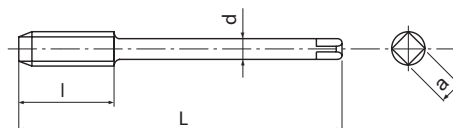
Threading | Forming taps | Metric



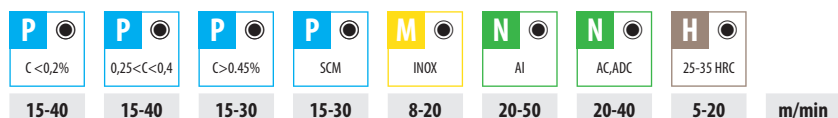
Type 1



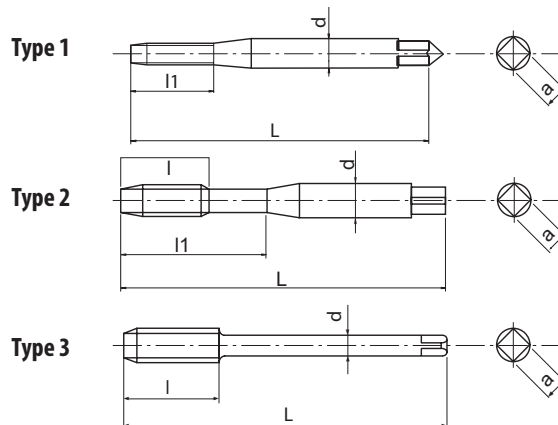
Type 2



- First choice in quality and performance
- HSSE forming tap for through & blind holes
- Multilayer TiCN coating
- For general steels, stainless steels, aluminium
- Center through coolant, chamfer Form E

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Threading | Forming taps | Metric



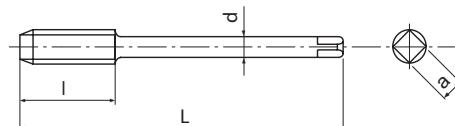
- First choice in quality and performance
- HSSE forming tap for through & blind holes
- Multilayer TiCN coating
- For general steels, stainless steels, aluminium
- With long shank for deep threading

P 	P 	P 	P 	M 	N 	N 	H 
C < 0,2%	0,25 < C < 0,4	C > 0,45%	SCM	INOX	Al	AC, ADC	25-35 HRC
15-40	15-40	15-30	15-30	8-20	20-50	20-40	5-20
							m/min

	M	HSS-Co		ISO 2 6HX					
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Threading | Forming taps | Metric



- First choice in quality and performance
- HSSE forming tap for through & blind holes
- Multilayer TiCN coating
- For general steels, stainless steels, aluminium
- With long shank for deep threading, side through coolant

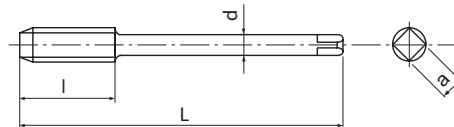
Threading | Forming taps



m/min

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Threading | Forming taps | Metric



- | | | | | | | | |
|--|--|--|--|--|--|--|--|
| P  | P  | P  | P  | M  | N  | N  | H  |
| C < 0,2% | 0,25 < C < 0,4 | C > 0,45% | SCM | INOX | Al | AC, ADC | 25-35 HRC |
| 15-40 | 15-40 | 15-30 | 15-30 | 8-20 | 20-50 | 20-40 | 5-20 |
| | | | | | | | m/min |

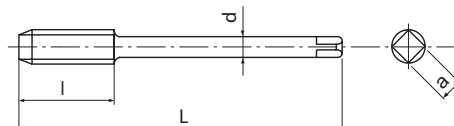


Threading | Forming taps



Metric

Threading | Forming taps | Metric

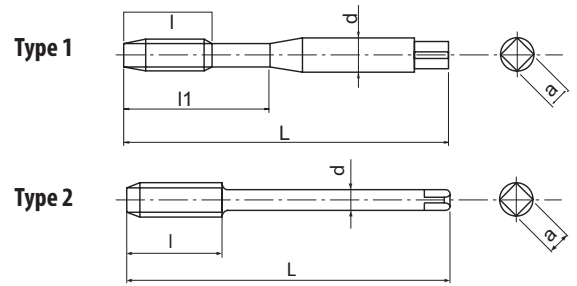


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|--|--|--|--|--|--|--|--|
| P  | P  | P  | P  | M  | N  | N  | H  |
| C <0,2% | 0,25<C<0,4 | C>0.45% | SCM | INOX | Al | AC,ADC | 25-35 HRC |
| 15-40 | 15-40 | 15-30 | 15-30 | 8-20 | 20-50 | 20-40 | 5-20 |
- m/min



Threading | Forming taps

Threading | Forming taps | Metric



- | | | | | | | | |
|--|--|--|--|--|--|--|-------|
| P  | P  | P  | P  | M  | N  | N  | |
| C <0,2% | 0,25<C<0,4 | C>0.45% | SCM | INOX | Al | Al,ADC | |
| 10-20 | 10-20 | 10-20 | 10-20 | 8-15 | 10-15 | 10-15 | m/min |

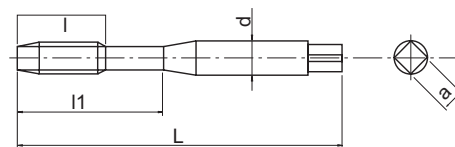


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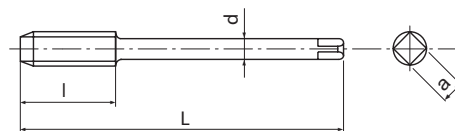
Threading | Forming taps | Metric



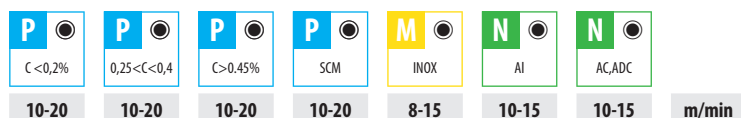
Type 1



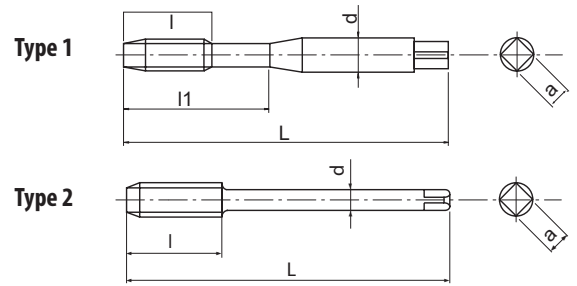
Type 2



- First choice in quality and performance
- HSSE forming tap for through & blind holes
- Multilayer TiCN coating
- For general steels, stainless steels, aluminium
- Without oil grooves for higher rigidity, for 6G internal thread tolerance

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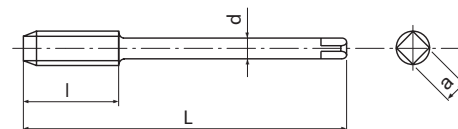
Threading | Forming taps | Metric



- | | | | | | | | | |
|--|--|--|--|--|--|--|--|-------|
| P  | P  | P  | P  | M  | N  | N  | H  | |
| C <0,2% | 0,25<C<0,4 | C>0.45% | SCM | INOX | Al | AC,ADC | 25-35 HRC | |
| 15-40 | 15-40 | 15-30 | 15-30 | 8-20 | 20-50 | 20-40 | 5-20 | m/min |



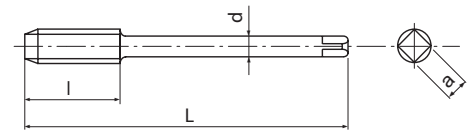
Metric



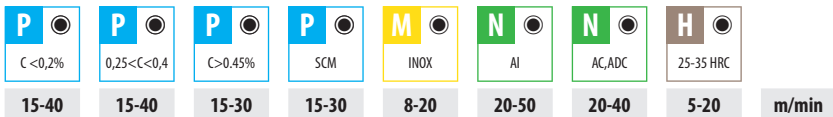
- ## Threading | Forming taps



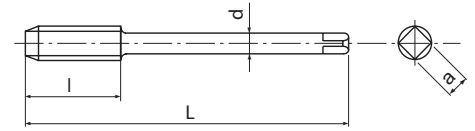
Threading | Forming taps | Metric Fine



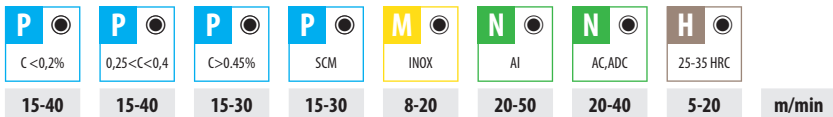
- First choice in quality and performance
- HSSE forming tap for through & blind holes
- Multilayer TiCN coating
- For general steels, stainless steels, aluminium
- Side through coolant

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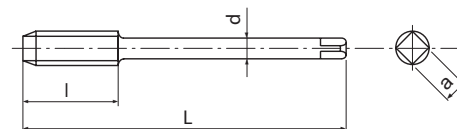
Threading | Forming taps | Metric Fine



- First choice in quality and performance
- HSSE forming tap for through & blind holes
- Multilayer TiCN coating
- For general steels, stainless steels, aluminium
- For 6G internal thread tolerance

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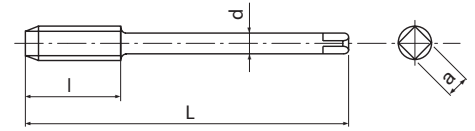
Threading | Forming taps | Metric Fine



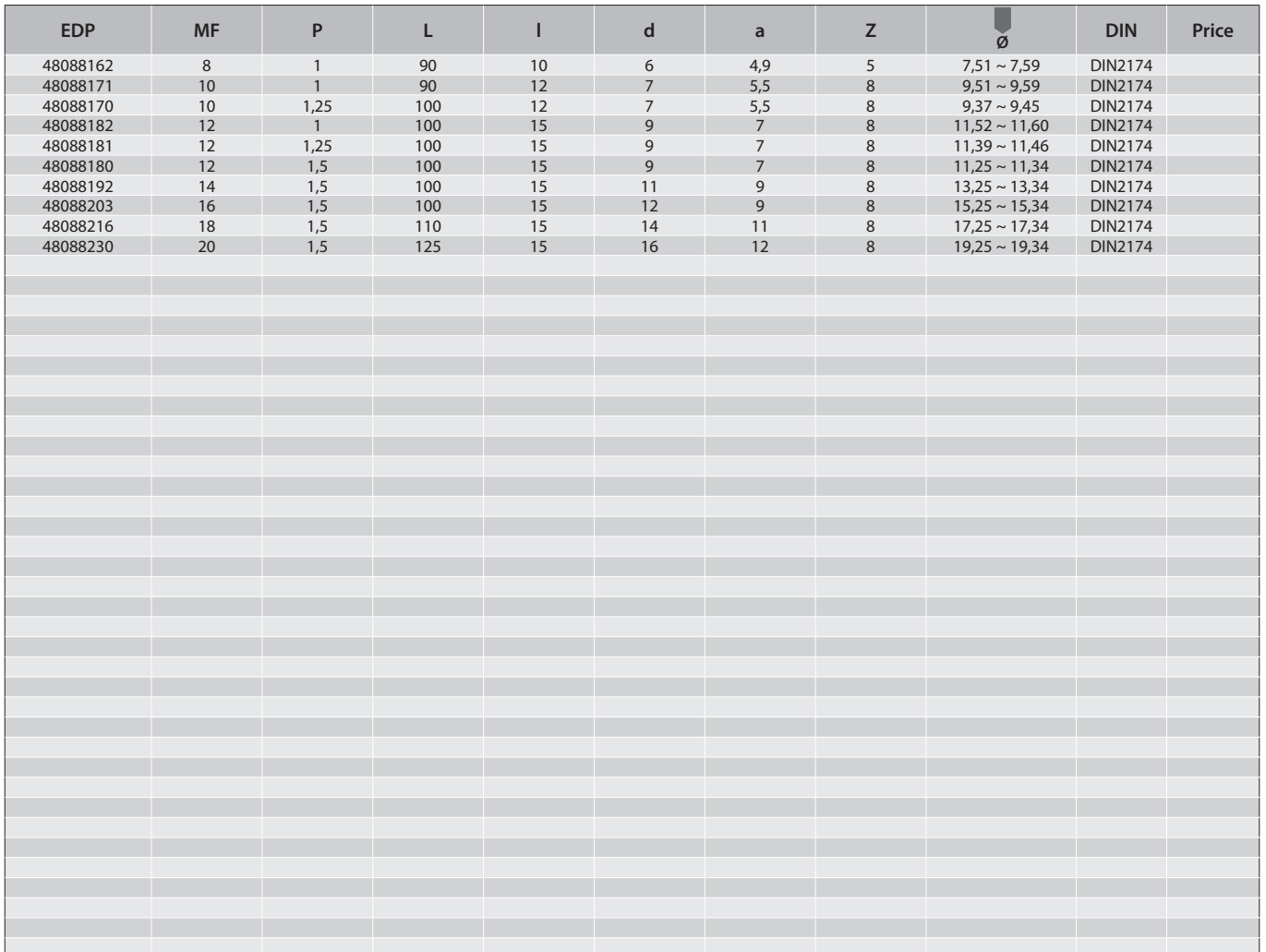
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|--|--|--|--|--|--|--|--|
| P  | P  | P  | P  | M  | N  | N  | H  |
| C < 0,2% | 0,25 < C < 0,4 | C > 0,45% | SCM | INOX | Al | Al, ADC | 25-35 HRC |
| 15-40 | 15-40 | 15-30 | 15-30 | 8-20 | 20-50 | 20-40 | 5-20 |
- m/min

[illegible]

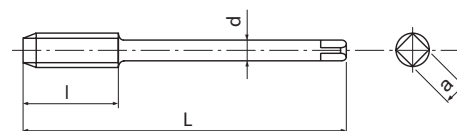
Threading | Forming taps | Metric Fine



- ## Threading | Forming taps



Threading | Forming taps | Metric Fine

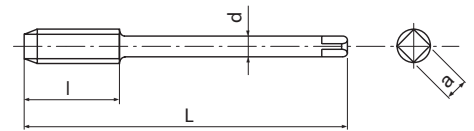


- | | | | | | | | | |
|--|--|--|--|--|--|--|--|-------|
| P  | P  | P  | P  | M  | N  | N  | H  | |
| C < 0,2% | 0,25 < C < 0,4 | C > 0,45% | SCM | INOX | Al | AC, ADC | 25-35 HRC | |
| 15-40 | 15-40 | 15-30 | 15-30 | 8-20 | 20-50 | 20-40 | 5-20 | m/min |

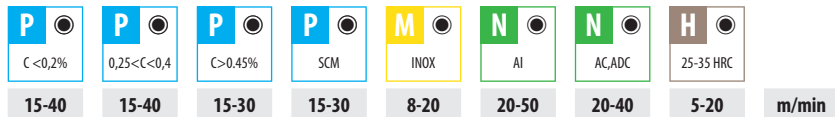
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S-OIL-XPF FORM E NEW

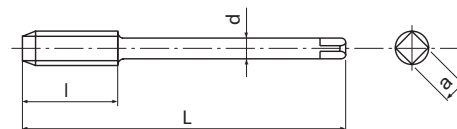
Threading | Forming taps | Metric Fine



- First choice in quality and performance
- HSSE forming tap for through & blind holes
- Multilayer TiCN coating
- For general steels, stainless steels, aluminium
- Chamfer Form E, center through coolant

[illegible]

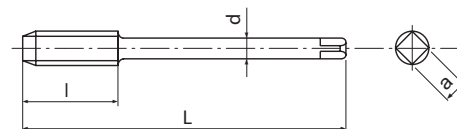
Threading | Forming taps | Metric Fine



- First choice in quality and performance
- HSSE forming tap for through & blind holes
- Multilayer TiCN coating
- For general steels, stainless steels, aluminium
- With long shank for long reach threading, side through coolant

[illegible]

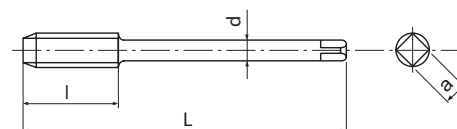
Threading | Forming taps | Metric Fine



- First choice in quality and performance
- HSSE forming tap for through & blind holes
- Multilayer TiCN coating
- For general steels, stainless steels, aluminium
- Without oil grooves for higher rigidity

40

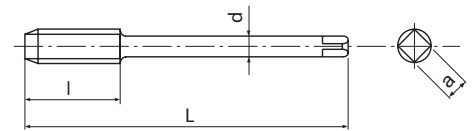
Threading | Forming taps | Metric Fine



- First choice in quality and performance
- HSSE forming tap for through & blind holes
- Multilayer TiCN coating
- For general steels, stainless steels, aluminium
- Without oil grooves for higher rigidity, for 6G internal thread tolerance

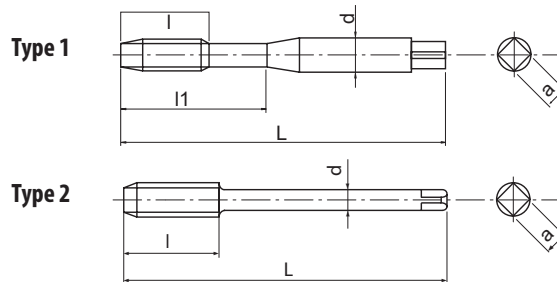
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Threading | Forming taps | Metric Fine



- ## Threading | Forming taps

Metric Fine

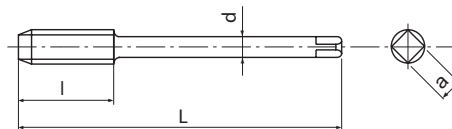
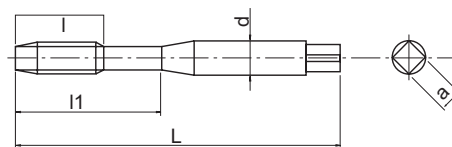


- First choice in quality and performance
- HSSE forming tap for through & blind holes
- Multilayer TiCN coating
- For general steels, stainless steels, aluminium

P 	P 	P 	P 	M 	N 	N 	H 	
C < 0,2%	0,25 < C < 0,4	C > 0,45%	SCM	INOX	Al	AC, ADC	25-35 HRC	
15-40	15-40	15-30	15-30	8-20	20-50	20-40	5-20	m/min

[illegible]

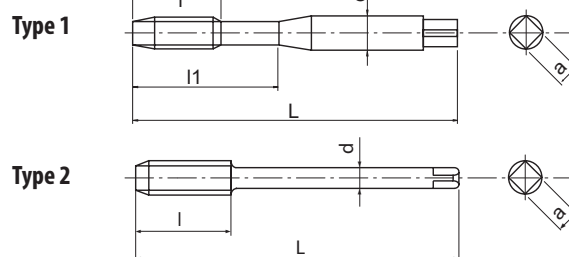
Threading | Forming taps | UNC



- First choice in quality and performance
- HSSE forming tap for through & blind holes
- Multilayer TiCN coating
- For general steels, stainless steels, aluminium
- Side through coolant

[illegible]

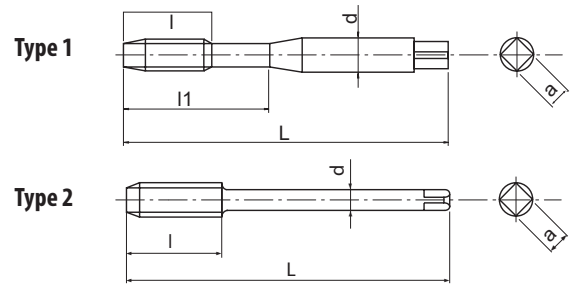
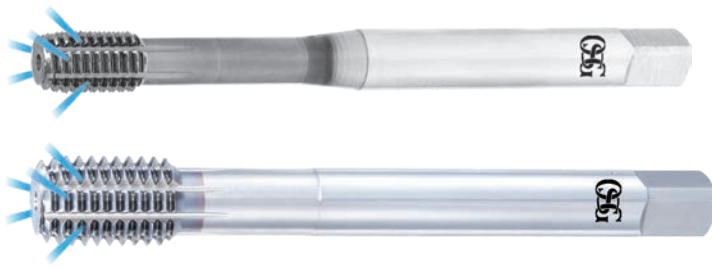
Threading | Forming taps | UNF



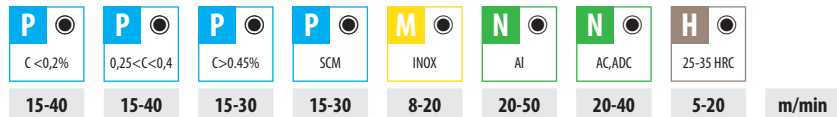
- | | | | | | | | | |
|--|--|--|--|--|--|--|--|-------|
| P  | P  | P  | P  | M  | N  | N  | H  | |
| C < 0,2% | 0,25 < C < 0,4 | C > 0,45% | SCM | INOX | Al | Al, ADC | 25-35 HRC | |
| 15-40 | 15-40 | 15-30 | 15-30 | 8-20 | 20-50 | 20-40 | 5-20 | m/min |

[illegible]

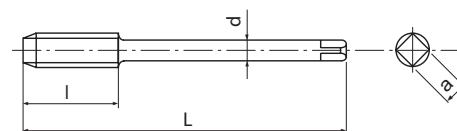
Threading | Forming taps | UNF



- First choice in quality and performance
- HSSE forming tap for through & blind holes
- Multilayer TiCN coating
- For general steels, stainless steels, aluminium
- Side through coolant

[illegible]

Threading | Forming taps | G (BSP)

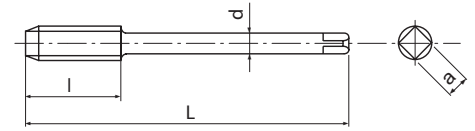


- | | | | | | | | |
|--|--|--|--|--|--|--|--|
| P  | P  | P  | P  | M  | N  | N  | H  |
| C < 0,2% | 0,25 < C < 0,4 | C > 0,45% | SCM | INOX | Al | AC, ADC | 25-35 HRC |
| 15-40 | 15-40 | 15-30 | 15-30 | 8-20 | 20-50 | 20-40 | 5-20 |
- m/min

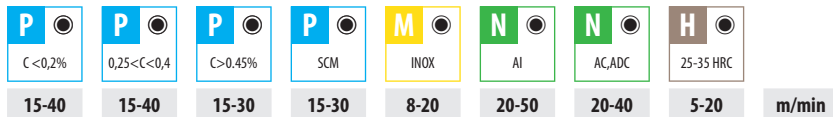
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S-OIL-XPf NEW

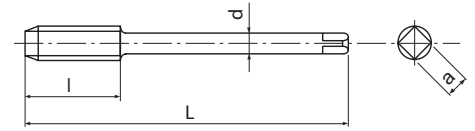
Threading | Forming taps | G (BSP)



- First choice in quality and performance
- HSSE forming tap for through & blind holes
- Multilayer TiCN coating
- For general steels, stainless steels, aluminium
- Side through coolant

[illegible]

Threading | Forming taps | G (BSP)



- First choice in quality and performance
- HSSE forming tap for through & blind holes
- Multilayer TiCN coating
- Without oil grooves for higher rigidity

P 	P 	P 	P 	M 	N 	N 	
$C < 0,2\%$	$0,25 < C < 0,4$	$C > 0,45\%$	SCM	INOX	AI	AC,ADC	
10-20	10-20	10-20	10-20	8-15	10-15	10-15	m/min

[illegible]

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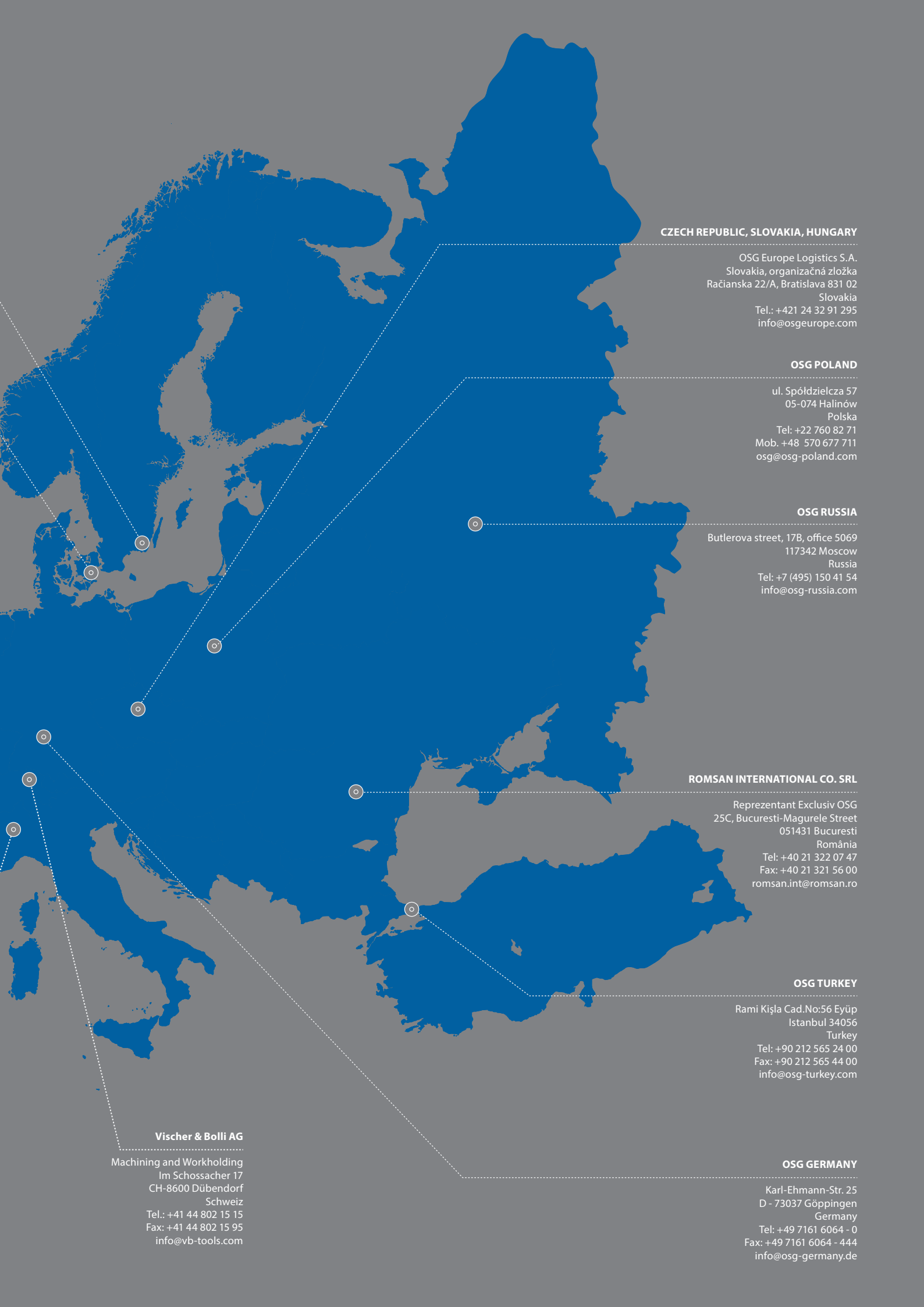
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