



**THE MOST
PERFECT ALLROUNDER**
THAT A CNC MACHINE HAS EVER FACED

threading





dcswiss.com

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.

We have made every effort to ensure that the information (drawings, prints, technical data) given is correct.

However, we do not assume any responsibility for any errors, omissions or subsequent changes.

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QTAP

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CREATING VALUE THROUGH TECHNOLOGY & SERVICES

With more than 75 years of experience in threading technology, DC SWISS is one of the world's leading manufacturers of high-quality precision threading tools.

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

DC threading tools guarantee precision 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.



Core hole diameter



Number of flutes (Z)



For Classic Tapping



For Rigid Tapping



HSSE-PM



HSSE



Straight flutes with spiral point



40° right hand spiral flutes



Internal coolant with frontal outflow



Internal coolant with radial outflow



Through hole,
long chipping materials



Blind hole $< 2.5 \times D$,
long chipping materials



2 - 3 chamfered threads,
form C



3.5 - 5 chamfered threads,
form B



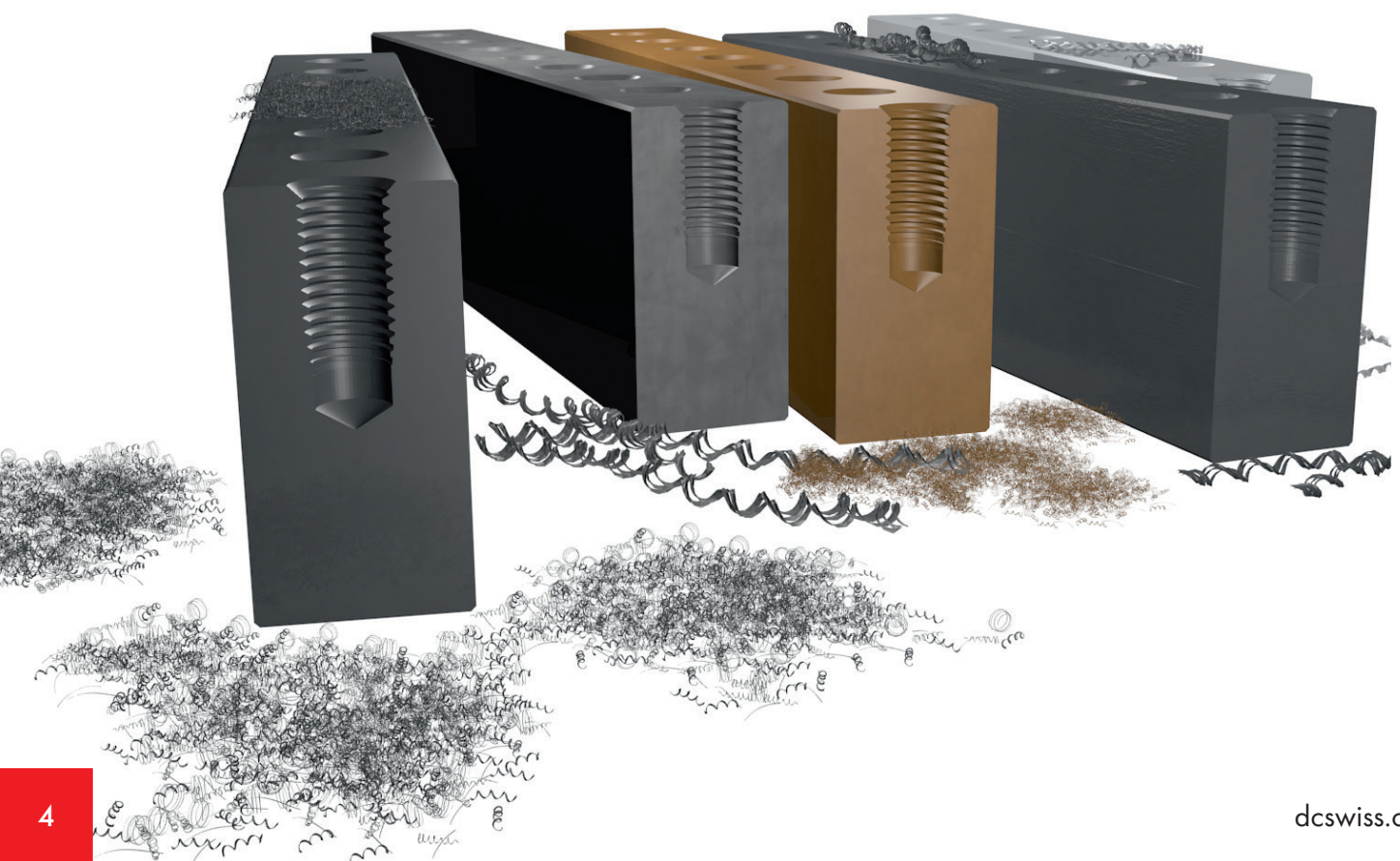
VS-coating



In stock



Delivery time : between 3 to 6 weeks



NC-THREADING

MULTI-PURPOSE TAP WITH PERFECT CHIP CONTROL SETS NEW RULES IN NC-TAPING PROCESS.

DC SWISS integrates :

FUNCTIONALITY

UNIVERSALITY

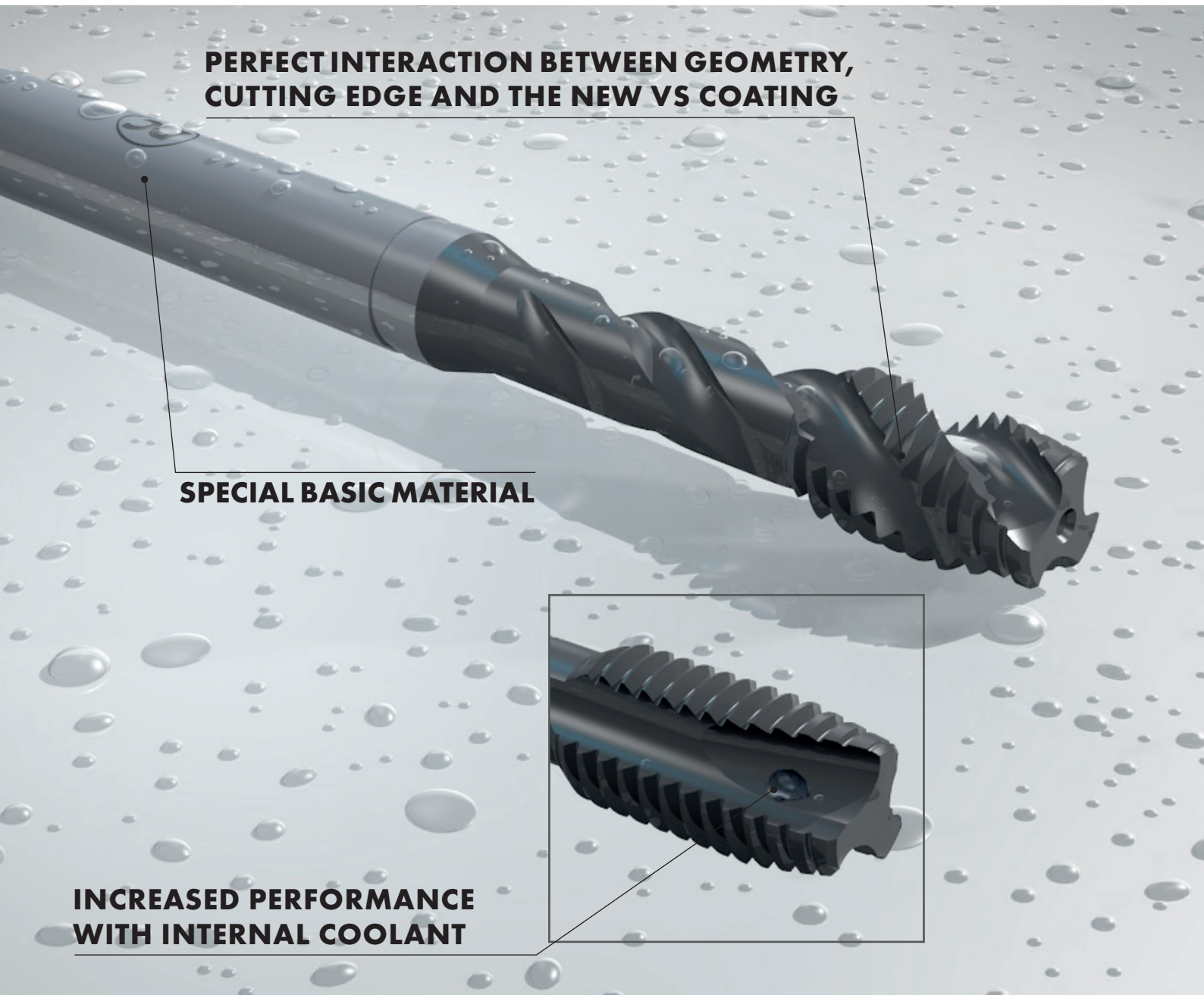
&

PERFORMANCE

QTAP




FEATURES



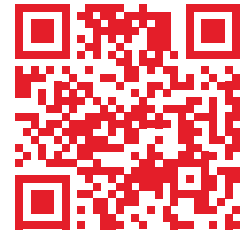
**PERFECT INTERACTION BETWEEN GEOMETRY,
CUTTING EDGE AND THE NEW VS COATING**

SPECIAL BASIC MATERIAL

**INCREASED PERFORMANCE
WITH INTERNAL COOLANT**

 **Q-TAP** cuts a wide range of materials – carbon steels, alloy steels, stainless steels, aluminium, cast iron, brass alloys.

THE INNOVATIVE GEOMETRIC DESIGN IN INTERACTION WITH THE PERFECT CUTTING EDGE AND THE NEW VS COATING ALLOWS TO HANDLE VARIOUS MATERIALS AND APPLICATIONS.



**DISCOVER OUR
YOUTUBE VIDEO**

Q.20VS



FOR THROUGH HOLES
SPIRAL POINT
GEOMETRY AND CUTTING EDGE OPTIMISED
VS-COATING

Q.23VS



FOR THROUGH HOLES
SPIRAL POINT
GEOMETRY AND CUTTING EDGE OPTIMISED
VS-COATING
INTERNAL COOLANT WITH RADIAL OUTFLOW

Q.60VS



FOR BLIND HOLES
SPIRAL FLUTES
GEOMETRY AND CUTTING EDGE OPTIMISED
VS-COATING

Q.63VS



FOR BLIND HOLES
SPIRAL FLUTES
GEOMETRY AND CUTTING EDGE OPTIMISED
VS-COATING
CENTRAL INTERNAL COOLANT WITH FRONTAL OUTFLOW

DC TAPPING CHUCKS



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



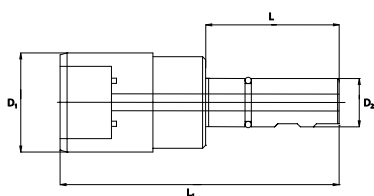
DC Swiss offers a specific total solution adapted to this modern machining method; a tapping chuck with axial shock absorber, type SRT, Soft Rigid Tapping. This tapping chuck, suitable for quick change systems is able to overcome the axial pressure applied to the cutting edges while the spindle reverses,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

SRT Tapping chucks with axial shock absorber



<h2>SRT short</h2>	SRT312-D20 SRT312-D25 SRT520-D25									
	<table border="0"> <tr> <td style="text-align: center;"></td> <td style="text-align: center;"></td> <td style="text-align: center;"></td> </tr> <tr> <td style="text-align: center;"></td> <td style="text-align: center;"></td> <td style="text-align: center;"></td> </tr> <tr> <td style="text-align: center;"></td> <td style="text-align: center;"></td> <td style="text-align: center;"></td> </tr> </table>									

DIN 1835 B short

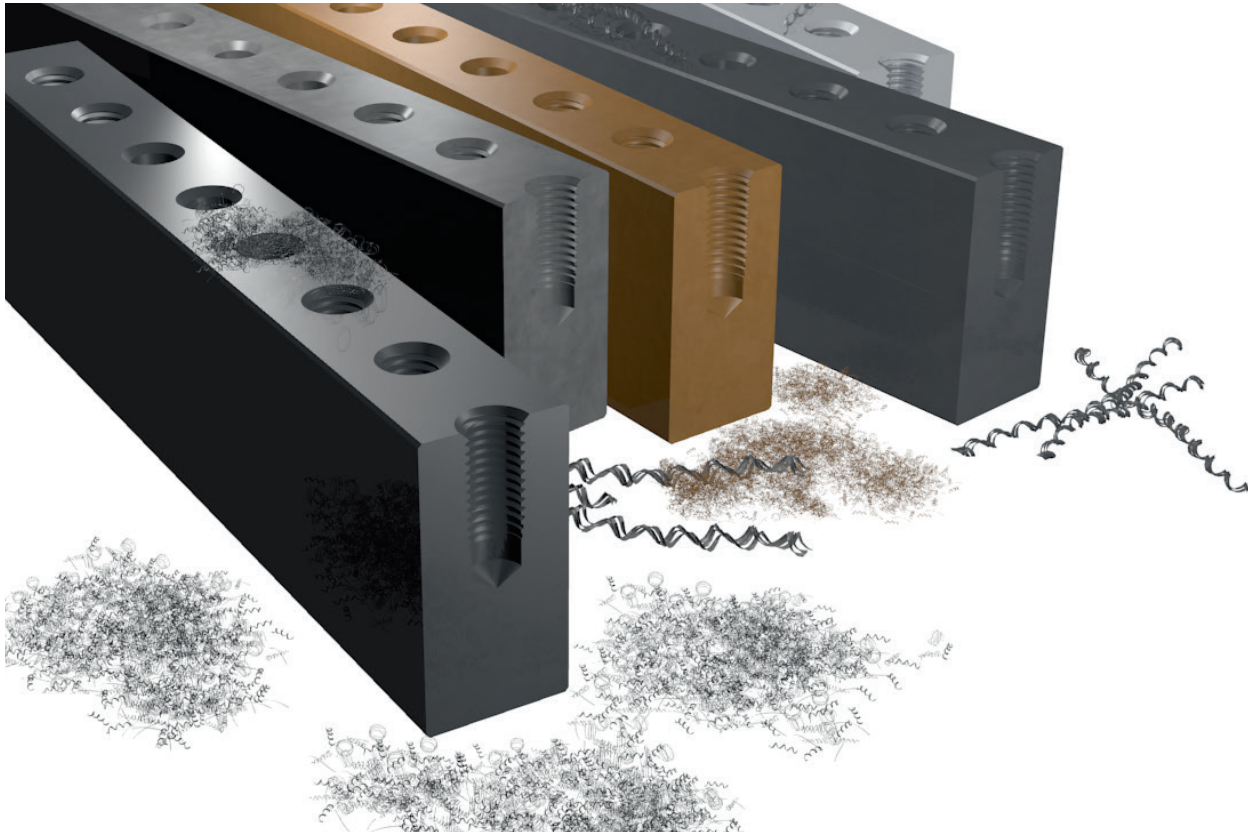


						SRT312-D20	SRT312-D25	SRT520-D25	
						ID			
d_1	D_1 mm	D_2 mm	L mm	L_1 mm					
M3 - M12	39	20	47	86.0	S1	●	162832		
M3 - M12	39	25	53	90.0	S1		●	162831	
M5 - M20	56	25	53	110.0	S2			●	162833

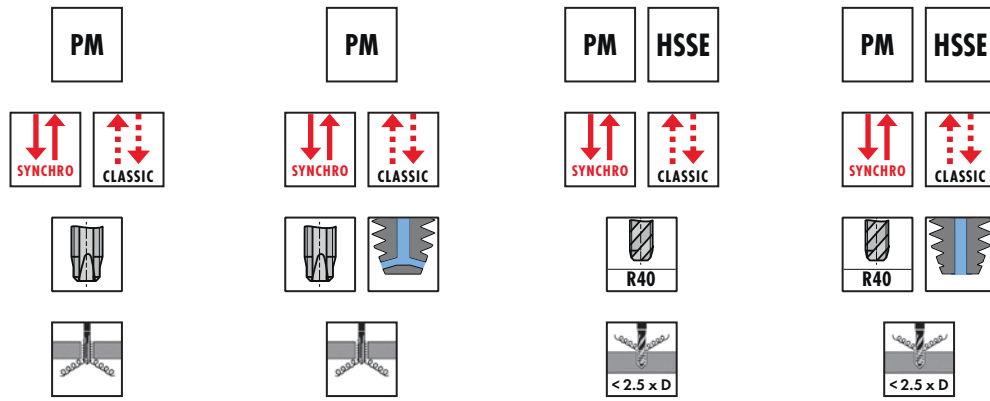
● In stock

DC APPLICATIONS

QTAP



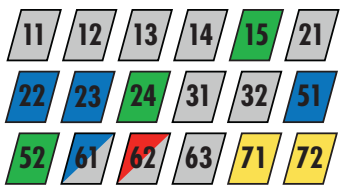












MATERIAL GROUPS	MATERIAL DESIGNATIONS	
STEELS	11	FREE-CUTTING STEELS
	12	STRUCTURAL / CEMENTATION STEELS
	13	CARBON STEELS
	14	ALLOY STEELS <850 N/mm ²
	15	ALLOY STEELS HARD. / TEMP. >850 - <1150 N/mm ²
STAINLESS STEELS	21	FREE MACHINING STAINLESS STEELS
	22	AUSTENITIC STAINLESS STEELS
	23	FERRITIC AND MARTENSITIC <850 N/mm ²
	24	FERRITIC AND MARTENSITIC >850 - <1150 N/mm ²
CAST IRON	31	CAST IRON
	32	SPHEROIDAL GRAPHITE + MALLEABLE CAST IRON
NICKEL	51	NICKEL ALLOYS 1 <850 N/mm ²
	52	NICKEL ALLOYS 2 >850 - <1150 N/mm ²
COPPER	61	PURE COPPER (ELECTROLYTIC COPPER)
	62	SHORT CHIP BRASS, PHOSPHOR BRONZE, GUN METAL
	63	LONG CHIP BRASS
ALUMINIUM MAGNESIUM	71	AL UNALLOYED
	72	AL ALLOYED Si < 1.5 %
	73	AL ALLOYED Si > 1.5 % - < 10 %
	74	AL ALLOYED Si > 10 %, MG ALLOYS
PLASTIC COMPOUNDS	81	THERMOPLASTICS
	82	DUROPLASTICS
	83	GLASS FIBRE REINFORCED PLASTICS

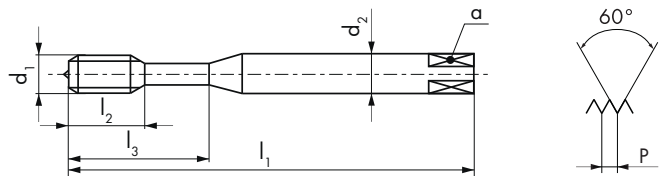
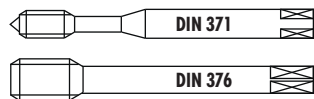


	Q.20VS		Q.23VS		Q.60VS		Q.63VS	
	Q320VS-4	Q420VS-4	Q323VS-4	Q423VS-4	Q360VS-3	Q460VS-3	Q363VS-3	Q463VS-3
	VS							
	Vc (m/min)							
11	20 - 30							
12	20 - 30							
13	16 - 24							
14	16 - 24							
15	6 - 12							
21	20 - 30							
22	6 - 12							
23	6 - 12							
24	4 - 8							
31	20 - 30							
32	20 - 30							
51	6 - 12							
52	4 - 8							
61	12 - 16							
62	25 - 35							
63	20 - 30							
71	20 - 30							
72	20 - 30							
73	20 - 30							
74	20 - 30							
81	20 - 30							
82	16 - 24							
83	8 - 16							


DC® THREAD CUTTING – QTAP

PM	 	Q320VS-4 	Q420VS-4 	Q320VS-4 Q420VS-4 
		       		

M ISO DIN 13



Q320VS-4	Q420VS-4
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M	d ₁	Ød ₁ mm	P mm	l ₁ mm	l ₂ mm	l ₃ mm	d ₂ mm	α mm			ID	
											6H	6H
M3	3.0	0.50	56	12.0	18	3.5	2.7	3	2.50	●	195494	
M4	4.0	0.70	63	14.0	21	4.5	3.4	3	3.30	●	195495	
M5	5.0	0.80	70	15.0	25	6.0	4.9	3	4.20	●	195496	
M6	6.0	1.00	80	17.0	30	6.0	4.9	3	5.00	●	195497	
M8	8.0	1.25	90	20.0	35	8.0	6.2	3	6.80	●	195498	
M10	10.0	1.50	100	22.0	39	10.0	8.0	3	8.50	●	195499	
M12	12.0	1.75	110	24.0		9.0	7.0	3	10.20		●	195500
M14	14.0	2.00	110	28.0		11.0	9.0	3	12.00		●	195501
M16	16.0	2.00	110	30.0		12.0	9.0	3	14.00		●	195502
M20	20.0	2.50	140	36.0		16.0	12.0	4	17.50		●	195503
M24	24.0	3.00	160	39.0		18.0	14.5	4	21.00		●	195504

THREAD CUTTING – QTAP

$\leq \varnothing 16$ $> \varnothing 16$

PM

HSSE

CLASSIC

SYNCHRO

Q360VS-3

11

12

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Q460VS-3

73

74

81

82

83

Q360VS-3

Q460VS-3

VS

VS

R40

R40

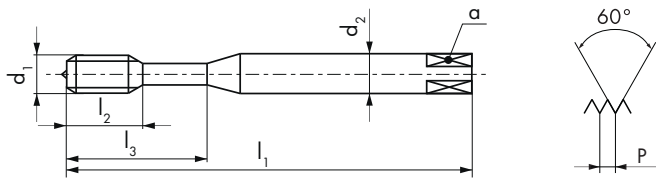
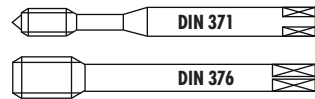
< 2.5 x D

< 2.5 x D

C
 2.5 x P

C
 2.5 x P

M ISO DIN 13



		Q360VS-3	Q460VS-3
		ID	
		6H	6H

M	d ₁	Ød ₁ mm	P mm	l ₁ mm	l ₂ mm	l ₃ mm	d ₂ mm	α mm		
M3	3.0	3.0	0.50	56	5.5	18	3.5	2.7	3	2.50
M4	4.0	4.0	0.70	63	7.5	21	4.5	3.4	3	3.30
M5	5.0	5.0	0.80	70	9.0	25	6.0	4.9	3	4.20
M6	6.0	6.0	1.00	80	11.0	30	6.0	4.9	3	5.00
M8	8.0	8.0	1.25	90	12.5	35	8.0	6.2	3	6.80
M10	10.0	10.0	1.50	100	14.0	39	10.0	8.0	3	8.50
M12	12.0	12.0	1.75	110	14.0		9.0	7.0	3	10.20
M14	14.0	14.0	2.00	110	14.0		11.0	9.0	3	12.00
M16	16.0	16.0	2.00	110	18.0		12.0	9.0	3	14.00
M20	20.0	20.0	2.50	140	24.0		16.0	12.0	3	17.50
M24	24.0	24.0	3.00	160	27.0		18.0	14.5	4	21.00

●	195516
●	195517
●	195518
●	195519
●	195520
●	195521
●	195522
●	195523
●	195524
●	195525
●	195526

- In stock
- Delivery time: between 3 to 6 weeks

DC® THREAD CUTTING – QTAP

PM

CLASSIC

SYNCHRO

Q323VS-4

11 12 13 14 15 21


22 23 24 31 32 51

52 61 62 63 71 72


Q423VS-4

73 74 81 82 83





Q323VS-4



Q423VS-4







VS

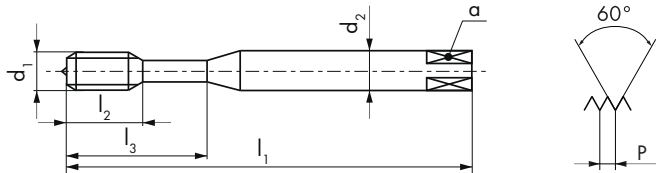
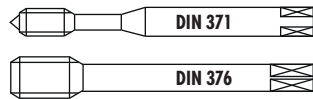
B
4 x P

VS

B
4 x P

M ISO DIN 13



Q323VS-4	Q423VS-4
ID	
6H	6H
● 195505	
● 195506	
● 195507	
● 195508	
● 195509	
● 195510	
	● 195511
	● 195512
	● 195513
	● 195514
	● 195515

	d ₁	Ød ₁ mm	P mm	l ₁ mm	l ₂ mm	l ₃ mm	d ₂ mm	α mm		
M3	3.0	3.0	0.50	56	12.0	18	3.5	2.7	3	2.50
M4	4.0	4.0	0.70	63	14.0	21	4.5	3.4	3	3.30
M5	5.0	5.0	0.80	70	15.0	25	6.0	4.9	3	4.20
M6	6.0	6.0	1.00	80	17.0	30	6.0	4.9	3	5.00
M8	8.0	8.0	1.25	90	20.0	35	8.0	6.2	3	6.80
M10	10.0	10.0	1.50	100	22.0	39	10.0	8.0	3	8.50
M12	12.0	12.0	1.75	110	24.0		9.0	7.0	3	10.20
M14	14.0	14.0	2.00	110	28.0		11.0	9.0	3	12.00
M16	16.0	16.0	2.00	110	30.0		12.0	9.0	3	14.00
M20	20.0	20.0	2.50	140	36.0		16.0	12.0	4	17.50
M24	24.0	24.0	3.00	160	39.0		18.0	14.5	4	21.00

THREAD CUTTING – QTAP

$\leq \varnothing 16$ $> \varnothing 16$

PM

HSSE

↑ ↓
CLASSIC

↓ ↑
SYNCHRO

Q363VS-3
Q463VS-3

VS

R40

< 2.5 x D

C
2.5 x P

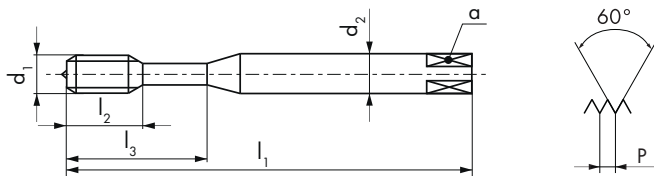
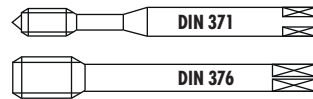
VS

R40

< 2.5 x D

C
2.5 x P

M ISO DIN 13

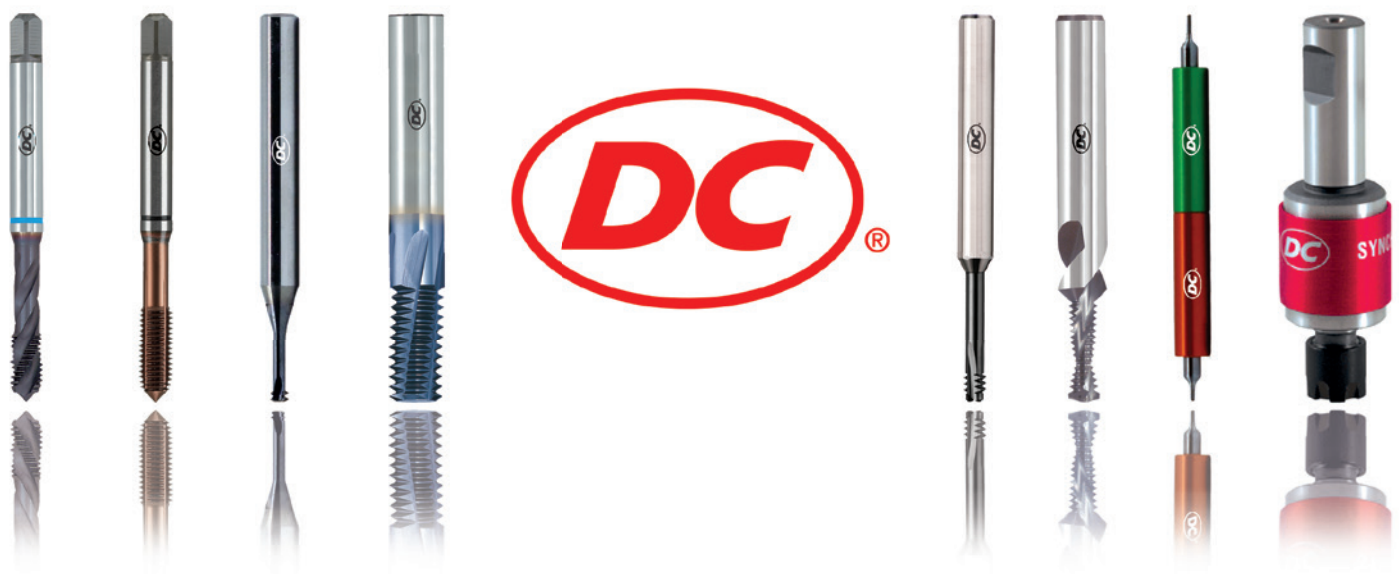


		Q363VS-3	Q463VS-3
		ID	
		6H	6H

M	d ₁	∅d ₁ mm	P mm	l ₁ mm	l ₂ mm	l ₃ mm	d ₂ mm	α mm		
M3	3.0	3.0	0.50	56	5.5	18	3.5	2.7	3	2.50
M4	4.0	4.0	0.70	63	7.5	21	4.5	3.4	3	3.30
M5	5.0	5.0	0.80	70	9.0	25	6.0	4.9	3	4.20
M6	6.0	6.0	1.00	80	11.0	30	6.0	4.9	3	5.00
M8	8.0	8.0	1.25	90	12.5	35	8.0	6.2	3	6.80
M10	10.0	10.0	1.50	100	14.0	39	10.0	8.0	3	8.50
M12	12.0	12.0	1.75	110	14.0		9.0	7.0	3	10.20
M14	14.0	14.0	2.00	110	14.0		11.0	9.0	3	12.00
M16	16.0	16.0	2.00	110	18.0		12.0	9.0	3	14.00
M20	20.0	20.0	2.50	140	24.0		16.0	12.0	3	17.50
M24	24.0	24.0	3.00	160	27.0		18.0	14.5	4	21.00

● 195527
● 195528
● 195529
● 195530
● 195531
● 195532
● 195533
● 195534
● 195535
● 195536
● 195537

- In stock
- Delivery time: between 3 to 6 weeks



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