



# A BRAND A-XPF & A-OIL-XPF

Highly Efficient Multi-Purpose Forming Tap

Designed for a Wide Variety of Materials

## PRIMARY TARGETS

- Customers Tapping Deep Threads in Blind Holes
- Customers with High-Volume Production
- Job Shops that Run into a Wide Array of Materials

## SOLUTIONS

- Reduces Tool Change Time and Machine Downtime Caused by Cutting Chip Troubles.

## WHAT OUR CUSTOMERS SEE

- Stable and Uninterrupted Machining

## HOW DOES IT WORK?

### Special Chamfer Specification

- Achieves Stable Machining with Reduced Thrust

### Special Thread Configuration

- Improved Cutting Edge and Thread Rigidity

### New VI Coating

- Formulated for High-Performance Taps that is Suitable for High-Loading Machining with High-Hardness, Oxidation Resistance and Excellent Lubricity.



**A**  
The A Brand

# A Brand A-XPF & A-OIL-XPF

## Advanced Performance Highly Efficient Multi-Purpose Forming Tap

### A Brand A-XPF & A-OIL-XPF

OSG's A Brand XPF forms threads by deformation of the work material and does not generate cutting chips resolving tapping troubles that are caused by unstable chip evacuation. The A-XPF enables the reduction of tool change time caused by cutting chip troubles and machine downtime required for removing accumulated cutting chips. Enabling stable and uninterrupted machining, the A-XPF can reduce power consumption, which minimizes environmental impact. The newly released A-OIL-XPF adds coolant-fed options to the A-XPF series for even higher performance capabilities.



### Features & Benefits

- **Special Chamfer Specification** achieves stable machining with reduced thrust.
- **Special Thread Configuration** for improved cutting edge and thread rigidity.
- **Coolant-Fed** options for high-performance
- **New VI Coating** formulated for high-performance taps that is suitable for high-loading machining with high-hardness, oxidation resistance and excellent lubricity.
- **Large Offering** Inch and metric offering with size range of No. 0-1"

### List Numbers

	Size Range
26250 - A Brand A-XPF (Inch)	No. 0-1"
26350 - A Brand A-XPF (Metric)	M1-M24
<b>NEW</b> 26050 - A Brand A-OIL-XPF (Inch)	1/4"-1"
26150 - A Brand A-OIL-XPF (Metric)	M5-M24
26255 - A Brand A-LT-XPF (Inch, Long Shank)	No. 5-1"
26355 - A Brand A-LT-XPF (Metric, Long Shank)	M3-M20
26260 - A Brand A-XPF-STI (Inch, STI)	No. 2-1"
26360 - A Brand A-XPF-STI (Metric, STI)	M2-M24

### Revolutionary Productivity with Zero Cutting Chips

#### Avoid Common Tapping Troubles

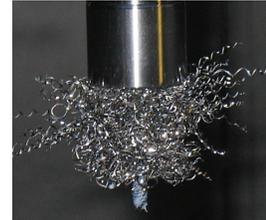
Most tapping troubles are caused by unstable chip evacuation. The A-XPF forms threads by plastic deformation of the work material and does not generate cutting chips. It is a revolutionary product that excels in a wide range of work materials and cutting conditions.

#### Common Tapping Issues

1 Breakage and chipping	26%
2 Dimensional error	17%
3 Galling	14%
Other	43%

Source: OSG Technical Consultation Division

Chip Packing



### Stable Machining with Reduced Thrust

#### Avoid Common Tapping Troubles

#### Tool

A-XPF M3x0.5 2P

#### Work Material

4140 (30HRC)

#### Drill Hole Size

Ø2.8x9mm (Blind)

#### Tapping Length

6mm (2D)

#### Cutting Speed

49 SFM (1,591 RPM)

#### Coolant

Water-Soluble Chlorine-Free (5%)

#### Machine

BT30 Vertical Machining Center

