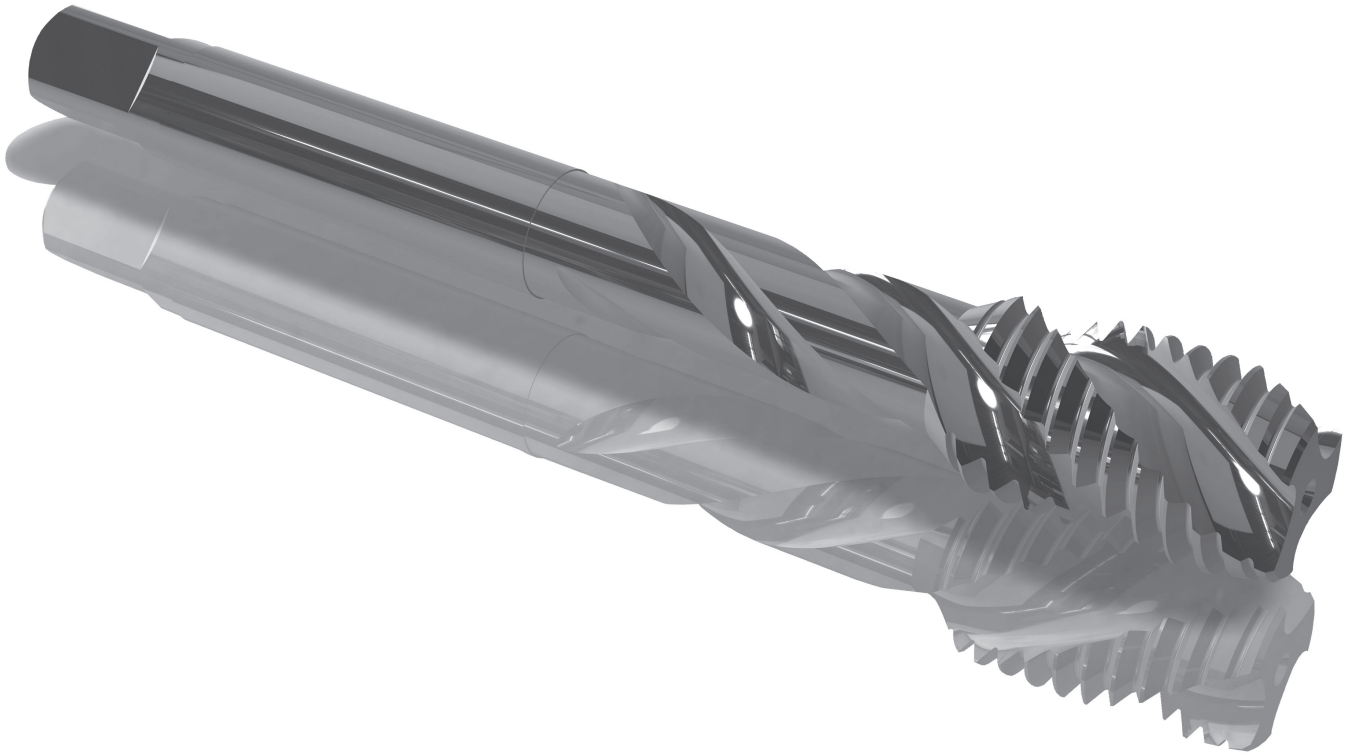
JIS

TAP STANDARD



DC®

THREADING TECHNOLOGY

EN-ID-0316

DC Swiss stands for High Quality Tools made in Switzerland. For over 75 years the company designs, produces and markets top of the range thread cutting tools intended for all companies and all materials. As one of the leading Tap Manufacturers in Europe and with over 6'000 standard articles, **DC Swiss** offers a reliable solution to any threading application.

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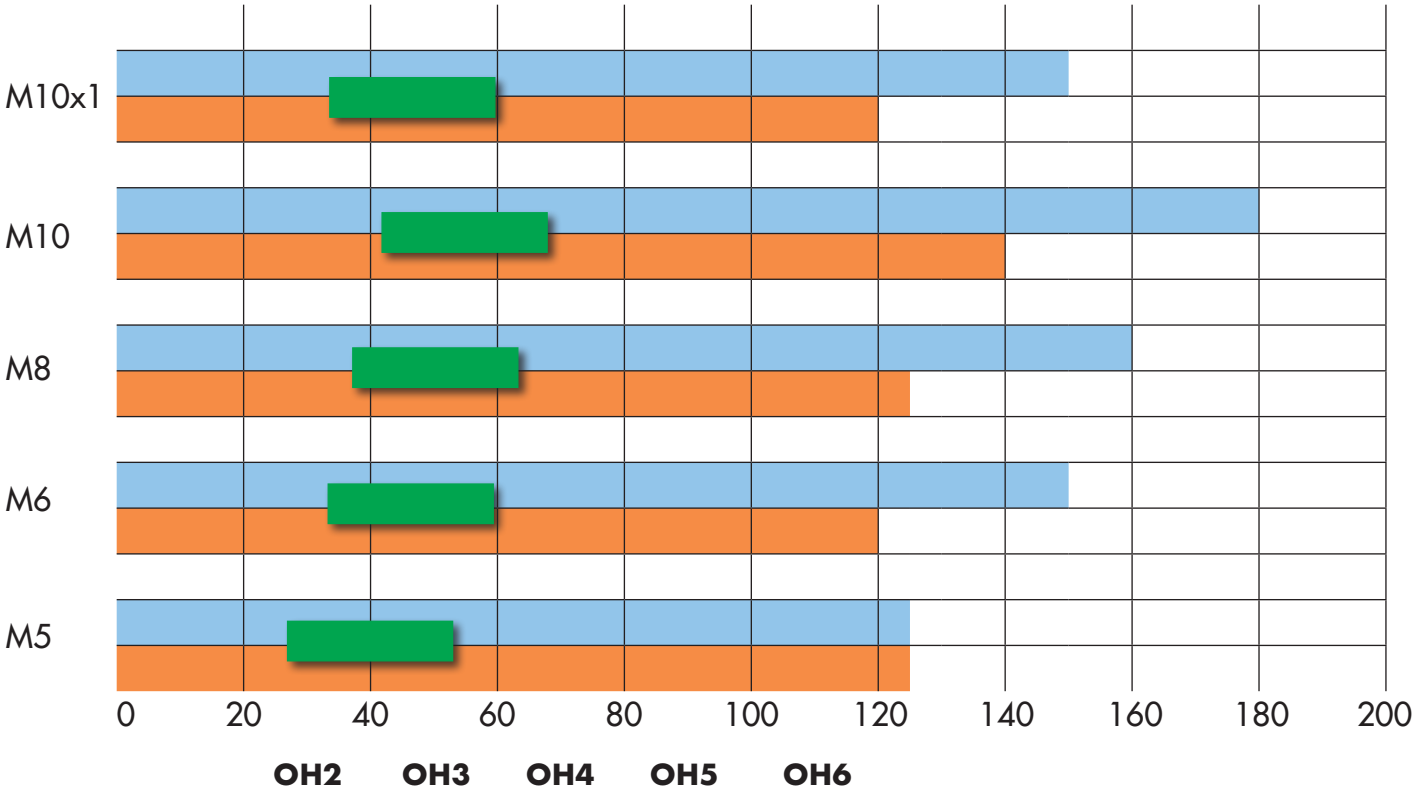
JIS TOLERANCES



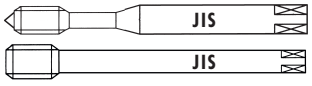
JIS / ISO965 / DIN13 / 6H

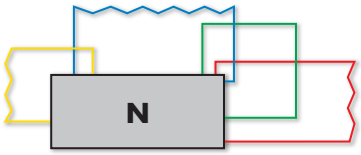
JIS II / B 0205 (old standard)

M/MF

ISO DIN 13

HSSE

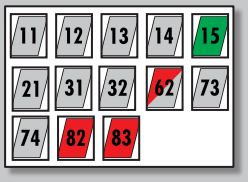


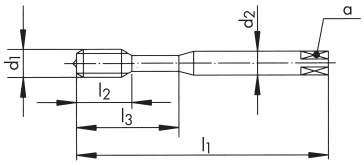


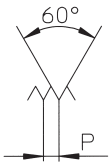
	NJS920VS-4	NJS960VS-3	NJS920VS-4	NJS960VS-3
				
	Through hole	Blind hole	Through hole	Blind hole
	B 4 x P	C 2.5 x P	B 4 x P	C 2.5 x P
	OH 3	OH 3	OH 3	OH 3

NJS920VS-4  VS

NJS960VS-3  VS







⌀ d_1 M	P mm	l_1 mm	l_2 mm	l_3 mm	d_2 mm	a mm			ID	ID	ID	ID
5	0.80	60	12.0	24	5.5	4.5	3	4.20	182410	182421		
6	1.00	62	14.0	29	6.0	4.5	3	5.00	182413	182424		
8	1.25	70	16.0		6.2	5.0	3	6.80			182415	182427
10	1.50	75	18.0		7.0	5.5	3	8.50			182417	182430

⌀ d_1 MF	P mm	l_1 mm	l_2 mm	l_3 mm	d_2 mm	a mm			ID	ID
10	1.25	75	18.0		7.0	5.5	3	8.75	182419	182433

Application Chart and Cutting Speeds

Material groups		Material designation	Hardness (HB)	Tensile strength Rm (N/mm²)	Elongation A (%)	Vc (m/min)	NJS920VS-4 	NJS960VS-3 
Steels	11	Free-cutting steels	< 200	< 700	< 10	20 - 30	√	√
	12	Structural / cementation steels	< 200	< 700	< 30	20 - 30	√	√
	13	Carbon steels	< 300	< 1000	< 20	16 - 24	√	√
	14	Alloy steels <850 N/mm²	< 250	< 850	< 30	16 - 24	√	√
	15	Alloy steels hard. / temp. >850 - <1150 N/mm²	> 250	> 850	< 30	6 - 12	√	√
	16	High tensile alloy steels	> 250	> 850	< 12			
	*	High tensile alloy steels 55 - 63 HRC	> 560	> 2000	< 10			
Stainless Steels	21	Free machining stainless steels	< 250	< 850	< 25	20 - 30	√	√
	22	Austenitic stainless steels	< 250	< 850	> 20			
	23	Ferritic and martensitic <850 N/mm²	< 250	< 850	> 20			
	24	Ferritic and martens. >850 - <1150 N/mm²	> 250	> 850	> 15			
Cast Iron	31	Cast iron	< 250	< 850	< 10	20 - 30	√	√
	32	Spheroidal graphite + malleable cast iron	< 250	< 850	> 10	20 - 30	√	√
Titanium	41	Pure titanium	< 250	< 850	> 20			
	42	Titanium alloys	> 250	> 850	< 20			
Nickel	51	Nickel alloys 1 <850 N/mm²	< 250	< 850	> 25			
	52	Nickel alloys 2 >850 - <1150 N/mm²	> 250	> 850	< 25			
	53	Nickel alloys 3 >1150 - ≤1600 N/mm²	> 340	> 1150	< 20			
Copper	61	Pure copper (electrolitic copper)	< 120	< 400	> 12			
	62	Short chip brass, phosphor bronze, gun metal	< 200	< 700	< 12	20 - 30	√	√
	63	Long chip brass	< 200	< 700	> 12			
Aluminium Magnesium	71	Al unalloyed	< 100	< 350	> 15			
	72	Al alloyed Si < 1.5 %	< 150	< 500	> 15			
	73	Al alloyed Si > 1.5 % - < 10 %	< 120	< 400	< 15	20 - 30	√	√
	74	Al alloyed Si > 10 %, Mg-Alloys	< 120	< 400	< 10	20 - 30	√	√
Plastic Compounds	81	Thermoplastics	-	-	-			
	82	Duroplastics	-	-	-	16 - 24	√	√
	83	Glass fibre reinforced plastics	-	-	-	8 - 16	√	√

√ = Optimal √ = Suitable

DC SWISS SA

CH-2735 Malleray
Tel. +41 32 491 63 63
Fax +41 32 491 64 64
E-mail: info@dcswiss.ch

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www.dcswiss.com