



Spiral Flute Tap for Aluminum Alloys

A-SFT-AL

Volume 1



KEY FEATURES: A-SFT-AL

Are you struggling with chip entanglement when machining highly ductile aluminum alloys?

- Sharp cutting performance
 - Smooth chip evacuation
 - High rigidity
- Optimized for aluminum machining



Chip entanglement is the leading cause of reduced tapping efficiency.

Issues caused by chip entanglement

Primary Problems	Resulting Tasks
● Chipping and breakage of taps ● Poor internal thread accuracy ● Scratches caused by chip friction	☒ Stopping the machine ☒ Manual chip removal by operators ☒ Reworking
Reduced work efficiency and hindered automation	

V Coating
High wear resistance

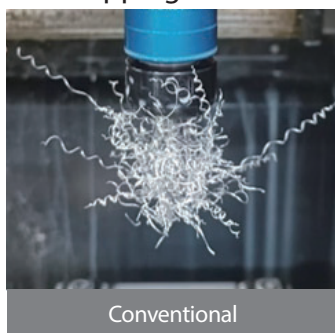
Optimal shank length
that minimizes chip
entanglement

Reduces chip removal work!

Reduces machine downtime and improves overall productivity

Work Material: A6061 Tool: M6 X 1 2,5P Cutting speed: 40m/min.
Tapping length: 12mm (2D)

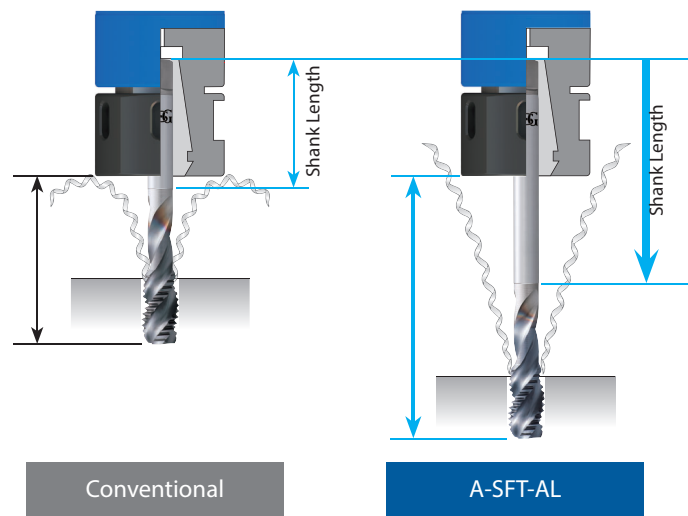
After tapping 20 holes



Uninterrupted
Machining

Smooth chip evacuation for better operational efficiency

Optimal shank length that suppresses chip entanglement



Superior chip control even on horizontal machining centers

Work Material: A5052
Tool: M6 X 1 2,5P
Tapping length: 12mm (2D)

Maintains low chip entanglement across varying cutting speeds, enabling stable, uninterrupted machining.

After tapping 20 holes

Cutting Speed	20m/min (1.061min ⁻¹)	40m/min (2.122min ⁻¹)
A-SFT-AL		
Conventional		
Competitor		

Environmental Considerations

Reducing machine stoppages improves productivity and promotes labor savings

Unstable chip evacuation is a common issue when machining aluminum alloys. The A-SFT-AL minimizes chip-related stoppages, boosting productivity and reducing labor needs. Improved efficiency also leads to lower energy use.

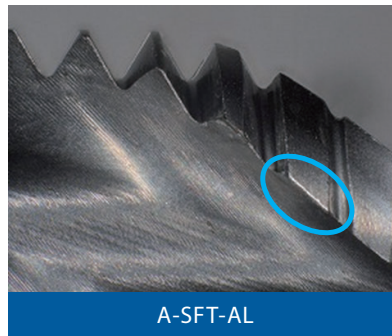


CUTTING DATA

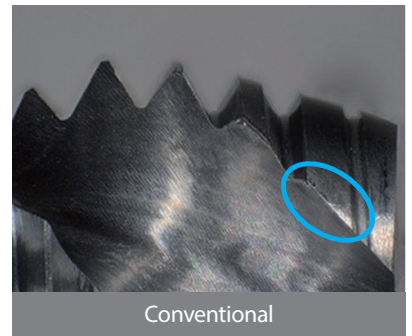
Machining A2024

Tool	A-SFT-AL M6 x 1 2,5P
Work Material	A2024
Drill Hole Size	Ø5 × 20mm (Through)
Tapping length	12 mm (2D)
Cutting Speed	40m/min (2.122min ⁻¹)
Coolant	Water Soluble Chlorine-Free (5%)
Machine	Vertical Machining Center (BT30)

Cutting edge after tapping 500 holes



A-SFT-AL

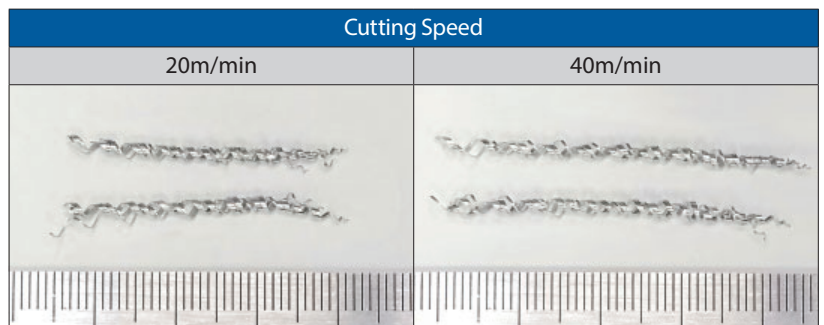


Conventional

Compared with the conventional product, wear is more uniform and overall wear is reduced.

Cutting speed and shape of chips

Tool	A-SFT-AL M6 x 1 2,5P
Work Material	A2024
Drill Hole Size	Ø5 × 20mm (Through)
Tapping length	12 mm (2D)
Coolant	Water Soluble Chlorine-Free (5%)
Machine	Vertical Machining Center (BT30)



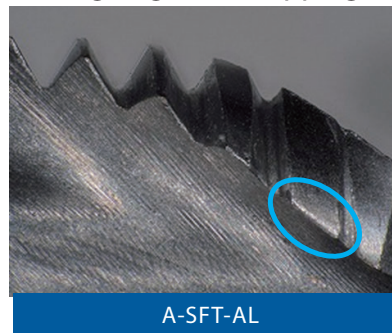
Cutting speed and shape of chips
Chip shape remains consistent even when cutting speeds change, enabling stable machining.

Threading | Cutting taps

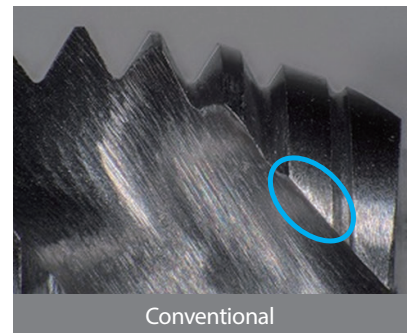
Machining A7075

Tool	A-SFT-AL M3 x 0,5 2,5P
Work Material	A7075
Drill Hole Size	Ø2,5 × 10mm (Through)
Tapping length	6 mm (2D)
Cutting Speed	40m/min (4.244min ⁻¹)
Coolant	Water Soluble Chlorine-Free (5%)
Machine	Vertical Machining Center (BT30)

Cutting edge after tapping 500 holes



A-SFT-AL



Conventional

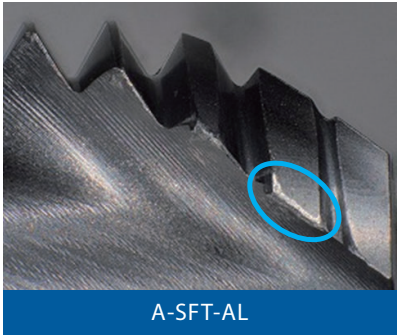
Ensures stable machining with minimal wear in high-strength wrought aluminum alloys.

Machining ADC12

Tool	A-SFT-AL M6 x 1 2,5P
Work Material	ADC12
Drill Hole Size	Ø5 x 20mm (Through)
Tapping length	12 mm (2D)
Cutting Speed	50m/min (2.653min ⁻¹)
Coolant	Water Soluble Chlorine-Free (5%)
Machine	Vertical Machining Center (BT30)

Delivers favorable wear progression even in aluminum die-cast materials that typically experience rapid tool wear.

Cutting edge after tapping 500 holes

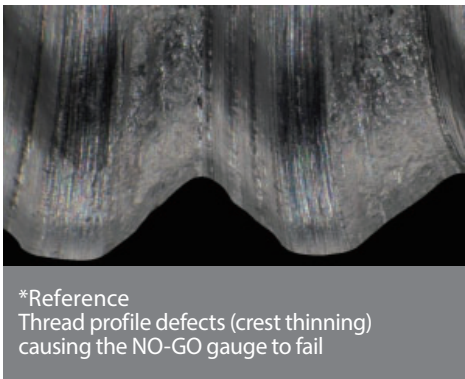
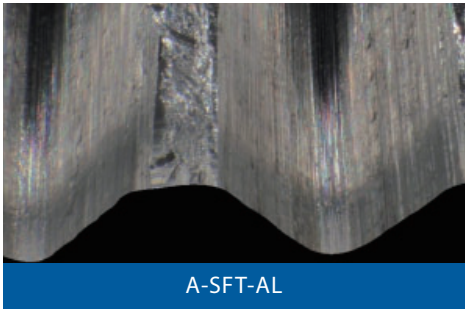


Machining A5052 using a floating tap holder

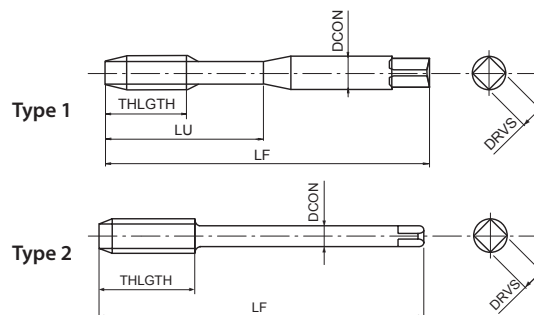
Tool	A-SFT-AL M6 x 1 2,5P
Work Material	A5052
Drill Hole Size	Ø5 x 20mm (Through)
Tapping length	12 mm (2D)
Cutting Speed	10m/min (531min ⁻¹)
Holder	Floating Holder
Coolant	Water Soluble Chlorine-Free (5%)
Machine	Vertical Machining Center (BT30)

The A-SFT-AL produces high-quality thread profiles that pass gauge inspection, even when using a floating tap holder, regardless of the machine tool.

Thread Profile



Threading | Cutting taps | Metric



- First choice in quality and performance
- HSSE spiral-fluted cutting tap for blind holes
- Multilayer TiCN coating
- High speed tapping in aluminium cast and aluminium die cast

Metric

**HSSE**

ISO 2
6HX

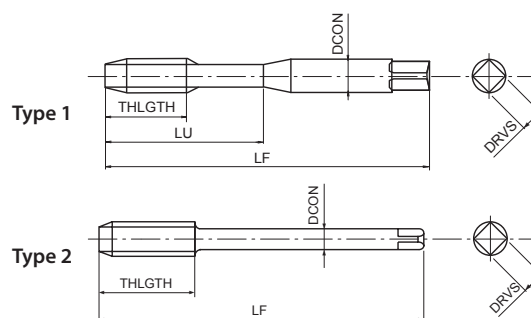


DIN 371

DIN 376

[illegible]

Threading | Cutting taps | Metric



- N** 
AC, ADC

5-30

m/min



M

HSSE

V

45°

ISO 2
6HX

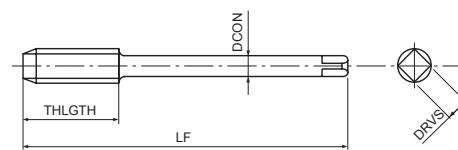
E/15

DIN 371

DIN 376

[illegible]

Threading | Cutting taps | Metric Fine

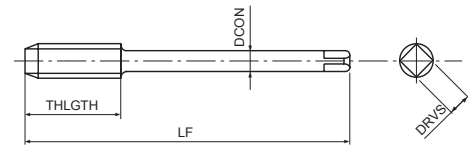


- First choice in quality and performance
- HSSE spiral-fluted cutting tap for blind holes
- Multilayer TiCN coating
- High speed tapping in aluminium cast and aluminium die cast

Metric Fine

[illegible]

Threading | Cutting taps | Metric Fine



- N** 
AC, ADC

5-30

m/min



MF

HSSE

V

45°

**ISO 2
6HX**

E/1,5

DIN 374

[illegible]

SWEDEN

Branch office of OSG SCANDINAVIA
Singelgatan 7
212 28 Malmö
Sweden
Tel: +46 40 41 22 55
osg@osg-scandinavia.com

OSG SCANDINAVIA

(For Scandinavian countries)
Langebjergvaenget 16
4000 Roskilde
Denmark
Tel: +45 46 75 65 55
osg@osg-scandinavia.com

OSG NETHERLANDS

Bedrijfsweg 5
3481 MG Harmelen
The Netherlands
Tel: +31 348 44 2764
info@osg-nl.com

OSG UK

Kelsey Close, Attleborough Fields Ind Est,
CV11 6RS, Nuneaton
United Kingdom
Tel: +44 (0) 1827 720 013
uk_sales@osg-uk.com

OSG EUROPE LOGISTICS

Avenue Lavoisier 1
B-1300 Z.I. Wavre - Nord
Belgium
Tel: +32 10 23 05 07
info@osgeurope.com

OSG BELUX

Avenue Lavoisier 1
B-1300 Z.I. Wavre - Nord
Belgium
Tel: +32 10 23 05 11
info@osg-belgium.com

OSG IBÉRICA

Bekolarra 4
E - 01010 Vitoria-Gasteiz
Spain
Tel: +34 945 242 400
osg.iberica@osg-ib.com

OSG FRANCE

Parc Icade, Paris Nord 2
Immeuble "Le Rimbaud"
22 Avenue des Nations
CS66191 - 93420 Villepinte
France
Tel: +33 1 49 90 10 10
sales@osg-france.com

OSG ITALY

Via Ferrero, 65 A/B
I - 10098 Rivoli
Italy
Tel: +39 0117705211
info@osg-italia.it



OSG IN EUROPE

CZECH REPUBLIC, SLOVAKIA, HUNGARY

OSG Europe Logistics S.A.
Slovakia, organizačná zložka
Račianska 22/A, Bratislava 831 02
Slovakia
Tel.: +421 24 32 91 295
info@osgeurope.com

OSG POLAND

ul. Spółdzielcza 57
05-074 Halinów
Polska
Tel: +22 760 82 71
Mob. +48 570 677 711
osg@osg-poland.com

OSG ROMANIA SRL

25C, Bucuresti-Magurele Street (Sector 5)
051431 Bucuresti
România
Tel: +40 21 322 07 47
info@osgromania.ro

OSG TURKEY

Rami Kışla Cad.No:56 Eyüp
İstanbul 34056
Turkey
Tel: +90 212 565 24 00
Fax: +90 212 565 44 00
info@osg-turkey.com

Vischer & Bolli AG

Machining and Workholding
Im Schossacher 17
CH-8600 Dübendorf
Switzerland
Tel.: +41 44 802 15 15
info@vb-tools.com

OSG GERMANY

Karl-Ehmann-Str. 25
D - 73037 Göppingen
Germany
Tel: +49 7161 6064 - 0
Fax: +49 7161 6064 - 444
info@osg-germany.de



shaping your dreams

OSG EUROPE LOGISTICS

Avenue Lavoisier 1
B-1300 Z.I. Wavre - Nord - Belgium
Tel: +32 10 23 05 07
info@osgeurope.com

OSG POLAND Sp. z o.o.

Spółdzielcza 57
05-074 Halinów - Poland
Tel: +22 760 82 71
osg@osg-poland.com

OSG ROMANIA SRL

25C, Bucuresti-Magurele Street (Sector 5)
051431 Bucuresti - România
Tel: +40 21 322 07 47
info@osgromania.ro

OSG BELUX

Avenue Lavoisier 1
B-1300 Z.I. Wavre - Nord - Belgium
Tel: +32 10 23 05 11
info@osg-belgium.com

OSG GERMANY

Karl-Ehmann-Str. 25
D - 73037 Göppingen - Germany
Tel: +49 7161 6064 - 0
Fax: +49 7161 6064 - 444
info@osg-germany.de

AUSTRIA

Branch office of OSG GERMANY
Messestraße 11
A-6850 Dornbirn
Tel: +49 7161 6064-0
info@osg-germany.de

OSG FRANCE

Parc Icade, Paris Nord 2
Immeuble "Le Rimbaud"
22 Avenue des Nations
CS66191 - 93420 Villepinte - France
Tel: +33 1 49 90 10 10
sales@osg-france.com

OSG SCANDINAVIA

(For Scandinavian countries)
Langebjergvaenget 16
4000 Roskilde - Denmark
Tel: +45 46 75 65 55
osg@osg-scandinavia.com

OSG ITALIA

Via Ferrero, 65 A/B3
I - 10098 Rivoli - Italy
Tel: +39 0117705211
info@osg-italia.it

OSG NETHERLANDS

Bedrijfsweg 5 - 3481 MG Harmelen
Tel: +31 348 44 2764
info@osg-nl.com

SWEDEN

Branch office of OSG SCANDINAVIA
Singelgatan 7
212 28 Malmö - Sweden
Tel: +46 40 41 22 55
osg@osg-scandinavia.com

Vischer & Bolli AG

Machining and Workholding
Im Schossacher 17
CH-8600 Dübendorf
T +41 44 802 15 15
info@vb-tools.com

OSG UK

Kelsey Close, Attleborough Fields Ind Est,
CV11 6RS, Nuneaton, United Kingdom.
Tel: +44 1827 720 013
uk_sales@osg-uk.com

OSG IBERICA

Bekolarra 4
E - 01010 Vitoria-Gasteiz - Spain
Tel: +34 945 242 400
osg.iberica@osg-ib.com

CZECH, SLOVAKIA, HUNGARY

OSG Europe Logistics S.A.
Slovakia organizacna zlozka
Racianská 22/A, SK-83102 Bratislava
Slovakia
Tel. +421 24 32 91 295
Orders-osgsvk@osgeurope.com

OSG TURKEY

Rami Kışla Cad.No:56 Eyüp
Istanbul 34056 - Turkey
Tel+90 212 565 24 00
Fax: +90 212 565 44 00
info@osg-turkey.com

OSG EUROPE LOGISTICS S.A.

08/2026 - All rights reserved. © OSG Europe 2026

The contents of this catalogue are provided to you for viewing only. They are not intended for reproduction either in part or in whole in this or other medium. They cannot be copied, used to create derivation work or used for any reason, by means without the express, written permission of the copyright owner. If prices are stated, they are netto unit-prices and any eventual tax(es) have to be added. The company is not responsible for any printing error in technical, price and/or any other data.

Tool specifications subject to change without notice.

www.osgeurope.com