



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

threading





[dcswiss.com](https://dcswiss.com)

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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



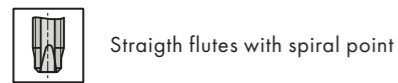
For Rigid Tapping



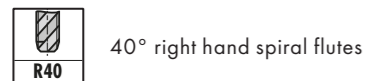
HSSE-PM



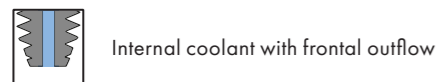
HSSE



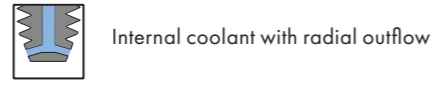
Straight flutes with spiral point



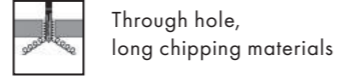
40° right hand spiral flutes



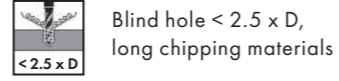
Internal coolant with frontal outflow



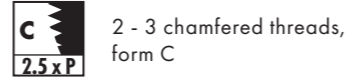
Internal coolant with radial outflow



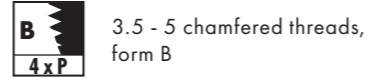
Through hole,  
long chipping materials



Blind hole < 2.5 x 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**

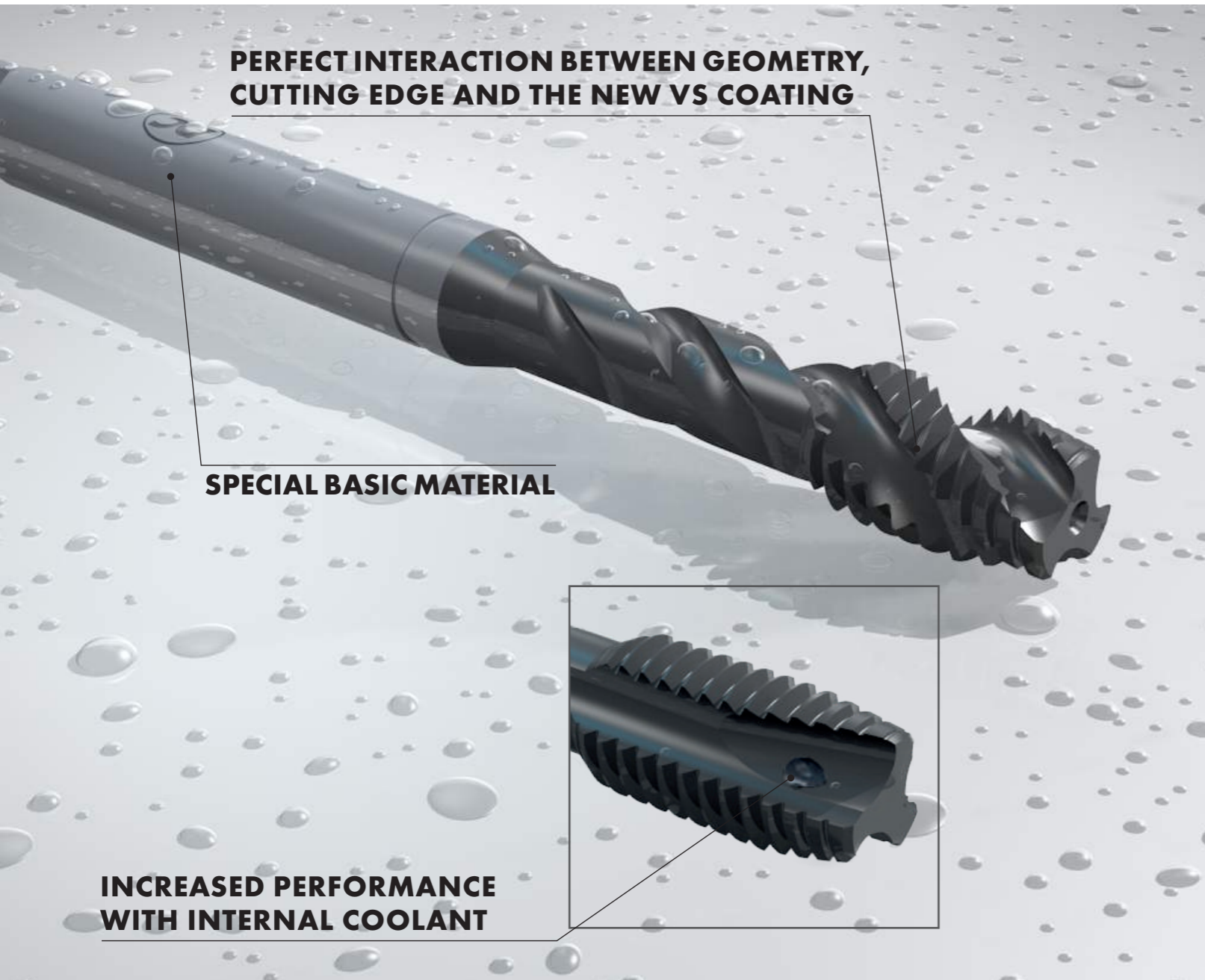
**UNIVERSALITY**

&

**PERFORMANCE**



# DC FEATURES



**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.**



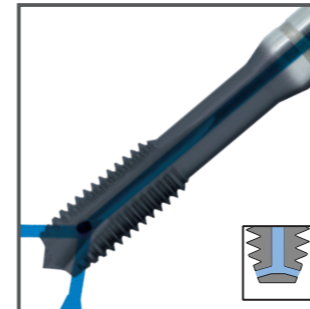
**DISCOVER OUR YOUTUBE VIDEO**

## Q20VS



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

## Q23VS



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

## Q60VS



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

## Q65VS



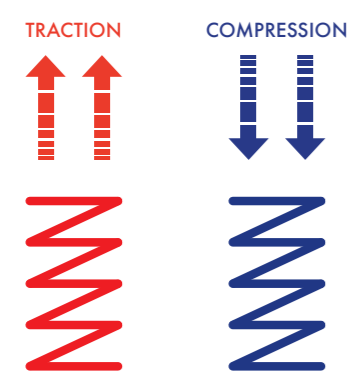
FOR BLIND HOLES  
SPIRAL FLUTES  
GEOMETRY AND CUTTING EDGE OPTIMISED  
VS-COATING  
CENTRAL INTERNAL COOLANT WITH FRONTAL OUTFLOW

# DC TAPPING CHUCK SCT AND SST

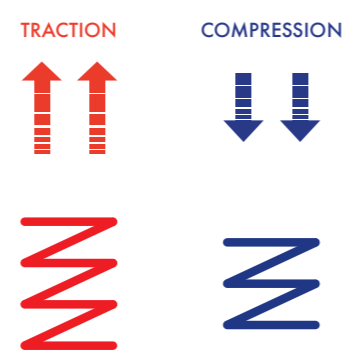


works perfectly with our SCT (conventional tapping chuck) as well as with our new SST (Synchro Tapping Chuck)

**SCT**  
CONVENTIONAL  
TAPPING CHUCK



**NEW**  
**SST**  
SYNCHRO  
TAPPING CHUCK



COOLANT THROUGH  
UP TO 50 BAR

**NEW**  
**SST**  
SYNCHRO  
TAPPING CHUCK



**QUICK CHANGE**

- MODULARITY
- FLEXIBILITY
- COST SAVING

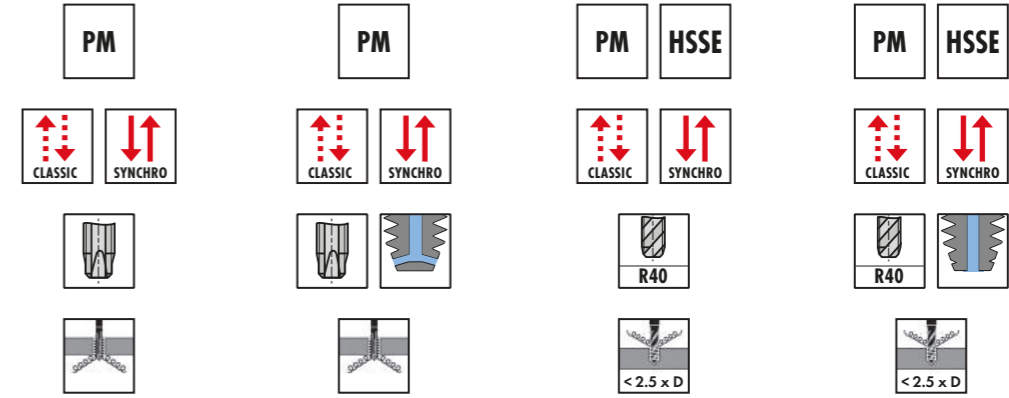
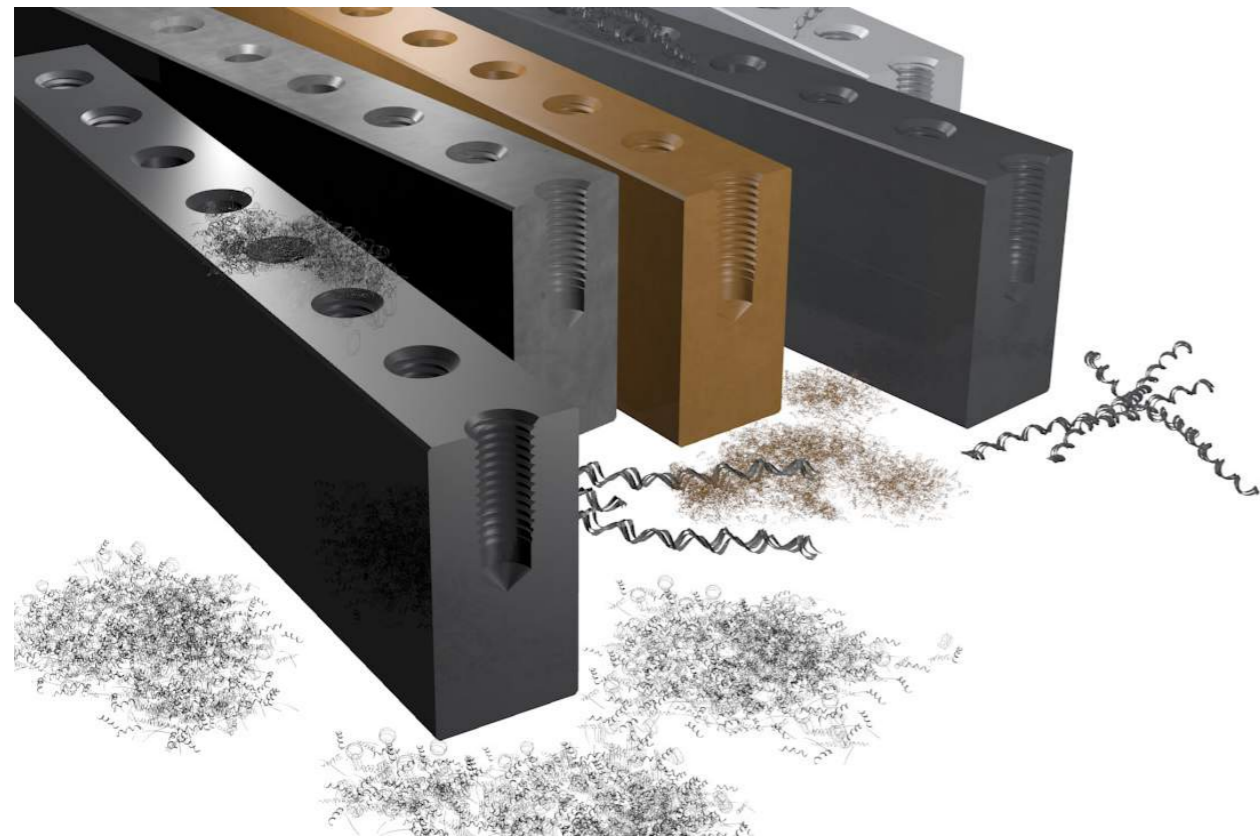


Available from April 2019



# APPLICATIONS

## QTAP



Q20VS		Q23VS		Q60VS		Q65VS	
<b>Q320VS-4</b>	<b>Q420VS-4</b>	<b>Q323VS-4</b>	<b>Q423VS-4</b>	<b>Q360VS-3</b>	<b>Q460VS-3</b>	<b>Q365VS-3</b>	<b>Q465VS-3</b>
VS							
Vc (mm/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

### MATERIAL GROUPS

### MATERIAL DESIGNATIONS

MATERIAL GROUPS	MATERIAL DESIGNATIONS
STEELS	11 FREE-CUTTING STEELS
	12 STRUCTURAL / CEMENTATION STEELS
	13 CARBON STEELS
	14 ALLOY STEELS <850 N/mm <sup>2</sup>
	15 ALLOY STEELS HARD. / TEMP. >850 - <1150 N/mm <sup>2</sup>
STAINLESS STEELS	21 FREE MACHINING STAINLESS STEELS
	22 AUSTENITIC STAINLESS STEELS
	23 FERRITIC AND MARTENSITIC <850 N/mm <sup>2</sup>
	24 FERRITIC AND MARTENSITIC >850 - <1150 N/mm <sup>2</sup>
CAST IRON	31 CAST IRON
	32 SPHEROIDAL GRAPHITE + MALLEABLE CAST IRON
NICKEL	51 NICKEL ALLOYS 1 <850 N/mm <sup>2</sup>
	52 NICKEL ALLOYS 2 >850 - <1150 N/mm <sup>2</sup>
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

The above mentioned information is not binding



# DC THREAD CUTTING – QTAP

PM

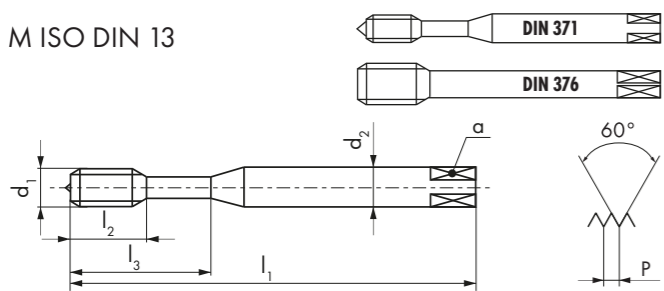
**Q320VS-4**

**Q420VS-4**

VS

VS

M ISO DIN 13



**Q320VS-4 Q420VS-4**

ID

M	d <sub>1</sub>	Ød <sub>1</sub> mm	P mm	l <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>3</sub> mm	d <sub>2</sub> mm	a mm		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

# DC THREAD CUTTING – QTAP

≤ Ø 16 > Ø 16

PM HSSE

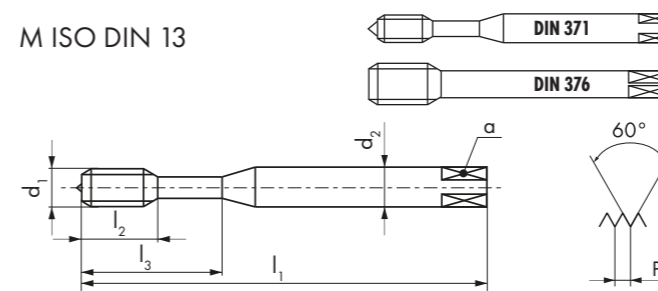
**Q360VS-3**

**Q460VS-3**

VS

VS

M ISO DIN 13



**Q360VS-3 Q460VS-3**

ID

M	d <sub>1</sub>	Ød <sub>1</sub> mm	P mm	l <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>3</sub> mm	d <sub>2</sub> mm	a mm		6H	6H
M3	3.0	0.50	56	5.5	18	3.5	2.7	3	2.50	●	195516
M4	4.0	0.70	63	7.5	21	4.5	3.4	3	3.30	●	195517
M5	5.0	0.80	70	9.0	25	6.0	4.9	3	4.20	●	195518
M6	6.0	1.00	80	11.0	30	6.0	4.9	3	5.00	●	195519
M8	8.0	1.25	90	12.5	35	8.0	6.2	3	6.80	●	195520
M10	10.0	1.50	100	14.0	39	10.0	8.0	3	8.50	●	195521
M12	12.0	1.75	110	14.0		9.0	7.0	3	10.20		● 195522
M14	14.0	2.00	110	14.0		11.0	9.0	3	12.00		● 195523
M16	16.0	2.00	110	18.0		12.0	9.0	3	14.00		● 195524
M20	20.0	2.50	140	24.0		16.0	12.0	3	17.50		● 195525
M24	24.0	3.00	160	27.0		18.0	14.5	4	21.00		● 195526

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



PM

**Q323VS-4**

**Q423VS-4**

VS

VS

≤∅ 16 >∅ 16

PM HSSE

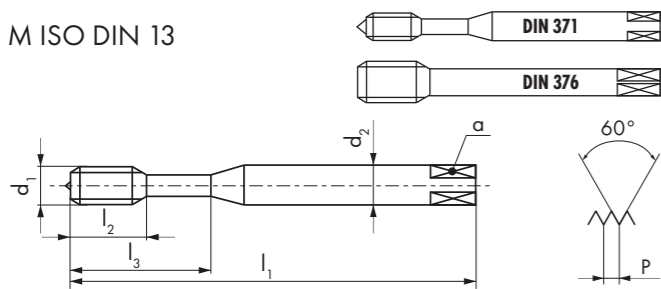
**Q365VS-3**

**Q465VS-3**

VS

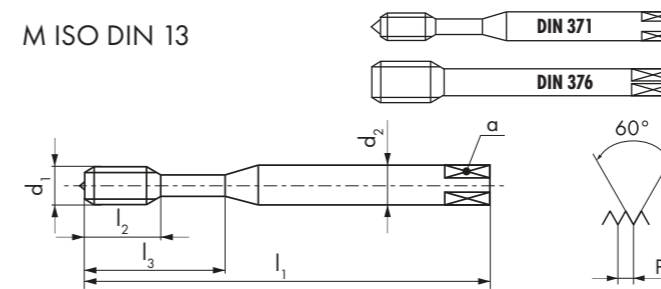
VS

M ISO DIN 13



		Q323VS-4		Q423VS-4			
				ID			
M		6H	6H	6H	6H		
M3							
M4							
M5							
M6							
M8							
M10							
M12							
M14							
M16							
M20							
M24							

M ISO DIN 13



		Q365VS-3		Q465VS-3			
				ID			
M		6H	6H	6H	6H		
M3							
M4							
M5							
M6							
M8							
M10							
M12							
M14							
M16							
M20							
M24							

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



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