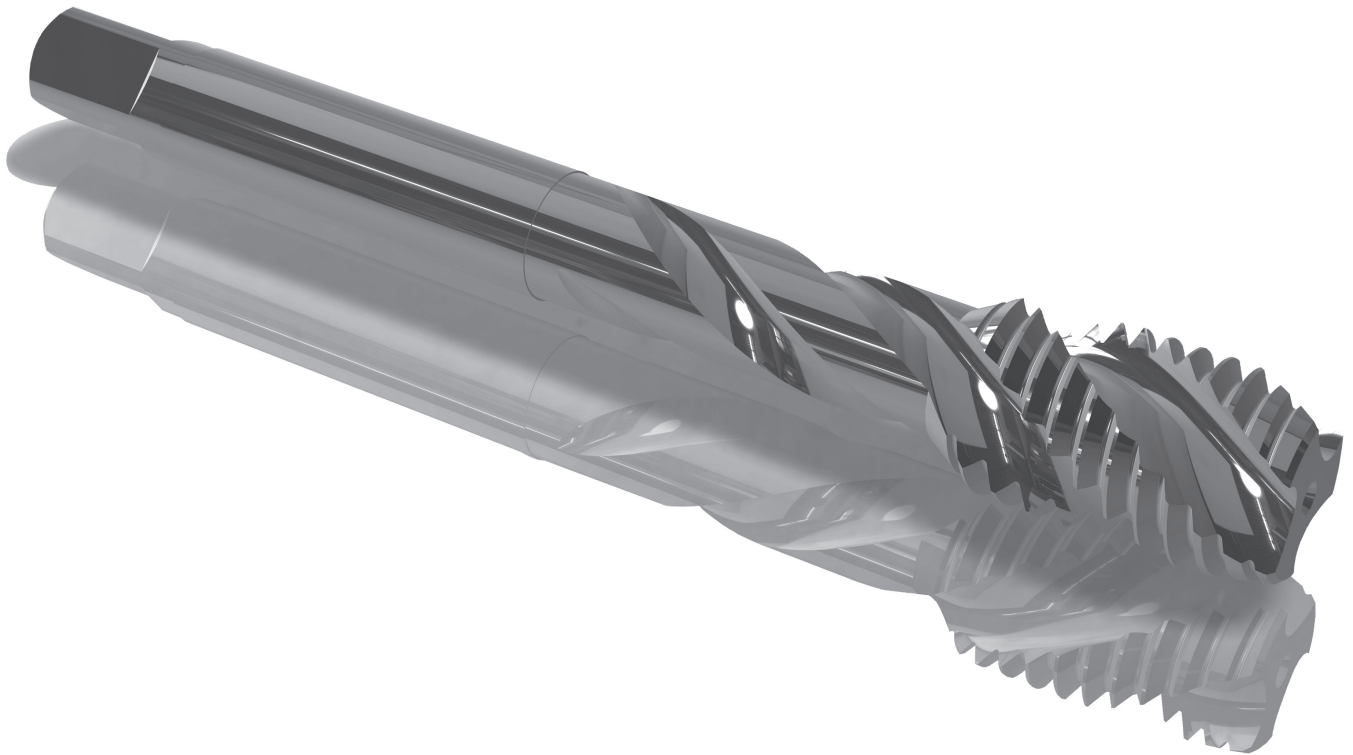


JIS

TAP STANDARD



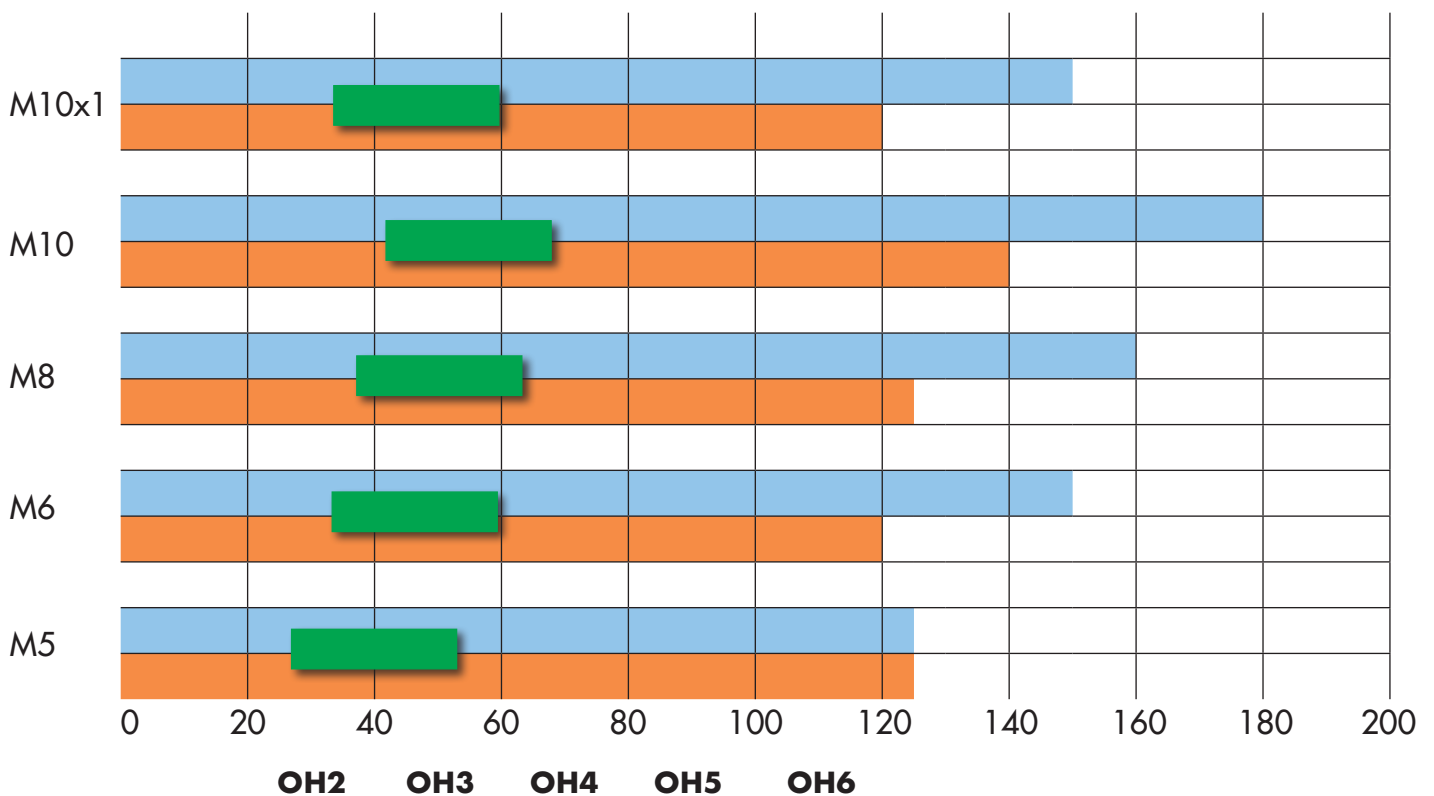
THREADING

TECHNOLOGY

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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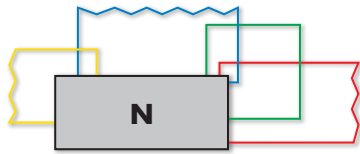
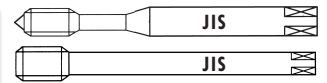
JIS TOLERANCES



M/MF

ISO DIN 13

HSSE



NJS920VS-4



NJS960VS-3



11	12	13	14	15
21	31	32	62	73
74	82	83		

NJS920VS-4

NJS960VS-3

NJS920VS-4

NJS960VS-3



Through hole



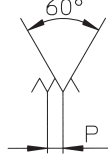
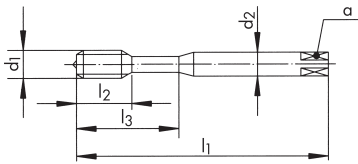
Blind hole



Through hole



Blind hole



$\varnothing d_1$	P	l_1	l_2	l_3	d_2	α		
M	mm	mm	mm	mm	mm	mm		
5	0.80	60	12.0	24	5.5	4.5	3	4.20
6	1.00	62	14.0	29	6.0	4.5	3	5.00
8	1.25	70	16.0		6.2	5.0	3	6.80
10	1.50	75	18.0		7.0	5.5	3	8.50

ID

ID

ID

ID

182410

182421

182413

182424

182415

182427

182417

182430

$\varnothing d_1$	P	l_1	l_2	l_3	d_2	α		
MF	mm	mm	mm	mm	mm	mm		
10	1.25	75	18.0		7.0	5.5	3	8.75



ID

ID

182419

182433

Application Chart and Cutting Speeds

Material groups		Material designation	Hardness (HB)	Tensile strength Rm (N/mm ²)	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/mm ²	< 250	< 850	< 30	16 - 24	✓	✓
	15	Alloy steels hard. / temp. >850 - <1150 N/mm ²	> 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/mm ²	< 250	< 850	> 20			
	24	Ferritic and martens. >850 - <1150 N/mm ²	> 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/mm ²	< 250	< 850	> 25			
	52	Nickel alloys 2 >850 - <1150 N/mm ²	> 250	> 850	< 25			
	53	Nickel alloys 3 >1150 - ≤1600 N/mm ²	> 340	> 1150	< 20			
Copper	61	Pure copper (electrolytic 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

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