shaping your dreams

ONE-SFT

고능율·다기능탭

Highly Efficient·Multi-Purpose Tap Series

DIN-TYPE

획기적인 성능개선

가성비 NUMBER 1

Outstanding productivity with
cost-effective performance

한국OSG주식회사
OSG KOREA Corporation

Vol.1 (2025. 8)

ONE-SFT 제품 특징

ONE-SFT Product Features

다양한 가공 조건에서 사용 Usable in Various Machining Conditions

- 연강에서 합금강까지 **폭 넓은 피삭재**에 사용
  Applicable to a wide range of materials from mild steel to alloy steel
- **다양한 가공 장비**에서 사용 (레이디얼 드릴링 머신, 머시닝 센터 등)
  Compatible with various machining equipment (Radial drilling machines, Machining centers, etc.)

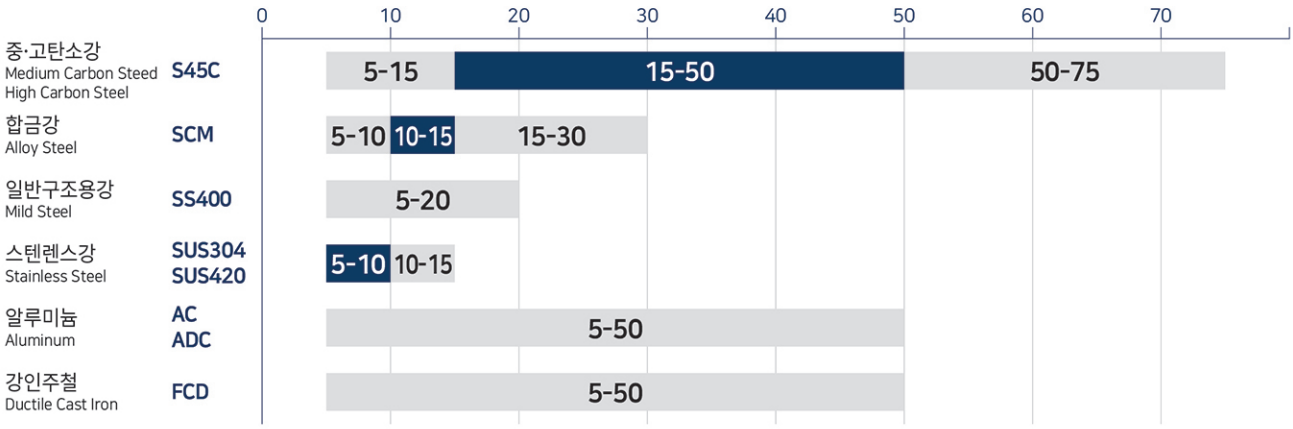
인성과 내마모성 향상 Improved Durability and Wear Resistance

- **분말하이스 재질** 및 표면조도가 우수한 **다층 구조의 "HP" 코팅** 적용
  Application of multi-layer "HP" coating with excellent powder high-speed steel material and surface finish
- **암나사 조도 개선** 및 품질 향상
  Improved tool edge sharpness and product quality

가공성이 우수한 홈형상 Excellent Machinability with Optimized Flute Design

- 폭 넓은 피삭재에서 **탁월한 Chip 배출성**
  Excellent chip evacuation in a wide range of materials
- 태핑 깊이가 2D 이상의 **깊은 구멍 가공** 가능
  Capable of deep hole machining with a tapping depth of over 2D
- 절삭속도 UP 가능으로 **가공시간 단축**
  Increased cutting speed allows for reduced machining time

ONE-SFT 절삭 조건 Cutting Conditions



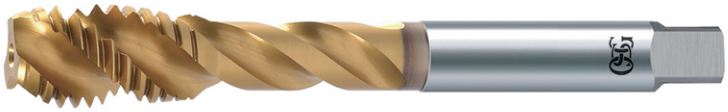
ONE-SFT 적용 피삭재질 Applied Work Material

저탄소강 Low Carbon Steels	중탄소강 Medium Carbon Steels	고탄소강 High Carbon Steels	합금강 Alloy Steels	조질강 Hardenned Steels			스테인레스강 Stainess Steels	공구강 Tool Steels	주강 Cast Steels	주철 Cast Iron	강인주철 High Tension Cast Iron
C~0.25%	C 0.25% ~0.45%	C 0.45%~	SCM	25~45 HRC	45~55 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD
○	◎	◎	○	○			○	○	○		○

동 Copper	황동 Brass	황동주물 Brass Casting	청동 Bronze	알루미늄 압조재 Aluminum Rolled	알루미늄 합금주물 Aluminum Alloy Casti	마그네슘 합금주물 Magnesium Alloy Casting	아연 합금주물 Zinc Alloy Casting	티탄합금 Titanium Alloys	Ni기합금 Nickel Alloys	열경화성 플라스틱 Thermo Sstting Plastic	열가소성 플라스틱 Thermo Plastic
Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
○	○	○	○	○	◎	○	○				

ONE-SFT 형상 정보

Shape Information



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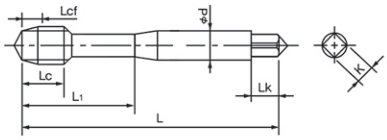

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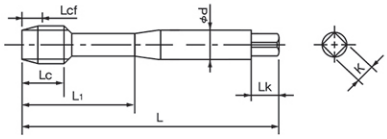

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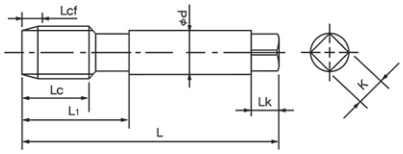
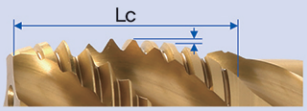




ONE-SFT 형상 Key Point !

완전산부 테이퍼 연삭으로 치핑 방지

Chipping Suppression Shape

CPM HP 45° Lcf/2.5p 6HX DIN 371 DIN 376 DIN 374

EDP NO.	규격 Thread Size	전장 L	나사길이 Lc	목부길이 L1	생크경 Ød	사각부 폭 K	사각부 길이 LK	형상 TYPE	DIN TYPE
OS03050D	M 3X0.5	56	4	18	3.5	2.7	6	1	DIN371
OS04070D	M 4X0.7	63	5.6	21	4.5	3.4	6	1	DIN371
OS05080D	M 5X0.8	70	6.4	25	6	4.9	8	1	DIN371
OS06100D	M 6X1.0	80	8	30	6	4.9	8	1	DIN371
OS08125D	M 8X1.25	90	15	35	8	6.2	9	2	DIN371
OS10150D	M10X1.5	100	18	39	10	8	11	2	DIN371
OS10125D	M10X1.25	100	15	39	10	8	11	2	DIN371
OS12175D	M12X1.75	110	21	48	9	7	10	3	DIN376
OS12150D	M12X1.5	100	18	48	9	7	10	3	DIN374
OS12125D	M12X1.25	100	18	48	9	7	10	3	DIN374
OS14200D	M14X2.0	110	24	48	11	9	12	3	DIN376
OS14150D	M14X1.5	100	18	48	11	9	12	3	DIN374
OS16200D	M16X2.0	110	24	52	12	9	12	3	DIN376
OS16150D	M16X1.5	100	18	52	12	9	12	3	DIN374
OS18250D	M18X2.5	125	30	55	14	11	14	3	DIN376
OS18150D	M18X1.5	110	24	55	14	11	14	3	DIN374
OS20250D	M20X2.5	140	30	58	16	12	15	3	DIN376
OS20150D	M20X1.5	125	24	58	16	12	15	3	DIN374
OS22250D	M22X2.5	140	30	63	18	14.5	17	3	DIN376
OS22150D	M22X1.5	125	24	63	18	14.5	17	3	DIN374
OS24300D	M24X3.0	160	36	66	18	14.5	17	3	DIN376
OS24150D	M24X1.5	140	24	66	18	14.5	17	3	DIN374

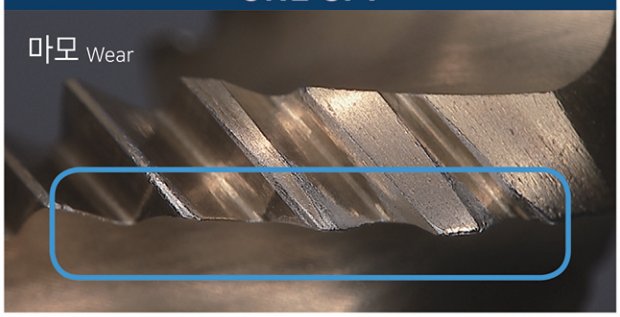
ONE-SFT 가공 DATA

Cutting Data for ONE-SFT

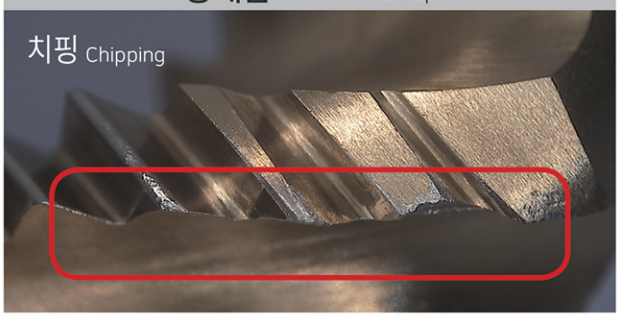
공구 TOOL	장비 Machine	절삭속도 Cutting Speed	이송속도 Feed	피삭재 Work Material	태핑깊이 Tapping Length	드릴경 Drill Hole Size	절삭유 Coolant
ONE-SFT M6X1	수직 Vertical M/C	20m/min	1,060 mm/min	S45C (HRC 5~8)	1.5D (막힘 Blind)	Ø5.0	수용성 Water Soluble 10%

2,256홀 가공후 탭 마모 비교 Chamfer wear after tapping 2,256 hole

ONE-SFT

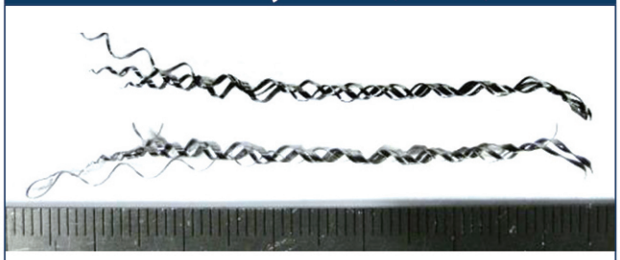


종래품 Conventional Tap



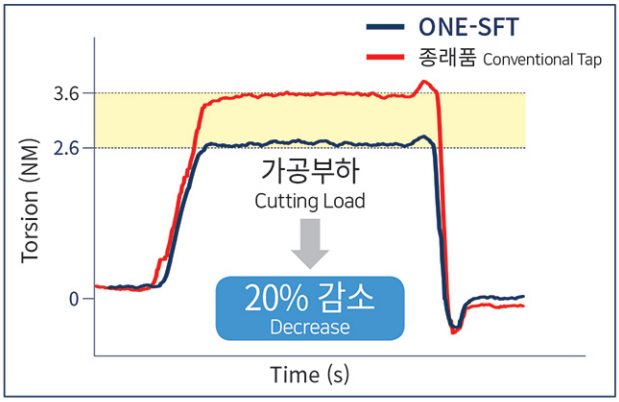
절삭Chip 형상 Shape of chips

ONE-SFT, M6X1 (S45C)



균일한 칩 Curl 및 칩 길이
Uniform Chip Curl And Chip Length

가공 부하 Cutting Load



한국OSG주식회사
OSG KOREA Corporation

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호산공장 및 기술연구소 대구광역시 달서구 호산동로 138 (호산동)
TEL.(053)588-2288 FAX.(053)580-2059

갈산1공장 대구광역시 달서구 성서공단로 125 (갈산동)
TEL.(053)583-2000 FAX.(053)589-1839

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