

HSSE-V3 SPIRAL POINT TAPS METRIC-BLUE RING



Designed for high-speed tapping applications. Developed to withstand the high stress and high heat associated with high-speed CNC production tapping. Features a unique free-cutting design with a special tempering and geometry which contributes to extra tool life.

- Used in general machine tapping applications for mild carbon steels such as 1018, 1010, 1035, 1045, 1050 and 1065
- Up to 25 HRC

• **4.5 PITCH LEAD (INTERMEDIATE)**

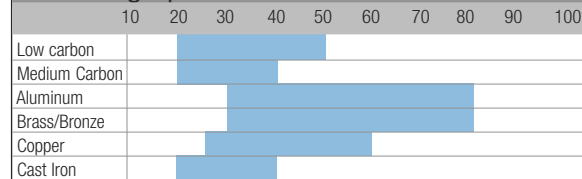
HSSE-V3 SPIRAL POINT TAPS METRIC SIZES

Nominal Size and Pitch	No. Flutes	Thread Limits	O/A Length (in)	Thread Length (in)	Code No.	Price \$
M2 x .4	2	D3	1-3/4	.433	119-750	9.10
M2.5 x .45	2	D3	1-13/16	.512	119-751	9.10
M3 x .5	3	D3	1-15/16	.433	119-752	8.10
M3.5 x .6	3	D4	2	.512	119-753	8.10
M4 x .7	3	D4	2-1/8	.512	119-754	8.60
M4.5 x .75	3	D4	2-3/8	.512	119-755	8.60
M5 x .8	3	D4	2-3/8	.512	119-756	8.60
M6 x 1	3	D5	2-1/2	.630	119-757	9.60
M7 x 1	3	D5	2-23/32	.630	119-758	11.50
M8 x 1	3	D5	2-23/32	.748	119-759	11.50
M8 x 1.25	3	D5	2-23/32	.748	119-760	11.50
M10 x 1.25	3	D5	2-15/16	.748	119-761	13.20
M10 x 1.5	3	D6	2-15/16	.748	119-762	13.20
M12 x 1.25	3	D5	3-3/8	.945	119-763	19.20
M12 x 1.75	3	D6	3-3/8	.945	119-764	19.20
M14 x 1.5	3	D6	3-19/32	.984	119-765	25.40
M14 x 2	3	D7	3-19/32	.984	119-766	25.40
M16 x 1.5	3	D6	3-13/16	1.102	119-767	30.00
M16 x 2	3	D7	3-13/16	1.102	119-768	30.00
M18 x 1.5	3	D6	4-1/32	1.102	119-769	50.00
M18 x 2.5	3	D7	4-1/32	1.102	119-770	50.00
M20 x 1.5	3	D5	4-15/32	1.220	119-771	58.30
M20 x 2.5	3	D6	4-15/32	1.220	119-772	58.30
M22 x 1.5	3	D6	4-11/16	1.339	119-773	66.50
M22 x 2.5	3	D6	4-11/16	1.339	119-774	66.50
M24 x 1.5	3	D5	4-29/32	1.339	119-775	89.30
M24 x 3	3	D7	4-29/32	1.339	119-776	89.30
M27 x 1.5	4	D7	5-1/8	1.181	119-777	126.50
M27 x 3	4	D7	5-1/8	1.181	119-778	126.50
M30 x 1.5	4	D7	5-7/16	1.378	119-779	147.30
M30 x 3.5	4	D7	5-7/16	1.378	119-780	147.30

cutting conditions

Materials				Hardness (HRC)	Cutting Speed (FPM)
Main Group	Sub-Group	Condition			
Low carbon	1018, 1010, 1035	Normalized	<25		20-50
Medium carbon	1045, 1050, 1065	Normalized	<25		20-40
Aluminum	Unalloyed, cast	—	—		30-80
Brass/bronze	—	—	—		30-80
Copper	—	—	—		25-60
Cast iron	—	As cast	<15		20-40

cutting speed (fpm)



hardness (hrc)

