

HSSE-V3 SPIRAL FLUTE 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

• 2.5 PITCH LEAD (BOTTOMING)

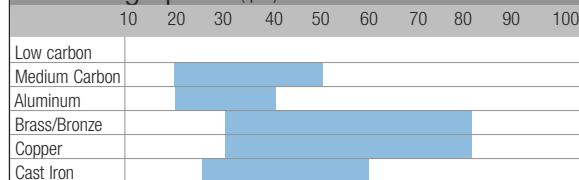
HSSE-V3 SPIRAL FLUTE TAPS METRIC SIZES

Nominal Size and Pitch	No. Flutes	Thread Limits	O/A Length (in)	Thread Length (in)	Code No.	Price \$
M3 x .5	3	D3	1-15/16	.433	119-840	9.10
M3.5 x .6	3	D4	2	.512	119-841	9.10
M4 x .7	3	D4	2-1/8	.512	119-842	9.10
M5 x .8	3	D4	2-3/8	.512	119-843	9.60
M6 x 1	3	D5	2-1/2	.630	119-844	9.80
M7 x 1	3	D5	2-23/32	.630	119-845	12.80
M8 x 1	3	D5	2-23/32	.748	119-846	12.80
M8 x 1.25	3	D5	2-23/32	.748	119-847	12.80
M10 x 1.25	3	D5	2-15/16	.748	119-848	15.00
M10 x 1.5	3	D6	2-15/16	.748	119-849	15.00
M12 x 1.25	3	D5	3-3/8	.945	119-850	25.60
M12 x 1.75	3	D6	3-3/8	.945	119-851	25.60
M14 x 1.5	3	D6	3-19/32	.984	119-852	29.80
M14 x 2	3	D7	3-19/32	.984	119-853	29.80
M16 x 1.5	3	D6	3-13/16	1.102	119-854	32.40
M16 x 2	3	D7	3-13/16	1.102	119-855	32.40
M18 x 1.5	4	D6	4-1/32	1.102	119-856	55.40
M18 x 2.5	4	D7	4-1/32	1.102	119-857	55.40
M20 x 1.5	4	D5	4-15/32	1.220	119-858	64.80
M20 x 2.5	4	D6	4-15/32	1.220	119-859	64.80
M22 x 1.5	4	D6	4-11/16	1.339	119-860	74.10
M22 x 2.5	4	D6	4-11/16	1.339	119-861	74.10
M24 x 1.5	4	D5	4-29/32	1.339	119-862	100.10
M24 x 3	4	D7	4-29/32	1.339	119-863	100.10
M27 x 1.5	4	D7	5-1/8	1.181	119-864	126.50
M27 x 3	4	D7	5-1/8	1.181	119-865	126.50
M30 x 1.5	4	D7	5-7/16	1.378	119-866	147.30
M30 x 3.5	4	D7	5-7/16	1.378	119-867	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)

