

HSSE-V3 – PVD, TIN COATED SPIRAL POINT 1/2" INCH-BLUE RING



BLUE GOLD TITANIUM NITRIDE

Taps can provide an increase in tool life of 2 to 6 times depending on the application.

The extremely hard and durable surface and high lubricity delivers long tool life, reduces friction and galling allowing higher speeds for higher productivity and less down time.

- 4.5 PITCH LEAD (INTERMEDIATE)

■ HSSE-V3 SPIRAL POINT TAPS INCH						
Nominal Size and Pitch	No. Flutes	Thread Limits	O/A Length (in)	Thread Length (in)	Code No.	Price \$
NC						
4-40	2	H2	1-7/8	.433	119-870	16.20
6-32	3	H3	2	.512	119-871	15.20
8-32	3	H3	2-1/8	.512	119-872	15.70
10-24	3	H3	2-3/8	.512	119-873	16.50
1/4-20	3	H3	2-1/2	.630	119-874	17.70
5/16-18	3	H3	2-23/32	.748	119-875	23.80
3/8-16	3	H3	2-15/16	.748	119-876	26.60
7/16-14	3	H3	3-5/32	.866	119-877	39.60
1/2-13	3	H3	3-3/8	.945	119-878	41.80
5/8-11	3	H3	3-13/16	1.102	119-879	63.10
3/4-10	3	H3	4-1/4	1.220	119-880	121.40
7/8-9	3	H4	4-11/16	1.339	119-881	167.90
1-8	3	H4	5-1/8	1.496	119-882	196.40
NF						
10-32	3	H3	2-3/8	.512	119-883	16.50
1/4-28	3	H3	2-1/2	.630	119-884	17.70
5/16-24	3	H3	2-23/32	.748	119-885	23.80
3/8-24	3	H3	2-15/16	.748	119-886	26.60
7/16-20	3	H3	3-5/32	.866	119-887	39.60
1/2-20	3	H3	3-3/8	.945	119-888	41.80
9/16-18	3	H3	3-19/32	1.006	119-889	52.10
5/8-18	3	H3	3-13/16	1.102	119-890	63.10

cutting conditions				
Materials				Cutting Speed (FPM)
Main Group	Sub-Group	Condition	Hardness (HRC)	Cutting Speed (FPM)
Stainless Steel	200 Series,	Annealed	<28	25-40
	300 Series,	Annealed	<28	25-40
	17-4, 15-5	Annealed	<25	20-30
	AM286	Annealed	<25	20-30
	400 Series	Annealed	<29	25-40
Tool steels	01, A-2,D-2 H-13,P-20	Annealed	<35	20-30
Medium Carbon	1030, 1035 1038,1040 1045, 1050	Normalized	<28	25-45
Alloyed high carbon	1065, 1070, 1080, 1090 1095, 1561, 1572	Normalized	<32	25-35
High strength	4140, 4340	Normalized	<32	25-35
Titanium	Commercially pure	Annealed	<32	20-35
Aluminum	Cast, wrought	-	-	40-100

cutting speed (fpm)	
	10 20 30 40 50 60 70 80 90 100
Stainless Steel	25-40
Tool Steels	20-30
Medium Carbon	25-45
Alloyed High Carbon	20-30
High Strength	25-35
Titanium	20-35
Aluminum	40-100

hardness (hrc)	
	0 5 10 15 20 25 30 35 35 40
Stainless Steel	up to 25
Tool Steels	up to 35
Medium Carbon	up to 28
Alloyed High Carbon	up to 32
High Strength	up to 32
Titanium	up to 32
Aluminum	

HSSE-V3 – P.V.D. TIN COATED SPIRAL FLUTE INCH-BLUE RING



BLUE TITANIUM NITRIDE

Taps can provide an increase in tool life of 2 to 6 times depending on the application.

The extremely hard and durable surface and high lubricity delivers long tool life, reduces friction and galling allowing higher speeds for higher productivity and less down time.

• 2.5 PITCH LEAD (BOTTOMING)

HSSE-V3 SPIRAL FLUTE TAPS INCH

Nominal Size and Pitch	No. Flutes	Thread Limits	O/A Length (in)	Thread Length (in)	Code No.	Price \$
NC						
4-40	2	H2	1-7/8	.256	119-900	17.70
6-32	3	H3	2	.315	119-901	17.20
8-32	3	H3	2-1/8	.315	119-902	17.20
10-24	3	H3	2-3/8	.413	119-903	18.00
1/4-20	3	H3	2-1/2	.492	119-904	18.20
5/16-18	3	H3	2-23/32	.551	119-905	26.10
3/8-16	3	H3	2-15/16	.630	119-906	28.60
7/16-14	3	H3	3-5/32	.709	119-907	42.70
1/2-13	3	H3	3-3/8	.768	119-908	49.30
5/8-11	4	H3	3-13/16	.906	119-909	65.60
3/4-10	4	H3	4-1/4	.827	119-910	126.90
7/8-9	4	H4	4-11/16	1.102	119-911	177.40
1-8	4	H4	5-1/8	1.260	119-912	210.00
NF						
10-32	3	H3	2-3/8	.413	119-913	18.00
1/4-28	3	H3	2-1/2	.492	119-914	18.20
5/16-24	3	H3	2-23/32	.551	119-915	26.10
3/8-24	3	H3	2-15/16	.630	119-916	28.60
7/16-20	3	H3	3-5/32	.709	119-917	42.70
1/2-20	3	H3	3-3/8	.768	119-918	49.30
9/16-18	3	H3	3-19/32	.827	119-919	57.10
5/8-18	4	H3	3-13/16	.906	119-920	65.60

cutting conditions

Materials				Cutting Speed (FPM)
Main Group	Sub-Group	Condition	Hardness (HRC)	
Stainless Steel	200 Series,	Annealed	<28	25-40
	300 Series,	Annealed	<28	25-40
	17-4, 15-5	Annealed	<25	20-30
	AM286	Annealed	<25	20-30
	400 Series	Annealed	<29	25-40
Tool steels	01, A-2, D-2 H-13, P-20	Annealed	<35	20-30
Medium Carbon	1030, 1035 1038, 1040 1045, 1050	Normalized	<28	25-45
Alloyed high carbon	1065, 1070, 1080, 1090 1095, 1561, 1572	Normalized	<32	25-35
High strength	4140, 4340	Normalized	<32	25-35
Titanium	Commercially pure	Annealed	<32	20-35
Aluminum	Cast, wrought	-	-	40-100

cutting speed (fpm)

	10	20	30	40	50	60	70	80	90	100
Stainless Steel										
Tool Steels										
Medium Carbon										
Alloyed High Carbon										
High Strength										
Titanium										
Aluminum										

hardness (hrc)

	0	5	10	15	20	25	30	35	40
Stainless Steel									
Tool Steels									
Medium Carbon									
Alloyed High Carbon									
High Strength									
Titanium									
Aluminum									