



- Steam oxide
- ANSI

Features a unique free-cutting design with a special tempering and geometry which contributes to extra tool life.

- 4.5 PITCH LEAD (INTERMEDIATE)

■ HSSE-V3 + .005" SPIRAL POINT TAPS INCH						
Tap	Threads Per Inch	No. Flutes	O/A Length (in)	Thread Length (in)	Code No.	Price \$
NC						
6	32	3	2	.512	119-925	8.10
8	32	3	2-1/8	.512	119-926	8.60
1/4	20	3	2-1/2	.630	119-927	9.60
5/16	18	3	2-23/32	.748	119-928	11.50
3/8	16	3	2-15/16	.748	119-929	13.20
7/16	14	3	3-5/32	.866	119-930	17.30
1/2	13	3	3-3/8	.945	119-931	19.20
5/8	11	3	3-13/16	1.102	119-932	30.00
3/4	10	3	4-1/4	1.220	119-933	50.00
NF						
1/4	28	3	2-1/2	.630	119-934	9.60
5/16	24	3	2-23/32	.748	119-935	11.50
3/8	24	3	2-15/16	.748	119-936	13.20
7/16	20	3	3-5/32	.866	119-937	17.30
1/2	20	3	3-3/8	.945	119-938	19.20

cutting conditions				
Materials				Cutting Speed (FPM)
Main Group	Sub-Group	Condition	Hardness (HRC)	Cutting Speed (FPM)
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)										
	10	20	30	40	50	60	70	80	90	100
Low carbon										
Medium Carbon										
Aluminum										
Brass/Bronze										
Copper										
Cast Iron										
hardness (hrc)										
	0	5	10	15	20	25	30	35	35	40
Low carbon						up to 25				
Medium Carbon						up to 25				
Aluminum										
Brass/Bronze										
Copper										
Cast Iron						up to 15				