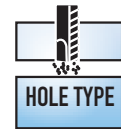




# HSSE-V3 SPIRAL POINT TAPS-SPECIAL LIMITS INCH YELLOW RING



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.

## HSSE-V3% VANADIUM

- Superior performance in hardened tool steels such as 4140, 4340, H13, D2.
- Up to 35 HRC

## SPECIAL LIMITS H5, H6, H7

### • 4.5 PITCH LEAD (INTERMEDIATE)

■ HSSE-V3 SPIRAL POINT TAPS INCH										
Tap	Threads Per Inch	No. Flutes	O/A L (in)	Thread L (in)	H5 Limit Code No.	Price \$	H6 Limit Code No.	Price \$	H7 Limit Code No.	Price \$
<b>NC</b>										
6	32	3	2	.512	122-556	<b>8.60</b>			122-650	<b>8.60</b>
8	32	3	2-1/8	.512	122-558	<b>9.10</b>			122-652	<b>9.10</b>
10	24	3	2-3/8	.512	122-560	<b>9.30</b>			122-654	<b>9.30</b>
1/4	20	3	2-1/2	.630	122-564	<b>10.60</b>			122-658	<b>10.60</b>
5/16	18	3	2-23/32	.748	122-568	<b>12.80</b>			122-662	<b>12.80</b>
3/8	16	3	2-15/16	.748	122-572	<b>15.60</b>			122-666	<b>15.60</b>
7/16	14	3	3-5/32	.866	122-576	<b>20.30</b>				
1/2	13	3	3-3/8	.945	122-580	<b>22.60</b>			122-670	<b>22.60</b>
5/8	11	3	3-13/16	1.102	122-584	<b>35.60</b>				
3/4	10	3	4-1/4	1.220	122-586	<b>59.60</b>				
1	8	4	5-1/8	1.496			122-588	<b>111.70</b>		
1-1/4	7	4	5-3/4	1.732			122-590	<b>184.10</b>		
1-3/8	6	4	6-1/16	2.000			122-592	<b>242.00</b>		
1-1/2	6	4	6-3/8	2.000			122-594	<b>310.50</b>		
<b>NF</b>										
10	32	3	2-3/8	.512	122-562	<b>9.30</b>			122-656	<b>9.30</b>
1/4	28	3	2-1/2	.630	122-566	<b>10.60</b>			122-660	<b>10.60</b>
5/16	24	3	2-23/32	.748	122-570	<b>12.80</b>			122-664	<b>12.80</b>
3/8	24	3	2-15/16	.748	122-574	<b>15.60</b>			122-668	<b>15.60</b>
7/16	20	3	3-5/32	.866	122-578	<b>20.30</b>				
1/2	20	3	3-3/8	.945	122-582	<b>22.60</b>				

cutting conditions					
Materials				Hardness (HRC)	Cutting Speed (FPM)
Main Group	Sub-Group	Condition			
Tool steels	01, A-2,D-2 H-13,P-20	Annealed	<35		15-25
Medium Carbon	1030, 1035 1038,1040 1045, 1050	Normalized	<28		20-40
Alloyed high carbon	1065, 1070, 1080, 1090 1095, 1561, 1572	Normalized	<32		20-30
High strength	4140, 4340	Normalized	<32		20-30
Titanium	Commercially pure	Annealed	<32		15-30
Aluminum	Cast, wrought	-	-		30-90

cutting speed (fpm)	
	10 20 30 40 50 60 70 80 90 100
Tool Steels	0-30
Medium Carbon	0-40
Alloyed High Carbon	0-30
High Strength	0-30
Titanium	0-100
Aluminum	0-100

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