HSSE-V3 SPIRAL FLUTE 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

• 2.5 PITCH LEAD (BOTTOMING)

HSSE-V3 SPIRAL FLUTE TAPS INCH

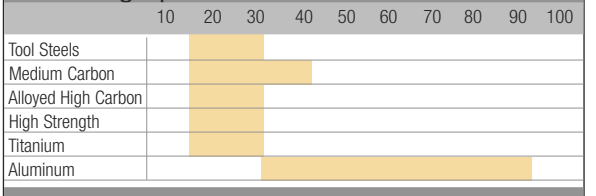
Tap	Threads Per Inch	No. Flutes	O/A L (in)	Thread L (in)	H5 Limit Code No.	Price $	H6 Limit Code No.	Price $	H7 Limit Code No.	Price $
NC										
6	32	3	2	.313	122-508	**10.60**			122-600	**10.60**
8	32	3	2-1/8	.313	122-510	**10.60**			122-602	**10.60**
10	24	3	2-3/8	.417	122-512	**10.80**			122-604	**10.80**
1/4	20	3	2-1/2	.500	122-516	**11.10**			122-608	**11.10**
5/16	18	3	2-23/32	.556	122-520	**15.10**			122-612	**15.10**
3/8	16	3	2-15/16	.625	122-524	**17.60**			122-616	**17.60**
7/16	14	3	3-5/32	.714	122-528	**23.50**				
1/2	13	3	3-3/8	.769	122-532	**30.10**			122-620	**30.10**
5/8	11	4	3-13/16	.909	122-536	**38.10**				
3/4	10	4	4-1/4	1.000	122-538	**65.10**				
1	8	4	5-1/8	1.250			122-540	**125.20**		
1-1/4	7	4	5-3/4	1.429			122-542	**184.10**		
1-3/8	6	4	6-1/16	1.667			122-544	**242.00**		
1-1/2	6	4	6-3/8	1.667			122-546	**310.50**		
NF										
10	32	3	2-3/8	.417	122-514	**10.80**			122-606	**10.80**
1/4	28	3	2-1/2	.500	122-518	**11.10**			122-610	**11.10**
5/16	24	3	2-23/32	.556	122-522	**15.10**			122-614	**15.10**
3/8	24	3	2-15/16	.625	122-526	**17.60**			122-618	**17.60**
7/16	20	3	3-5/32	.714	122-530	**23.50**				
1/2	20	3	3-3/8	.769	122-534	**30.10**				

cutting conditions

Materials

Main Group	Sub-Group	Condition	Hardness (HRC)	Cutting Speed (FPM)
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)



hardness (hrc)