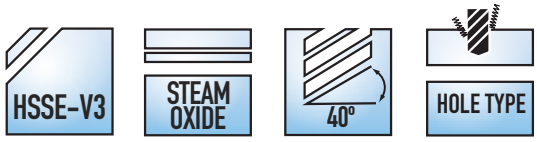


Designed for high-speed tapping applications. Developed to withstand the high stress and high heat associated with high-speed CNC production tapping. Features a unique free-cutting design with a special tempering and geometry which contributes to extra tool life.

Bright Finish Available
Add "B" to the end of the Code No.
e.g. 123-650B

• 2.5 PITCH LEAD (BOTTOMING)

HSSE-V3 SPIRAL FLUTE TAPS METRIC SIZES

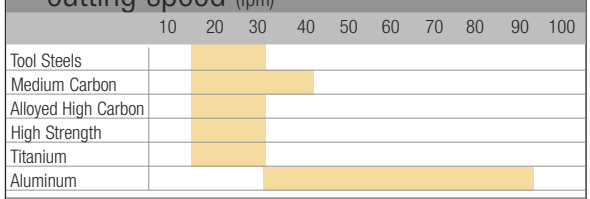
Nominal Size and Pitch	No. Flutes	Thread Limits	O/A Length (in)	Thread Length (in)	Code No.	Price $
M3 x .5	3	D3	2-3/8	.197	123-650	**10.60**
M3.5 x .6	3	D4	2-3/8	.236	123-651	**10.60**
M4 x .7	3	D4	2-3/8	.276	123-652	**10.60**
M5 x .8	3	D4	2-3/8	.315	123-654	**10.80**
M6 x 1	3	D5	2-1/2	.394	123-656	**11.10**
M7 x 1	3	D5	2-23/32	.394	123-657	**15.10**
M8 x 1	3	D5	2-23/32	.492	123-659	**15.10**
M8 x 1.25	3	D5	2-23/32	.492	123-658	**15.10**
M10 x 1.25	3	D5	2-15/16	.591	123-661	**17.60**
M10 x 1.5	3	D6	2-15/16	.591	123-660	**17.60**
M12 x 1.25	3	D5	3-3/8	.689	123-663	**30.10**
M12 x 1.75	3	D6	3-3/8	.689	123-662	**30.10**
M14 x 1.5	3	D6	3-19/32	.787	123-665	**35.10**
M14 x 2	3	D7	3-19/32	.787	123-667	**35.10**
M16 x 1.5	3	D6	3-13/16	.787	123-668	**38.10**
M16 x 2	3	D7	3-13/16	.787	123-669	**38.10**
M18 x 1.5	4	D6	4-1/32	.984	123-670	**65.10**
M18 x 2.5	4	D7	4-1/32	.984	123-671	**65.10**
M20 x 1.5	4	D5	4-15/32	.984	123-672	**78.90**
M20 x 2.5	4	D6	4-15/32	.984	123-673	**78.90**
M22 x 1.5	4	D6	4-11/16	.984	123-674	**92.60**
M22 x 2.5	4	D6	4-11/16	.984	123-675	**92.60**
M24 x 1.5	4	D5	4-29/32	1.181	123-676	**125.20**
M24 x 3	4	D7	4-29/32	1.181	123-677	**125.20**
M27 x 1.5	4	D7	5-1/8	1.181	123-678	**158.20**
M27 x 3	4	D7	5-1/8	1.181	123-679	**158.20**
M30 x 1.5	4	D7	5-7/16	1.378	123-680	**184.10**
M30 x 3.5	4	D7	5-7/16	1.378	123-681	**184.10**

cutting conditions

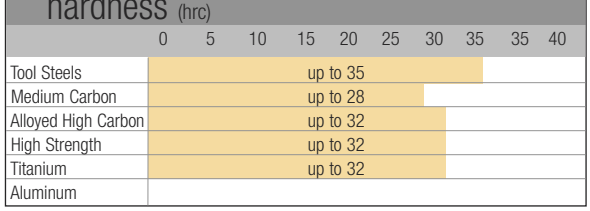
Materials

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)



LOW / MEDIUM CARBON STEELS | ALLOY / HIGH CARBON STEELS | STAINLESS STEEL | HIGH TENSILE