

HSSE-V3 UN 8 TAPS DIN LENGTH-ANSI SHANK INCH-YELLOW RING



HSSE-V3% VANADIUM

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

• 2.5 PITCH LEAD (BOTTOMING)

■ HSSE-V3 UN 8 PITCH DIN LENGTH ANSI SHANK TAPS

Nominal Size and Pitch	No. Flutes	Thread Limits	O/A Length (in)	Thread Length (in)	Code No.	Price \$
1-8	4	H7	6.299	1.417	123-055	197.30
1-1/8-8	4	H9	7.087	1.575	123-056	222.00
1-1/4-8	4	H9	7.087	1.575	123-079	369.90
1-3/8-8	5	H9	7.874	1.654	123-080	501.40
1-1/2-8	5	H9	7.874	1.654	123-057	575.40
1-3/4-8	6	H9	7.874	1.772	123-058	1,301.40
2-8	6	H10	8.858	1.969	123-059	1,851.90

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

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