



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.

These taps combine ANSI shank specifications with advantage of DIN lengths for added reach.

HSSE-V3% VANADIUM

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

• 4.5 PITCH LEAD (INTERMEDIATE)

HSSE-V3 DIN LENGTH ANSI SHANK SPIRAL POINT TAPS							
Tap	Threads Per Inch N.C.	No. Flutes	Thread Limit	O.A. Length (in)	Thread Length (in)	Code No.	Price \$
10	24	3	H3	2.756	.591	124-820	10.50
1/4	20	3	H3	3.150	.669	124-822	12.50
5/16	18	3	H3	3.543	.669	124-824	15.30
3/8	16	3	H3	3.937	.787	124-826	19.40
7/16	14	3	H3	3.937	.866	124-828	24.40
1/2	13	3	H3	4.331	.984	124-830	27.80
5/8	11	3	H3	4.331	1.063	124-832	42.20
3/4	10	3	H3	4.921	1.181	124-834	70.80

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	40
Tool Steels									
Medium Carbon									
Alloyed High Carbon									
High Strength									
Titanium									
Aluminum									

HSSE-V3 DIN LENGTH ANSI SHANK SPIRAL FLUTE TAPS INCH-YELLOW RING



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- Up to 35 HRC

• 2.5 PITCH LEAD (BOTTOMING)

HSSE-V3 DIN LENGTH ANSI SHANK SPIRAL FLUTE TAPS							
Tap	Threads Per Inch N.C.	No. Flutes	Thread Limit	O.A. Length (in)	Thread Length (in)	Code No.	Price \$
10	24	3	H3	2.756	.417	124-800	12.20
1/4	20	3	H3	3.150	.500	124-802	13.00
5/16	18	3	H3	3.543	.556	124-804	17.80
3/8	16	3	H3	3.937	.625	124-806	21.60
7/16	14	3	H3	3.937	.714	124-808	27.90
1/2	13	3	H3	4.331	.769	124-810	36.10
5/8	11	4	H3	4.331	.909	124-812	44.90
3/4	10	4	H3	4.921	1.000	124-814	76.80

cutting conditions					
Materials				Cutting Speed (FPM)	
Main Group	Sub-Group	Condition	Hardness (HRC)		
Stainless Steel	200 Series,	Annealed	<28	20-35	
	300 Series,	Annealed	<28	20-35	
	17-4, 15-5	Annealed	<25	15-25	
	AM286	Annealed	<25	15-25	
	400 Series	Annealed	<29	20-35	
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	up to 35
Medium Carbon	up to 28
Alloyed High Carbon	up to 32
High Strength	up to 32
Titanium	up to 32
Aluminum	