

# HSSE-V3 4" & 6" O.A.L. SPIRAL POINT TAPS 1/2" INCH-YELLOW RING



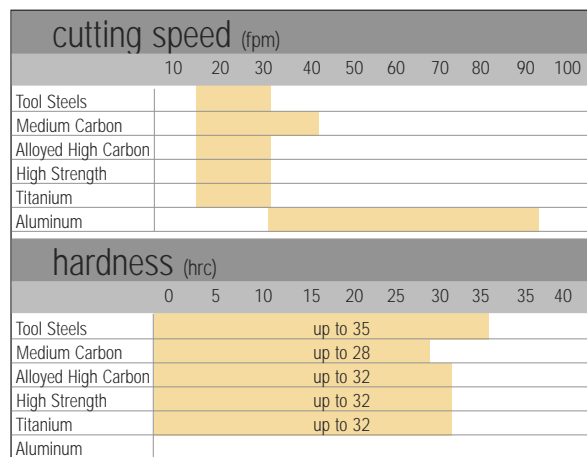
Designed for high-speed tapping applications. Developed to withstand the high stress and high heat associated with high-speed CNC production tapping. Features a unique free-cutting design with a special tempering and geometry which contributes to extra tool life. Designed for long reach applications.

## HSSE-V3% VANADIUM

- Superior performance in hardened tool steels such as 4140, 4340, H13, D2.
- Up to 35 HRC
- 4.5 PITCH LEAD (INTERMEDIATE)

4" & 6" O.A.L. SPIRAL POINT TAPS HSSE-V3 1/2" INCH							
Tap	Threads Per Inch	No. Flutes	Thread Limits	O/A Length (in)	Thread Length (in)	Code No.	Price \$
<b>NC</b>							
4	40	2	H2	4"	.433	122-700	12.00
6	32	3	H3	4"	.512	122-702	10.80
8	32	3	H3	4"	.512	122-704	11.80
10	24	3	H3	6"	.512	122-706	11.90
1/4	20	3	H3	6"	.630	122-710	16.70
5/16	18	3	H3	6"	.748	122-714	19.60
3/8	16	3	H3	6"	.748	122-718	24.70
7/16	14	3	H3	6"	.866	122-722	30.90
1/2	13	3	H3	6"	.945	122-726	34.10
5/8	11	3	H3	6"	1.102	122-730	51.20
3/4	10	3	H3	6"	1.220	122-731	81.10
7/8	9	3	H4	6"	1.339	122-732	108.90
1"	8	4	H4	6"	1.496	122-733	140.40
<b>NF</b>							
10	32	3	H3	6"	.512	122-708	11.90
1/4	28	3	H3	6"	.630	122-712	16.70
5/16	24	3	H3	6"	.748	122-716	19.60
3/8	24	3	H3	6"	.748	122-720	24.70
7/16	20	3	H3	6"	.866	122-724	30.90
1/2	20	3	H3	6"	.945	122-728	34.10

cutting conditions					
Materials				Hardness (HRC)	Cutting Speed (FPM)
Main Group	Sub-Group	Condition			
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	
Tool steels	400 Series	Annealed	<29	20-35	
	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 Titanium	4140, 4340 Commercially pure	Normalized Annealed	<32 <32	20-30 15-30	
Aluminum	Cast, wrought	-	-	30-90	



# HSSE-V3 4" & 6" O.A.L. SPIRAL FLUTE TAPS INCH-YELLOW RING

Designed for high-speed tapping applications. Developed to withstand the high stresses 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. Designed for long reach applications.



## 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 4" & 6" O.A.L. SPIRAL FLUTE TAPS INCH

Tap	Threads Per Inch	No. Flutes	Thread Limits	O/A Length (in)	Thread Length (in)	Code No.	Price \$
<b>NC</b>							
4	40	2	H2	4"	.433	123-060	13.80
6	32	3	H3	4"	.512	123-061	13.10
8	32	3	H3	4"	.512	123-062	13.50
10	24	3	H3	4"	.512	123-063	13.60
1/4	20	3	H3	6"	.630	123-064	17.20
5/16	18	3	H3	6"	.748	123-065	22.20
3/8	16	3	H3	6"	.748	123-066	27.00
7/16	14	3	H3	6"	.866	123-067	34.50
1/2	13	3	H3	6"	.945	123-068	42.70
5/8	11	4	H3	6"	1.102	123-069	54.10
3/4	10	4	H3	6"	1.220	123-070	87.40
7/8	9	4	H4	6"	1.339	123-071	119.80
1"	8	4	H4	6"	1.496	123-072	156.00
<b>NF</b>							
10	32	3	H3	6"	.512	123-073	13.60
1/4	28	3	H3	6"	.630	123-074	17.20
5/16	24	3	H3	6"	.748	123-075	22.20
3/8	24	3	H3	6"	.748	123-076	27.00
7/16	20	3	H3	6"	.866	123-077	34.50
1/2	20	3	H3	6"	.945	123-078	42.70

### cutting conditions

Materials			Hardness (HRC)	Cutting Speed (FPM)
Main Group	Sub-Group	Condition		
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	Annealed	<35	15-25
	H-13, P-20			
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 Titanium	4140, 4340	Normalized	<32	20-30
	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										