



HSSE-V3% VANADIUM

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

• 2.5 PITCH LEAD (BOTTOMING)

NPT SPIRAL FLUTE PIPE TAPS - HSSE-V3 FRACTIONAL SIZES						
Size	Threads Per Inch	No. Flutes	O/A Length (in)	Thread Length (in)	Code No.	Price \$
1/16	27	4	2-1/8	.688	123-400	17.60
1/8	27	4	2-1/8	.750	123-402	20.10
1/4	18	4	2-7/16	1.063	123-404	30.10
3/8	18	4	2-9/16	1.063	123-406	47.60
1/2	14	4	3-1/8	1.375	123-410	80.10
3/4	14	5	3-1/4	1.375	123-412	120.20
1	11-1/2	5	3-3/4	1.750	123-414	200.20
1-1/4	11-1/2	5	4	1.750	123-416	350.40
1-1/2	11-1/2	5	4-1/4	1.750	123-418	450.50
2	11-1/2	5	4-1/2	1.750	123-420	750.80

Spiral fluted design for steel, stainless steel and other materials.

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
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	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									