



HSSE-V3% VANADIUM

- Superior performance in stainless steels
- Up to 35 HRC

- 4.5 PITCH LEAD (INTERMEDIATE)

HSSE-V3 SPIRAL POINT 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	1-15/16	.433	124-955	8.60
M4 x .7	3	D4	2-1/8	.512	124-956	9.10
M5 x .8	3	D4	2-3/8	.512	124-957	9.30
M6 x 1	3	D5	2-1/2	.630	124-958	10.60
M8 x 1.25	3	D5	2-23/32	.748	124-959	12.80
M10 x 1.25	3	D5	2-15/16	.748	124-960	15.60
M10 x 1.5	3	D6	2-15/16	.748	124-961	15.60
M12 x 1.75	3	D6	3-3/8	.945	124-962	22.60
M14 x 2	3	D6	3-19/32	.984	124-897	30.10
M16 x 2	3	D7	3-13/16	1.102	124-899	35.60
M18 x 2.5	3	D7	4-1/32	1.102	124-901	59.60
M20 x 2.5	3	D6	4-1/4	1.220	124-903	71.40
M22 x 2.5	3	D6	4-11/16	1.339	124-905	83.10
M24 x 3	3	D7	4-29/32	1.339	124-907	111.70

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
	400 Series	Hardened	<35	15-20
	17-4PH, 15-5 A286	Hardened	<35	15-20
Low Carbon Steels	1010, 1018	Normalized	<20	25-50
	Alloyed high carbon	Normalized	<25	20-30
	1050, 1065, 1070, 1080, 1090, 1095, 1561, 1572			
Beryllium Copper	4140, 4340		<32	20-30

cutting speed (fpm)	
	10 20 30 40 50 60 70 80 90 100
Stainless Steel	10-35
Low Carbon Steels	10-25
Alloyed High Carbon	10-15
Beryllium Copper	10-15

hardness (hrc)	
	0 5 10 15 20 25 30 35 35 40
Stainless Steel	up to 35
Low Carbon Steels	up to 20
Alloyed High Carbon	up to 25
Beryllium Copper	up to 32