



HSSE-V3% VANADIUM

- Superior performance in stainless steels
- Up to 35 HRC

- 2.5 PITCH LEAD (BOTTOMING)

■ HSSE-V3 SPIRAL FLUTE 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	.197	124-988	10.60
M4 x .7	3	D4	2-1/8	.276	124-989	10.60
M5 x .8	3	D4	2-3/8	.315	124-990	10.80
M6 x 1	3	D5	2-1/2	.394	124-991	11.10
M8 x 1.25	3	D5	2-23/32	.492	124-992	15.10
M10 x 1.25	3	D5	2-15/16	.591	124-993	17.60
M10 x 1.5	3	D6	2-15/16	.591	124-994	17.60
M12 x 1.75	3	D6	3-3/8	.689	124-995	30.10
M14 x 2	3	D7	3-19/32	.787	124-996	35.10
M16 x 2	3	D7	3-13/16	.787	124-997	38.10
M18 x 2.5	4	D7	4-1/32	.984	124-998	125.20
M20 x 2.0	4	D6	4-15/32	.984	124-999	78.90
M22 x 2.5	4	D6	4-11/16	.984	124-943	92.60
M24 x 3	4	D7	4-29/32	1.181	124-944	125.20

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	1050, 1065,	Normalized	<25	20-30
	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										
Low Carbon Steels										
Alloyed High Carbon										
Beryllium Copper										

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