



P-HSS - POWDERED METAL

- Used for heat resistant materials, high strength stainless steel and titanium alloys as well as other high tensile steels and alloys including tool steel and nickel alloys
- Up to 48 HRC

Powdered Metal taps offer superior toughness and lubricity and are made of premium-grade, super hard powder high speed steel. These taps have a special geometry for tougher applications.

- 4.5 PITCH LEAD (INTERMEDIATE)

P-HSS 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	124-500	16.60
M4 x .7	3	D4	2-1/8	.512	124-505	16.60
M5 x .8	3	D4	2-3/8	.512	124-510	17.60
M6 x 1.0	3	D5	2-1/2	.630	124-515	19.10
M8 x 1.25	3	D5	2-23/32	.748	124-520	22.60
M10 x 1.25	3	D5	2-15/16	.748	124-525	30.10
M10 x 1.5	3	D6	2-15/16	.748	124-530	30.10
M12 x 1.75	3	D6	3-3/8	.945	124-535	41.60

cutting conditions				
Materials				Cutting Speed (FPM)
Main Group	Sub-Group	Condition	Hardness (HRC)	
Stainless Steel	17-4PH, 15-5, 17-7PH, AM350	hardened	<48	12-20
Tool steels	01, A-2, D-2, H-13, P-20	Hardened	<48	10-20
High strength	4140, 4340, 50100	Hardened	<48	15-20
Nickel alloys	Inconel, Hastaloy, Waspaloy, Rene, Monel	Annealed and Hardened	<42	5-20
Titanium	6 AL 4	Annealed/hardened	<42	8-15

cutting speed (fpm)										
	10	20	30	40	50	60	70	80	90	100
Stainless Steel										
Tool Steels										
High Strength										
Titanium										
Aluminum										

hardness (hrc)											
	0	5	10	15	20	25	30	35	40	45	50
Stainless Steel											
Tool Steels											
High Strength											
Titanium											
Aluminum											