

POWERED METAL SPIRAL FLUTE TAPS INCH-METRIC RED RING



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.

- **2.5 PITCH LEAD (BOTTOMING)**

P-HSS SPIRAL FLUTE TAPS INCH

Tap	Threads Per Inch	No. Flutes	Thread Limits	O/A Length (in)	Thread Length (in)	Code No.	Price \$
NC							
4	40	2	H2	1-7/8	.250	124-250	20.10
6	32	3	H3	2	.313	124-255	16.60
8	32	3	H3	2-1/8	.313	124-260	16.60
10	24	3	H3	2-3/8	.417	124-265	17.60
1/4	20	3	H3	2-1/2	.500	124-275	19.10
5/16	18	3	H3	2-23/32	.556	124-285	22.60
3/8	16	3	H3	2-15/16	.625	124-295	30.10
7/16	14	3	H3	3-5/32	.714	124-305	35.60
1/2	13	3	H3	3-3/8	.769	124-315	41.60
5/8	11	4	H3	3-13/16	.909	124-325	85.10
3/4	10	4	H3	4-1/4	1.000	124-335	135.20
NF							
10	32	3	H3	2-3/8	.417	124-270	17.60
1/4	28	3	H3	2-1/2	.500	124-280	19.10
5/16	24	3	H3	2-23/32	.556	124-290	22.60
3/8	24	3	H3	2-15/16	.625	124-300	30.10
7/16	20	3	H3	3-5/32	.714	124-310	35.60
1/2	20	3	H3	3-3/8	.769	124-320	41.60
5/8	18	4	H3	3-13/16	.909	124-330	85.10
3/4	16	4	H3	4-1/4	1.000	124-340	135.20

P-HSS 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	124-550	16.60
M4 x .7	3	D4	2-1/8	.276	124-555	16.60
M5 x .8	3	D4	2-3/8	.315	124-560	17.60
M6 x 1.0	3	D5	2-1/2	.394	124-565	19.10
M8 x 1.25	3	D5	2-23/32	.492	124-570	22.60
M10 x 1.25	3	D5	2-15/16	.591	124-575	30.10
M10 x 1.5	3	D6	2-15/16	.591	124-580	30.10
M12 x 1.75	3	D6	3-3/8	.689	124-585	41.60

cutting conditions

Materials			Hardness (HRC)	Cutting Speed (FPM)
Main Group	Sub-Group	Condition		
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	35	40	45	50
Stainless Steel												
Tool Steels												
High Strength												
Titanium												
Aluminum												