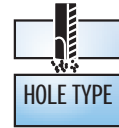


# POWERED METAL SPIRAL POINT TAPS INCH-RED RING



## 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

## • 4.5 PITCH LEAD (INTERMEDIATE)

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.

P-HSS SPIRAL POINT TAPS INCH						
Tap	Threads Per Inch	No. Flutes	Thread Limits	O/A Length (in)	Thread Length (in)	Code No.
4	40	2	H2	1-7/8	.433	124-100
5	40	3	H2	1-15/16	.433	124-105
6	32	3	H3	2	.512	124-110
8	32	3	H3	2-1/8	.512	124-115
10	24	3	H3	2-3/8	.512	124-120
10	32	3	H3	2-3/8	.512	124-125
1/4	20	3	H3	2-1/2	.630	124-130
1/4	28	3	H3	2-1/2	.630	124-135
5/16	18	3	H3	2-23/32	.748	124-140
5/16	24	3	H3	2-23/32	.748	124-145
3/8	16	3	H3	2-15/16	.748	124-150
3/8	24	3	H3	2-15/16	.748	124-155
7/16	14	3	H3	3-5/32	.866	124-160
7/16	20	3	H3	3-5/32	.866	124-165
1/2	13	3	H3	3-3/8	.945	124-170
1/2	20	3	H3	3-3/8	.945	124-175
5/8	11	3	H3	3-13/16	1.102	124-180
5/8	18	3	H3	3-13/16	1.102	124-185
3/4	10	4	H3	4-1/4	1.220	124-190
3/4	16	4	H3	4-1/4	1.220	124-195

cutting conditions				
Materials				Cutting Speed
Main Group	Sub-Group	Condition	Hardness (HRC)	(FPM)
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	10-20
Tool Steels	10-20
High Strength	15-20
Titanium	8-15
Aluminum	10-20

hardness (hrc)	
	0 5 10 15 20 25 30 35 35 40 45 50
Stainless Steel	up to 48
Tool Steels	up to 48
High Strength	up to 48
Titanium	up to 42
Aluminum	up to 42