

TAPS > HSS TAPS - HAND & MACHINE - SPIRAL POINT (GUN



suttontools

T422 - HSS TAPS - HAND & MACHINE - SPIRAL POINT (GUN TAPS - Sutton Tools

Features:

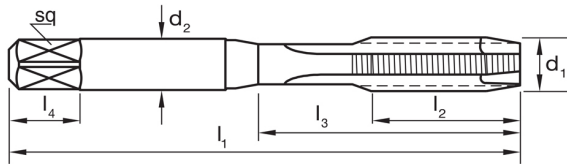
- General purpose use
 - Suitable for materials up to 1000N/mm²
 - Through holes
 - Depths up to approx. 3 x d1
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Specifications:

Designation:	N
Material:	HSSE V3
Finish:	Brt
Max Cut Depth:	3xD
Shank Form:	A
Type:	Spiral Point (Gun)
Standard:	ISO529
Thread Form:	UNC
Nut Tolerance:	2B
Lead:	Form B / 4.5 x P

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Range:



Item #	d1	TPI	Limit	l1	l2	l3	d2	sq	l4	z	Drill Ø
T4220284	#4	40	2B	48	15	14.5	3.15	2.5	5	2	2.3
T4220351	#6	32	2B	50	17	17.5	3.55	2.8	5	3	2.8
T4220417	#8	32	2B	53	13	18	4.5	3.55	6	3	3.4
T4220483	#10	24	2B	58	16	22	5	4	7	3	3.8
T4220635	1/4	20	2B	66	19	25	6.3	5	8	3	5.1
T4220794	5/16	18	2B	72	22	30	8	6.3	9	3	6.6
T4220953	3/8	16	2B	80	24	33	10	8	11	3	8
T4221111	7/16	14	2B	85	25	-	8	6.3	9	3	9.4
T4221270	1/2	13	2B	89	29	-	9	7.1	10	3	10.8
T4221588	5/8	11	2B	102	32	-	12.5	10	13	3	13.5
T4221905	3/4	10	2B	112	37	-	14	11.2	14	4	16.5

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Applications:

ISO	VDI	Description	Condition	Hardness	Strength	Optimal
P	1	Steel - Non-alloy, cast & free cutting (~ 0.15 %C)	Annealed	125HB	440MPa	●
P	2	Steel - Non-alloy, cast & free cutting (~ 0.45 %C)	Annealed	190HB	640MPa	●
P	3	Steel - Non-alloy, cast & free cutting (~ 0.45 %C)	Quenched & Tempered	250HB	840MPa	○
P	4	Steel - Non-alloy, cast & free cutting (~ 0.75 %C)	Annealed	270HB	910MPa	○
P	5	Steel - Non-alloy, cast & free cutting (~ 0.75 %C)	Quenched & Tempered	300HB	1010MPa	
P	6	Steel - Low alloy & cast < 5% of alloying elements	Annealed	180HB	610MPa	●
P	7	Steel - Low alloy & cast < 5% of alloying elements	Quenched & Tempered	275HB	930MPa	○
P	8	Steel - Low alloy & cast < 5% of alloying elements	Quenched & Tempered	300HB	1010MPa	
P	9	Steel - Low alloy & cast < 5% of alloying elements	Quenched & Tempered	350HB	1180MPa	
P	10	Steel - High alloy, cast & tool	Annealed	200HB	680MPa	
P	11	Steel - High alloy, cast & tool	Hardened & Tempered	325HB	1100MPa	
P	12	Steel - Corrosion resistant & cast - Ferritic / Martensitic	Annealed	200HB	680MPa	
P	13	Steel - Corrosion resistant & cast - Martensitic	Quenched & Tempered	240HB	810MPa	
M	14.1	Stainless Steel - Austenitic	Age Hardened	180HB	610MPa	○
M	14.2	Stainless Steel - Duplex		250HB	840MPa	○
M	14.3	Stainless Steel - Precipitation Hardening		250HB	840MPa	
K	15	Cast Iron, Grey (GG) - Ferritic / Pearlitic		180HB	610MPa	
K	16	Cast Iron, Grey (GG) - Pearlitic		260HB	880MPa	
K	17	Cast Iron, Nodular (GGG) - Ferritic		160HB	570MPa	○
K	18	Cast Iron, Nodular (GGG) - Pearlitic		250HB	840MPa	○
K	19	Cast Iron, Malleable - Ferritic		130HB	460MPa	○
K	20	Cast Iron, Malleable - Pearlitic		230HB	780MPa	
N	21	Aluminum & Magnesium, wrought alloy - Non Heat Treatable		60HB	210MPa	○
N	22	Aluminum & Magnesium, wrought alloy - Heat Treatable	Age Hardened	100HB	360MPa	○
N	23	Aluminum & Magnesium, cast alloy ≤12% Si - Non Heat Treatable		75HB	270MPa	○
N	24	Aluminum & Magnesium, cast alloy ≤12% Si - Heat Treatable	Age Hardened	90HB	320MPa	○
N	25	Aluminum & Magnesium, cast alloy >12% Si - Non Heat Treatable		130HB	460MPa	
N	26	Copper & Copper alloys (Brass/Bronze) - Free cutting, Pb > 1		110HB	390MPa	●
N	27	Copper & Copper alloys (Brass/Bronze) - Brass (CuZn, CuSnZn)		90HB	320MPa	○
N	28	Copper & Copper alloys (Brass/Bronze) - Bronze (CuSn)		100HB	360MPa	
N	29	Non-metallic - Thermosetting & fiber-reinforced plastics				
N	30	Non-metallic - Hard rubber, wood etc.				
S	31	High temperature alloys - Fe based	Annealed	200HB	680MPa	
S	32	High temperature alloys - Fe based	Age Hardened	280HB	950MPa	
S	33	High temperature alloys - Ni / Co based	Annealed	250HB	840MPa	
S	34	High temperature alloys - Ni / Co based	Age Hardened	350HB	1180MPa	
S	35	High temperature alloys - Ni / Co based	Cast	320HB	1080MPa	
S	36	Titanium & Titanium alloys - CP Titanium			400MPa	
S	37.1	Titanium & Titanium alloys - Alpha alloys			860MPa	
S	37.2	Titanium & Titanium alloys - Alpha / Beta alloys	Annealed		960MPa	
S	37.3	Titanium & Titanium alloys - Alpha / Beta alloys	Age Hardened		1170MPa	
S	37.4	Titanium & Titanium alloys - Beta alloys	Annealed		830MPa	
S	37.5	Titanium & Titanium alloys - Beta alloys	Age Hardened		1400MPa	
H	38.1	Hardened steel	Hardened & Tempered	45HRC		
H	38.2	Hardened steel	Hardened & Tempered	55HRC		

KEY

● Optimal ○ Effective



Steel



Stainless



Cast Iron



Non-Ferrous Metals



Titanium & Super Alloys



Hard Materials