



General Purpose Carbide High Performance Taps					
Material Guide		HRc	Cutting Speed (fpm)		Cutting Fluid*
			Spiral Point	Spiral Flute	
NICKEL BASE ALLOYS	Inconel-625/718, Waspalloy, Rene, Hastelloy	25 - 42	10	10	CO
TITANIUM ALLOYS	Commercially Pure, 6AL-4V, Astm 1/2/3, 6Al-25N-4Zr-2Mo-Si	under 32 over 32	10 8	10 8	CO CO
STAINLESS STEEL (PRECIPITATION)	13/8, 15/5, 17-4, AM-350/355	35 - 42	10	10	CO
STAINLESS STEEL (AUSTENITIC)	200 Series, 302, 303, 304, 316	< 25	20	15	CO
STAINLESS STEEL (MARTENSITIC)	403, 410, 416, 440	25 - 32	15	12	CO
HIGH STRENGTH TOOL STEELS	4140, 4340, 6150, 5210, A2, D2 P20, H11, H13, S2, O1	35 - 42	10	10	CO
MEDIUM ALLOY STEELS	200, 250, 300	< 15	35	25	WS, CO
CARBON STEELS	A36, 12L14, 12L15, 1005, 1018, 1020, 1108-1119, 1213-1215, 1513-1518, 4012, 5015, 9310	< 10	55	40	WS, CO
CAST IRONS	Gray Cast Irons	< 25	20	15	WS
MALLEABLE	A220, A436, A439, A602	< 25	15	12	CO
ALUMINUM	2014, 2024, 6061-(T1-T6), 7075, Die Cast, Extruded		80	60	WS, CO
BRASS, BRONZE	Brass, Alum/Bronze, Low Silicon Bronze		60	45	WS

YOUR INDIVIDUAL MANUFACTURING CONDITIONS WILL GREATLY INFLUENCE SPEEDS.

\*WS - WATER SOLUBLE

\*CO - CUTTING OIL

IN MOST INSTANCES CUTTING FLUID MANUFACTURERS RECOMMEND SPECIFIC FLUID FOR DIFFERENT MATERIALS.