



HAAS STAINLESS & CAST IRON TAPS

FEEDS & SPEEDS

HaasTooling.com

								Stainless Taps		Haas Cast Iron Taps
							SPIRAL FLUTE		SPIRAL POINT	STRAIGHT FLUTE
ISO	VDI 3323	Material Description	Composition / Structure / Heat Treatment		HB	HRC	Examples	SFM	SFM	SFM
P	1	Non-alloy steel	About 0.15% C	Annealed	125		S15C, C15, 1015	50-80	50-80	
P	2		About 0.45% C	Annealed	190	13	S45C, C45, 1045	50-80	50-80	
P	3		About 0.45% C	Quenched & tempered	250	25		50-80	50-80	
P	4		About 0.75% C	Annealed	270	28	SK5, CK75, 1080	10-35	10-35	
P	5		About 0.75% C	Quenched & tempered	300	32				
P	6	Low alloy steel		Annealed	180	10	SCM440, 42CrMo4, 410	10-35	10-35	
P	7			Quenched & tempered	275	29				
P	8			Quenched & tempered	300	32				
P	9			Quenched & tempered	350	38				
P	10	High alloyed steel, and tool steel		Annealed	200	15	SKD, D2			
P	11			Quenched & Tempered	325	35	SKH, SUH, M42			
M	12	Stainless steel	Ferritic / Martensitic	Annealed	200	15	SUS 420, X40Cr13, 420	20-50	20-50	
M	13		Martensitic	Quenched & Tempered	240	23		20-50	20-50	
M	14			Austenitic	180	10	SUS 316, 316, X5CrNiMo 17 12 2	12-15	12-15	
K	15	Grey cast iron	Pearlitic / ferritic		180	10	FC, GG, EN-GJL-250			50-65
K	16		Pearlitic (Martensitic)		260	26				50-65
K	17	Nodular cast iron	Ferritic		160	3	FCD, GGG, EN-GJS-500-7			25-55
K	18		Pearlitic		250	25				25-55
K	19	Malleable cast iron	Ferritic		130		FCMW, FCMF, GTS, GJMB350-10			25-55
K	20		Pearlitic		230	21				25-55
N	21	Aluminum-wrought alloy	Not Curable		60		SAE 1000, AlMg 1, 3.3315	50-65	50-65	
N	22		Curable	Hardened	100		SAE 7050, AlCuMg 1, 3.1325			
N	23	Aluminum-cast, alloyed	≤ 12% Si, Not Curable		75		ADC12, G-AISI12, 3.2581			45-90
N	24		≤ 12% Si, Curable	Hardened	90		C4BS, G-AISI10Mg, 3.2381			45-90
N	25		> 12% Si, Not Curable		130					
N	26	Copper and Copper Alloys (Bronze / Brass)	Cutting Alloys, PB>1%		110		CuZn36Pb 3, 2.0375	30-65	30-65	
N	27		CuZn, CuSnZn (Brass)		90		CuZn 15, 2.0240	30-65	30-65	
N	28		CuSn, lead-free copper and electrolytic copper		100		G-CuZn40Fe, 2.0590			
N	29	Non Metallic Materials	Duroplastic, Fiber Reinforced Plastic				CFRP			
N	30		Rubber, Wood, etc.							

Haas Material #'s																	
HAAS STAINLESS STEEL TAPS	Spiral Flute	03-0239	03-0240	03-0241	03-0242	03-0243	03-0244	03-0245	03-0246	03-0247	03-0248	03-0249	03-0250	03-0251	03-0252	03-0253	03-0254
	Spiral Point	03-0224	03-0225	03-0226	03-0227	03-0228	03-0229	03-0230	03-0231	03-0232	03-0233	03-0234	03-0235	03-0236	03-0237	03-0238	-
HAAS CAST IRON TAPS	Straight Flute	03-0168	03-0168	03-0169	03-0170	03-0171	03-0172	03-0173	03-0174	03-0175	03-0180	03-0176	03-0177	03-0178	03-0179	-	-