



Application Data • HSS-E • Metric

Material Group		 Through Holes					 Blind Holes					
		Tap Style	Grade	Range – m/min			Tap Style	Grade	Range – m/min			
				min	Starting Value	max			min	Starting Value	max	
P	P1	VT-SPO	WP42EG, WU41EG	21	27	34	VT-SFT	WP42EG, WU41EG	13	18	26	
		VT-SPO	WP49EG, WU40EG	10	14	17	VT-SFT	WP49EG, WU40EG	6	9	13	
	P2	VT-SPO	WP42EG, WU41EG	16	21	27	VT-SFT	WP42EG, WU41EG	11	15	22	
		VT-SPO	WP49EG, WU40EG	8	11	13	VT-SFT	WP49EG, WU40EG	4	6	9	
	P3	VT-SPO	WP42EG, WU41EG	9	12	15	VT-SFT	WP42EG, WU41EG	6	9	13	
		VT-SPO	WP49EG, WU40EG	5	6	8	VT-SFT	WP49EG, WU40EG	2	3	4	
		VT-STR NPT	WU41EG	5	6	8	VT-STR NPT	WU41EG	5	6	8	
			VT-STR NPT	WU40EG	2	3	4	VT-STR NPT	WU40EG	2	3	4
	M	M1	VT-SPO	WP42EG, WU41EG	9	12	15	VT-SFT	WP42EG, WU41EG	6	9	13
VT-SPO			WP49EG, WU40EG	5	6	8	VT-SFT	WP49EG, WU40EG	2	3	4	
VT-SFT NPT			WU41EG	5	6	8	VT-SFT NPT	WU41EG	5	6	8	
M3		VT-SFT NPT	WP49EG, WU40EG	2	3	4	VT-SFT NPT	WP49EG, WU40EG	2	3	4	
		VT-SPO	WP42EG, WU41EG	7	9	11	VT-SFT	WP42EG, WU41EG	4	6	9	
		VT-SPO	WP49EG, WU40EG	3	5	6	VT-SFT	WP49EG, WU40EG	2	3	4	
K	K1	VT-STR NPT	WU41EG	10	14	17	VT-STR NPT	WU41EG	10	14	17	
		VT-STR NPT	WU40EG	6	8	10	VT-STR NPT	WU40EG	6	8	10	
	K2	VT-SPO	WP42EG, WU41EG	21	27	34	VT-SFT	WP42EG, WU41EG	13	18	26	
VT-SPO		WP49EG, WU40EG	10	14	17	VT-SFT	WP49EG, WU40EG	6	9	13		
N	N1	VT-SPO	WP42EG, WU41EG	34	46	57	VT-SFT	WP42EG, WU41EG	23	34	48	
		VT-SPO	WU40EG	17	23	29	VT-SFT	WU40EG	11	15	22	
	N2	VT-SPO	WP42EG, WU41EG	30	40	50	VT-SFT	WP42EG, WU41EG	19	27	39	
		VT-SPO	WU40EG	15	20	25	VT-SFT	WU40EG	11	15	22	
	N4	VT-SPO	WP42EG, WU41EG	7	9	11	VT-SFT	WP42EG, WU41EG	4	6	9	
VT-SPO		WU40EG	3	5	6	VT-SFT	WU40EG	2	3	4		

* Grades: WP42EG = TiCN
 WU41EG = TiN
 WP49EG = oxide
 WU40EG = bright



INDEXABLE MILLING



SOLID END MILLING



HOLEMAKING



TAPPING



TURNING