



Torque Cut High Performance HSSE Color Ring Taps

- RedLine Torque Cut High Performance Taps give you greater performance when tapping Steel Alloys, Stainless Steels, Titanium and a variety of other Steels with a maximum Rc of 32.
- Made from High Vanadium Powdered Metal, Torque Cut Taps provide the right combination of strength and abrasion resistance. The benefit to this is increased speeds, while achieving longer tool life and a lower cost per thread.
- High Performance Taps found on pages 357-379.

High Performance HSSE Color Ring Tap Speeds				
Material	Grades	SFM	SFM	Ring
		Torque Cut HP	Pipe Taps	Color
P - Steels				
High Strength Tool Steel	A2, D2, P20, H11, H13, S2, 01	30-60	10-30	Green
Low Carbon	A36, 12L14, 12L15, 1005, 1018, 1020, 1108-1119, 1213-1215, 1513-1518, 4012, 5015, 9310	40-90	15-35	Yellow
Medium Carbon	1040-1095, 1140-1151, 1330-1345, 1520-1572, 4023-4063, 4120-4161, 4330-4340, 4620-4640, 8620-8660, 8740-8750, 6150, 51000, 52100	40-90	15-35	Yellow
M - Stainless Steels				
Austenitic	301-304L, 310, 316L, 321, 347	10-30	15-35	Blue
Martensitic	403, 410, 416, 420, 430, 431, 440	20-40	10-30	Red
Precipitation Hardening	12/8, 15/5, 17/4, AM-350/355/363, PH13-8MO, PH14-8/MO	8-20	6-15	Red
K - Cast Irons				
Ductile	A536, J434, 60-40-18	30-50	N/A	White
Gray	A48, A436, A319, Class 20, G4000	20-80	N/A	White
Malleable	A220, A602, J158	30-50	20-35	White
N - Non-Ferrous				
Aluminum Alloys	2014, 2024, 6061, 7075	90-150	65-110	Black
Aluminum High Silicon	A380, A390	65-75	50-55	Black
Brass/Bronze	Aluminum Bronze, Low Silicon Bronze	N/A	N/A	N/A
Composites	G-10, Fiberglass, Graphite, Graphite Epoxy, Plastics	N/A	N/A	N/A
Copper		N/A	N/A	N/A
Magnesium		N/A	N/A	N/A
S - High Temp Alloys				
Cobalt Base	Stellite, HS-21, Haynes 25/188, X40, L605	N/A	N/A	N/A
Iron Base	Incoloy 800-802, Multmet N-155, Timkin 16-25-6, Carpenter 22-b3	8-20	6-15	Blue
Nickel Base	Inconel 625/718, Inco 700, 713C, 718, Monel 400-401, 404, K401, Rene, Rene 41 & 95 Hastelloy, Waspoloy, Udimet 500 & 700	8-20	6-15	Blue
Titanium	Commercially Pure, 6Al-4V, ASTM 1/2/3, 6Al-25N-4Zr-2Mo-Si, Ti-8Al-1Mo, Ti-8Al-4Mo	20-50	15-35	Blue

NOTE: Speeds and Feeds listed are estimated and will vary by application.