



# HAAS MULTIPLE MATERIAL SERIES TAPS

FEEDS & SPEEDS

HaasTooling.com

							Haas Spiral Flute Multiple Material Tap Series				
							HAAS SPIRAL FLUTE	HAAS SPIRAL FLUTE TSC	HAAS SPIRAL POINT	HAAS SPIRAL POINT TSC	
ISO	VDI 3323	Material Description	Composition / Structure / Heat Treatment		HB	HRC	Examples	SFM	SFM	SFM	SFM
P	1	Non-alloy steel	About 0.15% C	Annealed	125		S15C, C15, 1015	50-80	50-80	50-80	50-80
P	2		About 0.45% C	Annealed	190	13	S45C, C45, 1045	50-80	50-80	50-80	50-80
P	3		About 0.45% C	Quenched & tempered	250	25		50-80	50-80	50-80	50-80
P	4		About 0.75% C	Annealed	270	28	SK5, Ck75, 1080	10-35	10-35	10-35	10-35
P	5		About 0.75% C	Quenched & tempered	300	32		10-35	10-35	10-35	10-35
P	6	Low alloy steel		Annealed	180	10	SCM440, 42CrMo4, 410	10-35	10-35	10-35	10-35
P	7			Quenched & tempered	275	29		10-35	10-35	10-35	10-35
P	8			Quenched & tempered	300	32		10-35	10-35	10-35	10-35
P	9			Quenched & tempered	350	38		10-35	10-35	10-35	10-35
P	10	High alloyed steel, and tool steel		Annealed	200	15	SKD, D2	10-35	10-35	10-35	10-35
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	20-50	20-50
M	13		Martensitic	Quenched & Tempered	240	23		20-50	20-50	20-50	20-50
M	14			Austenitic	180	10	SUS 316, 316, X5CrNiMo 17 12 2	12-15	12-15	12-15	12-15
K	15	Grey cast iron	Pearlitic / ferritic		180	10	FC, GG, EN-GJL-250	50-65	50-65	50-65	50-65
K	16		Pearlitic (Martensitic)		260	26		50-65	50-65	50-65	50-65
K	17	Nodular cast iron	Ferritic		160	3	FCD, GGG, EN-GJS-500-7	25-55	25-55	25-55	25-55
K	18		Pearlitic		250	25		25-55	25-55	25-55	25-55
K	19	Malleable cast iron	Ferritic		130		FCMW, FCMP, GTS, GJMB350-10				
K	20		Pearlitic		230	21					
N	21	Aluminum-wrought alloy	Not Curable		60		SAE 1000, AlMg 1, 3.3315				
N	22		Curable	Hardened	100		SAE 7050, AlCuMg 1, 3.1325				
N	23	Aluminum-cast, alloyed	≤ 12% Si, Not Curable		75		ADC12, G-AlSi12, 3.2581	45-90	45-90	45-90	45-90
N	24		≤ 12% Si, Curable	Hardened	90		C4BS, G-AlSi10Mg, 3.2381				
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	30-65	30-65
N	27		CuZn, CuSnZn (Brass)		90		CuZn 15, 2.0240	30-65	30-65	30-65	30-65
N	28		CuSn, lead-free copper and electrolytic copper		100		G-CuZn40Fe, 2.0590	30-65	30-65	30-65	30-65
N	29	Non Metallic Materials	Duroplastic, Fiber Reinforced Plastic				CFRP				
N	30		Rubber, Wood, etc.								

Haas Material #'s																
MULTI SPIRAL FLUTE	03-0112	03-0113	03-0114	03-0115	03-0116	03-0117	03-0118	03-0119	03-0120	03-0121	03-0122	03-0123	03-0124	03-0125	03-0126	03-0127
MULTI SPIRAL FLUTE TSC	03-0144	03-0145	03-0146	03-0147	03-0148	03-0149	03-0150	03-0151	03-0152	03-0153	03-0154	03-0155	-	-	-	-
MULTI SPIRAL POINT	03-0128	03-0129	03-0130	03-0131	03-0132	03-0133	03-0134	03-0135	03-0136	03-0137	03-0138	03-0139	03-0140	03-0141	03-0142	03-0143
MULTI SPIRAL POINT TSC	03-0156	03-0157	03-0158	03-0159	03-0160	03-0161	03-0162	03-0163	03-0164	03-0165	03-0166	03-0167	-	-	-	-