

RED RING CUT TAPS

Alloyed case hardened steels

Alloyed heat-treatable steels

Alloyed tool steels

High speed tool steels

Material group	Approximate Rc	Approximate HB	Recommended SFM					
			HSS-E		HSS-E-PM		Solid carbide	
			bright finish	hard coated	bright finish	hard coated	bright finish	hard coated
Alloyed case hardened steels	<25	<250	25-35	30-50	30-50	35-70	—	—
Alloyed heat-treatable steels	<30	<280	15-30	30-40	25-45	35-65	—	—
Alloyed tool steels	<35	<320	10-20	20-40	20-45	30-60	—	—
High speed tool steels	<38	<380	8-15	10-30	15-35	25-55	—	—
	<44	<415	—	—	4-10	8-15	—	8-16
	<60	—	—	—	—	4-10	—	6-12