

EXOCARB®-VX Taps

For Hardened Materials up to 65HRC

List 311



Straight Flute, DIN Overall Length, Modified Bottom(2.5P-3P)



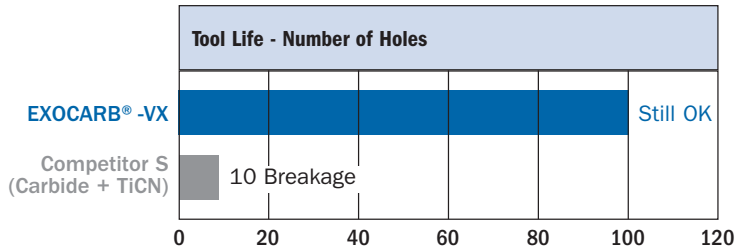
Tap Size	Threads Per Inch		Class of Fit	No. Of Flutes	OAL	Recomm'd SH-DRL	EDP Number	List Price (Each)
	UNC	UNF						
4	40	—	2B	4	56	2.3mm	3110108	101.04
6	32	—	2B	4	56	2.8mm	3110208	104.63
8	32	—	2B	4	63	3.5mm	3110308	104.63
10	24	—	2B	4	70	4.0mm	3110408	109.62
10	—	32	2B	4	70	4.2mm	3110508	109.62
1/4	20	—	2B	5	80	5.3mm	3110608	119.60
1/4	—	28	2B	5	80	5.6mm	3110708	119.60
5/16	18	—	2B	5	90	6.8mm	3110808	147.26
5/16	—	24	2B	5	90	7.1mm	3110908	147.26
3/8	16	—	2B	5	100	8.2mm	3111008	197.91
3/8	—	24	2B	5	100	8.7mm	3111108	197.91
7/16	14	—	2B	5	100	9.6mm	3111208	220.33
7/16	—	20	2B	5	100	10.1mm	3111308	220.33
1/2	13	—	2B	5	110	11.1mm	3111408	254.93
1/2	—	20	2B	5	110	11.7mm	3111508	254.93

Packed: 1 pc. Available TiCN finish only.

*Please see page 24-26 to find the recommended EXOCARB® SH-DRL drill.



EXOCARB®-VX Tap Performance:	
Tool:	List 311 1/4-20 NC
Material:	D2 (55HRC)
Speed:	100 RPM
Depth:	1.5D
Coolant:	Water soluble oil
Drill used:	EXOCARB® SH-DRL



Tapping Guidelines

1. Set tapping speed between 3 ~ 10 SFM.
2. Choose largest hole-size possible, within the recommended tolerance range.
3. Use a non-water soluble cutting fluid.
4. Use highly rigid machine and tool holders.
5. Tapping by hand is NOT recommended.
6. For tapping length over 1.5D, step feed is recommended.

Work Material																			
List No.	Aluminum		Cast Iron	CoCr	Carbon Steel	Alloy Steel and Die	Ductile Cast Iron	MMC	Copper Alloys	Fiberglass	High Heat Material		Stainless Steels			Hardened Steels			
	Alloys	Casting									Ti-Alloy	Inconel & Waspaloy	300	400	17-4PH	~55 Hrc	55-60 Hrc	60-65 Hrc	
311				○													○	○	○

○ good ○ best

