



■ VariTap™ • 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 (TC)	WP42EG, WU41EG	13	18	26
		VT-SPO	WP49EG, WU40EG	10	14	17	VT-SFT (TC)	WP49EG, WU40EG	6	9	13
	P2	VT-SPO	WP42EG, WU41EG	16	21	27	VT-SFT (TC)	WP42EG, WU41EG	11	15	22
		VT-SPO	WP49EG, WU40EG	8	11	13	VT-SFT (TC)	WP49EG, WU40EG	4	6	9
	P3	VT-SPO	WP42EG, WU41EG	9	12	15	VT-SFT (TC)	WP42EG, WU41EG	6	9	13
		VT-SPO	WP49EG, WU40EG	5	6	8	VT-SFT (TC)	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 (TC)	WP42EG, WU41EG	6	9	13
		VT-SPO	WP49EG, WU40EG	5	6	8	VT-SFT (TC)	WP49EG, WU40EG	2	3	4
		VT-SFT NPT	WU41EG	5	6	8	VT-SFT NPT	WU41EG	5	6	8
		VT-SFT NPT	WP49EG, WU40EG	2	3	4	VT-SFT NPT	WP49EG, WU40EG	2	3	4
	M3	VT-SPO	WP42EG, WU41EG	7	9	11	VT-SFT (TC)	WP42EG, WU41EG	4	6	9
		VT-SPO	WP49EG, WU40EG	3	5	6	VT-SFT (TC)	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 (TC)	WP42EG, WU41EG	13	18	26
		VT-SPO	WP49EG, WU40EG	10	14	17	VT-SFT (TC)	WP49EG, WU40EG	6	9	13
N	N1	VT-SPO	WP42EG, WU41EG	34	46	57	VT-SFT (TC)	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 (TC)	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 (TC)	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



VariTap™ • HSS-E • Inch

Tapping

Material Group	 Through Holes					 Blind Holes					
	Tap Style	Grade	Range – SFM			Tap Style	Grade	Range – SFM			
			min	Starting Value	max			min	Starting Value	max	
P	P1	VT-SPO	WP42EG, WU41EG	70	90	110	VT-SFT (TC)	WP42EG, WU41EG	40	60	90
		VT-SPO	WP49EG, WU40EG	30	45	60	VT-SFT (TC)	WP49EG, WU40EG	20	30	40
	P2	VT-SPO	WP42EG, WU41EG	50	70	90	VT-SFT (TC)	WP42EG, WU41EG	40	50	70
		VT-SPO	WP49EG, WU40EG	30	35	40	VT-SFT (TC)	WP49EG, WU40EG	10	20	30
	P3	VT-SPO	WP42EG, WU41EG	30	40	50	VT-SFT (TC)	WP42EG, WU41EG	20	30	40
		VT-SPO	WP49EG, WU40EG	20	20	30	VT-SFT (TC)	WP49EG, WU40EG	10	10	10
		VT-STR NPT	WU41EG	20	20	30	VT-STR NPT	WU41EG	20	20	30
	VT-STR NPT	WU40EG	10	10	10	VT-STR NPT	WU40EG	10	10	10	
M	M1	VT-SPO	WP42EG, WU41EG	30	40	50	VT-SFT (TC)	WP42EG, WU41EG	20	30	40
		VT-SPO	WP49EG, WU40EG	20	20	30	VT-SFT (TC)	WP49EG, WU40EG	10	10	10
		VT-SFT NPT	WU41EG	20	20	30	VT-SFT NPT	WU41EG	20	20	30
		VT-SFT NPT	WP49EG, WU40EG	10	10	10	VT-SFT NPT	WP49EG, WU40EG	10	10	10
	M3	VT-SPO	WP42EG, WU41EG	20	30	40	VT-SFT (TC)	WP42EG, WU41EG	10	20	30
		VT-SPO	WP49EG, WU40EG	10	15	20	VT-SFT (TC)	WP49EG, WU40EG	7	10	10
K	K1	VT-STR NPT	WU41EG	30	45	60	VT-STR NPT	WU41EG	30	45	60
		VT-STR NPT	WU40EG	20	25	30	VT-STR NPT	WU40EG	20	25	30
	K2	VT-SPO	WP42EG, WU41EG	70	90	110	VT-SFT (TC)	WP42EG, WU41EG	40	60	90
		VT-SPO	WP49EG, WU40EG	30	45	60	VT-SFT (TC)	WP49EG, WU40EG	20	30	40
N	N1	VT-SPO	WP42EG, WU41EG	110	150	190	VT-SFT (TC)	WP42EG, WU41EG	80	110	160
		VT-SPO	WU40EG	60	75	90	VT-SFT	WU40EG	40	50	72
	N2	VT-SPO	WP42EG, WU41EG	100	130	160	VT-SFT (TC)	WP42EG, WU41EG	60	90	130
		VT-SPO	WU40EG	50	65	80	VT-SFT	WU40EG	40	50	70
	N4	VT-SPO	WP42EG, WU41EG	23	30	40	VT-SFT (TC)	WP42EG, WU41EG	10	20	30
		VT-SPO	WU40EG	10	15	20	VT-SFT	WU40EG	10	10	10

* Grades: WP42EG = TiCN
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