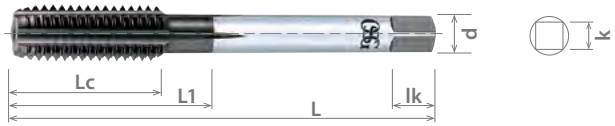
List 311

STRAIGHT FLUTE | CARBIDE | V | C/3P | 0° | PACKED 1 PIECE

EXOCARB® VX-OT, DIN Overall Length



EDP		Thread Size	Class of Fit	Overall Length L (Inch)	Thread Length Lc (Inch)	Neck Length L1 (Inch)	Shank Diameter d (Inch)	Square Width k (Inch)	Square Length lk (Inch)	Number of Flutes
3110108	●	No. 4 - 40 UNC	2B	2.205	0.295	0.705	0.141	0.110	0.188	4
3110208	●	No. 6 - 32 UNC	2B	2.205	0.370	0.783	0.141	0.110	0.188	4
3110308	●	No. 8 - 32 UNC	2B	2.480	0.374	0.827	0.168	0.131	0.250	4
3110408	●	No. 10 - 24 UNC	2B	2.756	0.492	0.976	0.194	0.152	0.250	4
3110508	●	No. 10 - 32 UNF	2B	2.756	0.500	0.984	0.194	0.152	0.250	4
3110608	●	1/4 - 20 UNC	2B	3.150	0.594	1.177	0.255	0.191	0.313	5
3110708	●	1/4 - 28 UNF	2B	3.150	0.606	1.189	0.255	0.191	0.313	5
3110808	●	5/16 - 18 UNC	2B	3.543	0.665	1.378	0.318	0.238	0.375	5
3110908	●	5/16 - 24 UNF	2B	3.543	0.665	1.378	0.318	0.238	0.375	5
3111008	●	3/8 - 16 UNC	2B	3.937	0.752	1.378	0.381	0.286	0.438	5
3111108	●	3/8 - 24 UNF	2B	3.937	0.752	1.378	0.381	0.286	0.438	5
3111208	●	7/16 - 14 UNC	2B	3.937	0.858	-	0.323	0.242	0.406	5
3111308	●	7/16 - 20 UNF	2B	3.937	0.858	-	0.323	0.242	0.406	5
3111408	●	1/2 - 13 UNC	2B	4.331	0.921	-	0.367	0.275	0.438	5
3111508	●	1/2 - 20 UNF	2B	4.331	0.921	-	0.367	0.275	0.438	5

● Stocked ○ Available Upon Request; MOQ May Apply ▲ Globally Stocked

HTE

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.

P					M			K	N		S		H			
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel			
Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium				
Low	Medium	High														
1010 1018	1035 1045	1065	4140 4340		300	400	17-4 PH		6061 7075	Casting	Inconel	6Al4V (30 HRC)	~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC
															○	◎
															3-10 SFM	3-10 SFM

○ Good ◎ Best