



Yellow Band Performance Taps

Application Key

Cutting Tools

○ = Very Good ● = Best

Recommended Application	Material to be Tapped	Hardness	Cutting Speed (SFM*)
○	Medium to High Carbon Steel such as 1040, 1050, 1080 & 1572	up to Rc 28	20-45
○	Medium Alloyed Steel such as 4140	Up to Rc 30	15-30
●	Cast Steel such as A356	Up to Rc 28	25-40
●	Stainless Steels - 200 and 400 Series	Up to Rc 28	25-40
●	Stainless Steels - 300 Series	Up to Rc 28	20-35
●	Stainless Steels - Precipitation Hardened (PH) such as 17-4 PH	Up to Rc 28	15-25

*RPM = 3.82 x SFM/DIA

□ = Steel □ = Stainless Steel