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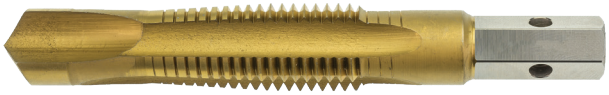
Combi Drill Taps - Data Sheet



Impact Torque Nm

Thread Diameter	Impact Tapping Torque		
	6mm Steel	12mm Steel	25mm Steel
Diameter Ø	Nm Torque		
M3	105	160	N/A
M4	120	180	N/A
M5	135	200	N/A
M6	140	240	N/A
1/4"	145	255	N/A
5/16"	145	265	N/A
M8	150	280	N/A
3/8"	160	290	N/A
M10	170	300	N/A
M12	185	320	512
1/2"	190	330	520
M14	195	340	544
5/8"	195	355	555
M16	200	360	576
3/4"	245	380	610
M20	315	400	640
7/8"	N/A	515	715
M24	N/A	600	960
1"	N/A	675	1050

Impact Tapping Torque		
1/4" Steel	1/2" Steel	1" Steel
Ft Lbs Torque		
75	120	N/A
90	130	N/A
95	145	N/A
100	180	N/A
105	175	295
105	205	330
110	205	N/A
115	220	355
125	220	N/A
135	235	380
140	235	375
140	300	405
145	365	425
150	265	425
185	295	470
230	295	475
N/A	370	710
N/A	420	720
N/A	445	735

Revolutions per minute (Rotary)

Thread Diameter	Structural Steel <500Nm	Structural Steel <1000Nm	Stainless Steel INOX	Aluminium	Cast Iron (Grey)
Diameter Ø	RPM Range				
M3	960	809	650	2700	1295
M4	730	610	490	2060	975
M5	585	485	385	1750	780
M6	485	405	325	1455	650
1/4"	485	405	325	1455	650
5/16"	365	310	245	1095	485
M8	365	310	245	1095	485
3/8"	295	245	195	870	390
M10	295	245	195	870	390
M12	240	200	162	730	330
1/2"	240	200	162	730	330
M14	210	175	140	625	275
5/8"	185	155	125	550	243
M16	185	155	125	550	243
3/4"	145	125	100	440	194
M20	145	125	100	440	194
7/8"	130	115	92	410	180
M24	120	100	85	370	165
1"	120	100	85	370	165

Impact Torque recommendations are the minimum required and for most applications additional torque is a benefit

Best Practice Advice

*GUIDELINE PARAMETERS ONLY - Actual parameters may vary depending on operating conditions

1	Impact DrillTaps are recommended for through hole applications only.	7	Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials.
2	Pilot drill the exact tapping size hole for best results	8	Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant
3	Select correct NM torque power for impact wrench applications	9	Flame cut/punched holes will require more torque to tap than drilled holes due to heat build up. Caution: Sometimes flame cut holes do not have parallel sides meaning risk of tap breakage.
4	Apply firm, steady feed pressure throughout the cut	10	Tap the hole in one pass where possible, applying adequate lubrication before you start.
5	Ensure the Tap is inserted squarely to the hole - misaligned taps will greatly increase the risk of breakage.	11	301125- Sheet Metal Drill-Taps are intended for tapping material no greater than the tap diameter when driven with an impact wrench
6	When tapping material thicker than 15-20mm, to speed up the process it is advisable to pilot drill the hole first, before drill-tapping the hole	12	301130- Heavy Duty Drill Taps are designed for use with Magnet Drills/Pillar Drills, or for tapping pre-drilled holes with an impact wrench. They are not designed for drill-tapping with hand-held rotary tools

Quick Guide - Drill Taps (301125)

Heavy Duty Drill Taps (301130)

1	*For fastest performance use on impact wrenches/drivers*	*Ideal for use in drill presses and magnet drills*
2	*Check the minimum torque requirement*	*For impact wrench use, pilot drilling is recommended*
3	*Up to M10 (3/8") can also be used on cordless drills*	*Correct RPM is critical for good performance on larger sizes*
4	*Use appropriate lubrication and correct RPM to achieve long tool life*	

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