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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

Best Practice Advice

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

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