Combi Drill Taps - Data Sheet

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	Thread Diameter	Max Material Thickness	Impact Torque Nm	Impact Torque Ft Lbs	Revolutions per minute RPM (Rotary) Structural Steel <500 Mpa	Structural Steel <1000 Mpa	Stainless Steel INOX	Aluminium	Cast Iron (Grey)
Metric	M3	3mm	105	80	960	810	650	2700	1295
	M4	4mm	120	90	730	610	490	2060	975
	M5	5mm	135	100	585	485	385	1750	780
	M6	6mm	140	105	485	405	325	1455	650
	M8	8mm	150	115	365	310	245	1095	485
	M10	10mm	170	125	295	245	195	870	390
	M12	12mm	185	135	240	200	160	730	330

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Inch (UNC)	4-40	3/32"	105	75	1050	850	710	2900	1390
	6-32	1/8"	120	90	950	790	650	2700	1295
	8-32	5/32"	135	95	730	610	490	2060	975
	10-24	13/64"	135	100	595	475	395	1700	820
	1/4-20	1/4"	135	105	485	405	325	1455	650
	5/16-18	5/16"	280	110	365	310	245	1095	485
	3/8-16	3/8"	300	120	295	245	195	870	390
	1/2-13	1/2"	320	140	240	200	160	730	330



	Thread Diameter	Impact Torque Nm	Impact Torque Ft Lbs	Structural Steel <500 Mpa	Structural Steel <1000 Mpa	Stainless Steel INOX	Aluminium	Cast Iron (Grey)
Metric	M8	280	205	365	310	245	1095	485
	M10	320	220	295	245	195	870	390
	M12	340	235	240	200	160	730	330
	M16	550	425	185	155	125	550	240
	M20	700	475	145	125	100	440	195
	M24	960	630	120	100	85	370	165

	Thread Diameter	Impact Torque Nm	Impact Torque Ft Lbs	Structural Steel <500 Mpa	Structural Steel <1000 Mpa	Stainless Steel INOX	Aluminium	Cast Iron (Grey)
Inch (UNC)	1/2-13	340	235	240	200	160	730	330
	5/8-11	550	365	185	155	125	550	240
	3/4-10	700	675	145	125	100	440	195
	1-8	960	735	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*
2. *Pilot drill the exact tapping size hole for best results*
3. *Select the correct torque for Impact tools using the table above. If exact match is not available select the closest torque setting above the recommendation*
4. *Apply firm, steady feed pressure throughout the cut*
5. *Ensure the Tap is inserted squarely to the hole - poorly aligned or off-centre taps will greatly increase the risk of breakage*
6. *Regularly apply quality cooling lubricant, especially when drilling thick or hardened materials*
7. *Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant*
8. *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*
9. *Tap the hole in one pass where possible, applying adequate lubrication before you start.*
10. *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*
11. *301125- Sheet Metal Drill-Taps are intended for tapping material no greater than the tap diameter when driven with an Impact Wrench*
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

301125
- *For fastest performance use on Impact Wrenches & Impact Drivers*
- *Check the minimum torque requirement*
- *Up to M10 (3/8") can also be used on cordless drills*

301130
- *Ideal for use in Pillar Drills & Magnet Drills*
- *Correct RPM is critical for good performance on larger sizes*
- *For Impact Wrench use, pilot drilling is recommended*

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