

SELECTING THE CORRECT TAPPING FEED AND SPEED

MATERIAL ↓	TAP SIZE→	4 M3	5 M3.5	6 M4	8	10 M5	12	1/4 M6	5/16 M8	3/8 M10	7/16 M12	1/2	9/16 M14	5/8 M16	3/4 M20	7/8	1 M24
ALUMINUM	RPM	5116	4584	4151	3494	3016	2653	1681	1345	1120	873	764	683	611	458	393	344
	HP	.07	.09	.17	.11	.20	.21	.21	.27	.34	.41	.48	.57	.67	.72	.92	1.16
	SFM	150	150	150	150	150	150	110	110	110	100	100	100	100	90	90	90
BRASS	RPM	5116	4584	4151	3494	3016	1768	1375	1110	917	786	688	547	489	407	349	306
	HP	.12	.15	.17	.17	.32	.22	.27	.35	.44	.60	.68	.72	.84	1.0	1.3	1.6
	SFM	150	150	150	150	150	100	90	90	90	90	90	80	80	80	80	80
CAST IRON	RPM	3410	3056	2768	2329	1809	1592	1222	978	815	698	535	478	428	357	306	267
	HP	.11	.15	.19	.20	.32	.46	.41	.51	.66	.88	.88	1.05	1.2	1.5	1.9	2.4
	SFM	100	100	100	100	90	90	80	80	80	80	70	70	70	70	70	70
MILD STEEL	RPM	2046	1833	1661	1397	1206	1061	764	611	509	437	306	274	244	203	175	153
	HP	.08	.11	.22	.24	.42	.43	.51	.64	.82	1.1	1.0	1.2	1.4	1.7	2.1	2.7
	SFM	60	60	60	60	60	60	50	50	50	50	40	40	40	40	40	40
STAINLESS STEEL	RPM	1194	1070	969	699	603	354	306	245	204	175	153	137	122	50	44	35
	HP	.05	.09	.14	.13	.23	.16	.22	.28	.36	.48	.55	.66	.77	.46	.60	.75
	SFM	35	35	35	30	30	20	20	20	20	20	20	20	20	10	10	10

Note: Tapping screw machine threads only. Horsepower requirements shown are for UNC threads - UNF threads require approximately 1/2 of the stated HP.

Table shows average setting. Adjust for tool life, production rate, hardness of material, and type of cutting tool used.

Rollform tapping may require up to 50% more speed and 100% more torque.

The SOTECH product line includes:

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- Leadscrew Tapping Units
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(888)768-3243 SOTECH Corporation, North Prairie, Wisconsin

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