











Impact Torque Ft Lb













			
Thread Diameter	Impact Tapping Torque 1/4" Thick Steel	Impact Tapping Torque 1/2" Thick Steel	Impact Tapping Torque 1" Thick Steel
Diameter Ø	Ft Lbs Torque	Ft Lbs Torque	Ft Lbs Torque
1/4	105	175	295
5/16	110	205	330
3/8	125	220	355
1/2	135	235	375
5/8	145	365	425
3/4	230	295	470
7/8	N/A	370	710
1"	N/A	445	735

Rotary RPM

					
Thread Diameter	Structural Steel <500Nm	Structural Steel <1000Nm	Stainless Steel INOX	Aluminium	Cast Iron (Grey)
Diameter Ø	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range
1/4	485	405	325	1455	650
5/16	365	310	245	1095	485
3/8	295	245	195	870	390
1/2	240	200	162	730	330
5/8	185	155	125	550	243
3/4	145	125	100	440	194
7/8	130	115	92	410	180
1"	120	100	85	370	165

Best Practice Advice

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

1 	ImpactaTaps 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 the correct torque power for impact wrench/drivers using the data range above. If exact match is not available select the closest torque setting above the recommendation.	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 - poorly aligned or off-centre taps will greatly increase the risk of breakage.	11 	If the tap is over-run from the hole once it is tapped, to remove the risk of cross-threading/damage to the tap, remove the tap from the adapter and locate it in the thread by hand, before reversing.
6 	When using cordless tools, consider that the torque may drop once the battery charge becomes low. Keep batteries well charged. Low battery charge can lead to lower torque which can break or damage taps as point 3.	12 	When re-threading an existing thread, use caution to avoid cross-threading which can lead to tap breakage or thread damage. It is advisable to insert/start the tap into the thread by hand before driving it through at the correct torque

Quick Guide

1	For fastest performance use on impact wrenches & impact drivers
2	Check the minimum torque requirement
3	Laser cut holes & Stainless Steel require higher torque
4	Use appropriate lubrication and correct RPM to achieve long tool life