



Newton meter (Nm)
Impact Torque

Thread Diameter	Structural Steel <500Nm	Structural Steel <1000Nm	Stainless Steel INOX	Aluminium	Cast Iron (Grey)	Brass	Copper	Plastics	Impact Tapping Torque	
									12MM Thick Steel	25MM Thick Steel
Diameter Ø	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	Nm Torque	Nm Torque
M3	960	809	650	2700	1295	2550	1620	1700	160	N/A
M4	730	610	490	2060	975	1950	1220	1285	180	N/A
M5	585	485	385	1750	780	1555	970	1020	200	N/A
M6	485	405	325	1455	650	1295	810	855	240	400
M8	365	310	245	1095	485	970	610	650	280	448
M10	295	245	195	870	390	780	485	510	300	480
M12	240	200	162	730	330	645	410	430	320	512
M14	210	175	140	625	275	560	350	370	340	544
M16	185	155	125	550	243	485	310	330	360	576
M20	145	125	100	440	194	385	245	260	400	640
M24	120	100	85	370	165	325	210	225	600	960
M27	105	90	75	330	145	290	180	190	740	1184
M30	95	80	60	310	130	275	160	170	800	1200

Best Practice Advice

	ImpactaTaps are recommended for through hole applications only.		Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials.
	Pilot drill the exact tapping size hole for best results		Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant
	Select correct NM torque power for impact wrench applications		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.
	Apply firm, steady feed pressure throughout the cut		Tap the hole in one pass where possible, applying adequate lubrication before you start.
	Ensure the Tap is inserted squarely to the hole - misaligned taps will greatly increase the risk of breakage.		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.
	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		



Foot Pound (Ft lb)
Impact Torque

Thread Diameter	Structural Steel <500Nm	Structural Steel <1000Nm	Stainless Steel INOX	Aluminium	Cast Iron (Grey)	Brass	Copper	Plastics	Impact Tapping Torque	
									1/2" Thick Steel	1" Thick Steel
Diameter Ø	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	Ft Lbs Torque	Ft Lbs Torque
1/4	485	405	325	1455	650	1295	810	855	175	295
5/16	365	310	245	1095	485	970	610	650	205	330
3/8	295	245	195	870	390	780	485	510	220	355
1/2	240	200	162	730	330	645	410	430	235	375
5/8	185	155	125	550	243	485	310	330	365	425
3/4	145	125	100	440	194	385	245	260	295	470
7/8	130	115	92	410	180	355	225		370	710
1"	120	100	85	370	165	325	210	225	445	735

***GUIDELINE PARAMETERS ONLY.**

Actual parameters may vary depending on operating conditions

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	ImpactaTaps are recommended for through hole applications only.		Ensure regular application of quality cooling lubricant, especially when drilling thick or hardened materials.
	Pilot drill the exact tapping size hole for best results		Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant
	Select correct NM torque power for impact wrench applications		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.
	Apply firm, steady feed pressure throughout the cut		Tap the hole in one pass where possible, applying adequate lubrication before you start.
	Ensure the Tap is inserted squarely to the hole - misaligned taps will greatly increase the risk of breakage.		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.
	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		