ImpactaTaps - Data Sheet

VERSADRIVE® PATENT PROTECTED

Impact Torque

Revolutions per minute (Rotary)

	Thread Diameter	Impact Tapping Torque			Impact Tapping Torque			Structural Steel	Structural Steel	Stainless Steel	Aluminium	Cast Iron (Grey)
		6mm Steel	12mm Steel	25mm Steel	1/4" Steel	1/2" Steel	1" Steel	<500 Mpa	<1000 Mpa	INOX		
		Nm Torque			Ft Lbs Torque			RPM Range				
Metric	M3	105	160	N/A	80	120	N/A	960	809	650	2700	1295
	M4	120	180	N/A	90	135	N/A	730	610	490	2060	975
	M5	135	200	N/A	100	150	N/A	585	485	385	1750	780
	M6	140	240	400	105	180	N/A	485	405	325	1455	650
	M8	150	280	430	115	210	330	365	310	245	1095	485
	M10	170	300	480	125	220	360	295	245	195	870	390
	M12	185	320	512	135	235	400	240	200	162	730	330
	M14	190	340	544	140	250	400	210	175	140	625	275
	M16	200	360	576	150	265	425	185	155	125	550	243
	M20	315	400	640	235	300	470	145	125	100	440	194
	M24	N/A	600	960	N/A	440	720	120	100	85	370	165
	M27	N/A	740	1184	N/A	545	875	105	90	75	330	145
	M30	N/A	800	1200	N/A	590	885	95	80	60	310	130
Inch	1/4"	145	255	410	105	180	295	485	405	325	1455	650
	5/16"	145	265	420	110	205	320	365	310	245	1095	485
	3/8"	165	290	440	125	220	355	295	245	195	870	390
	1/2"	190	330	525	135	235	375	240	200	162	730	330
	5/8"	195	355	555	145	365	425	185	155	125	550	243
	3/4"	245	385	615	230	295	470	145	125	100	440	194
	7/8"	N/A	515	775	N/A	370	710	130	115	92	410	180
	1"	N/A	695	1050	N/A	445	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. *ImpactaTaps 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. *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*
11. *When using cordless tools, 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

- *For fastest performance use on Impact Wrenches & Impact Drivers*
- *Check the minimum torque requirement*
- *Laser cut holes & Stainless Steel require higher torque*
- *Use appropriate lubrication and correct RPM to achieve long tool life*

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