Impact Torque Nm

Thread Diameter	Impact Tapping Torque 6mm Steel	12mm Steel	25mm Steel
Diameter Ø	Nm Torque		
M3	105	160	N/A
M4	120	180	N/A
M5	135	200	N/A
M6	140	240	400
1/4"	145	255	410
5/16"	145	265	420
M8	150	280	430
3/8"	165	290	440
M10	170	300	480
M12	185	320	512
1/2"	190	330	525
M14	190	340	544
5/8"	195	355	555
M16	200	360	576
3/4"	245	385	615
M20	315	400	640
7/8"	N/A	515	775
M24	N/A	600	960
1"	N/A	695	1050
M27	N/A	740	1184
M30	N/A	800	1200

Impact Tapping Torque 1/4" Steel	1/2" Steel	1" Steel
Ft Lbs Torque		
80	120	N/A
90	135	N/A
100	150	N/A
105	180	N/A
105	180	295
110	205	320
115	210	330
125	220	355
125	220	360
135	235	400
135	235	375
140	250	400
145	365	425
150	265	425
230	295	470
235	300	470
N/A	370	710
N/A	440	720
N/A	445	735
N/A	545	875
N/A	590	885

Revolutions per minute (Rotary)

Thread Diameter	Structural Steel <500Nm	Structural Steel <1000Nm	Stainless Steel INOX	Aluminium	Cast Iron (Grey)
Diameter Ø	RPM Range				
M3	960	809	650	2700	1295
M4	730	610	490	2060	975
M5	585	485	385	1750	780
M6	485	405	325	1455	650
1/4"	485	405	325	1455	650
5/16"	365	310	245	1095	485
M8	365	310	245	1095	485
3/8"	295	245	195	870	390
M10	295	245	195	870	390
M12	240	200	162	730	330
1/2"	240	200	162	730	330
M14	210	175	140	625	275
5/8"	185	155	125	550	243
M16	185	155	125	550	243
3/4"	145	125	100	440	194
M20	145	125	100	440	194
7/8"	130	115	92	410	180
M24	120	100	85	370	165
1"	120	100	85	370	165
M27	105	90	75	330	145
M30	95	80	60	310	130

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.	7	Regularly apply 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, 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*