Tapping Torque & Horsepower Requirements
Torque Setting Data For HSS Straight Flute Plug Taps

Tap Size And Pitch	*Minimum Tapping Torque*	*Maximum Tapping Torque*	*Tap Breaking Torque (low Strength)*	*Tap Breaking Torque (High Strength)*	*Required Horsepower (Minimum)*	*Tap Holder Setting (Normal)*	*Tap Holder Setting (Minimum)*	*Tap Holder Setting (Maximum)*
#0-#2								
NC & NF	10	18	25	50	1/4	20	15	25
#3 & #4								
NC & NF	10	20	30	50	1/4	20	15	30
#5 & #6								
NC & NF	10	20	30	50	1/4	20	15	30
8-30	20	30	40	60	1/4	25	20	40
8-32	20	30	40	60	1/4	25	20	40
10-32	20	30	40	60	1/3	25	20	40
10-24	25	50	40	60	1/3	30	25	50
12-28	25	50	40	70	1/3	30	25	50
12-24	25	50	40	70	1/3	30	25	50
1/4-28	30	60	50	100	1/2	40	30	60
1/4-20	40	80	50	100	1/2	50	40	80
5/16-24	40	80	75	150	1/2	60	50	100
5/16-18	60	120	75	150	1/2	90	80	150
3/8-24	60	120	180	260	3/4	90	80	150
3/8-16	100	200	180	260	3/4	130	110	220
7/16-20	80	160	180	300	3/4	130	110	220
7/16-14	100	200	180	300	1”	200	180	300
1/2-20	100	250	300	600	3/4	300	300	450
1/2-13	150	300	300	600	1”	300	300	450
9/16-18	150	350	500	800	3/4	350	350	500
9/16-12	200	500	500	800	1” 1/4	350	350	500
5/8-18	200	600	800	1200	3/4	450	450	650
5/8-11	300	800	800	1200	1” 1/2	450	450	650
3/4-16	300	800	1000	1500	1”	650	650	950
3/4-10	500	1000	1000	1500	1” 3/4	650	650	950
7/8-14	500	1000	1500	2000	1”	850	850	1500
7/8-9	800	1500	1500	2000	2	850	850	1500
1”-12 & 14	700	1800	2000	2500	1” 1/2	1100	1100	1800
1”-8	1000	1800	2000	2500	2” 1/2	1100	1100	1800