Standard Taps

TAPMATIC

	Low Carbon Steel, Medium Carbon Steel	High Carbon Steel, High Strength Steel, Tool Steel	High Strength Steel, Tool Steel Hardened	Stainless 303, 304, 316	Stainless 410, 430, 17-4 Hardened	Stainless 17-4 Annealed	Titanium Alloys	Nickel Base Alloys	Aluminium Alloys	Aluminium Die Cast	Magnesium	Brass, Bronze	Copper	Cast Iron
A) m/min **B) m/min**	10–20 20–40	8–12 15–25	4–6 12–18	6–12 8–15	3–5 4–10	6–12 8–20	4–8 8–15	3–5 5–10	15–25 40–60	10–15 30–40	15–25 40–60	15–25 40–60	8–12 15–25	10–20 20–30
Tap size	**A)** rpm for HSS-E uncoated taps **B)** rpm for HSS-E coated taps													
M2 **(#2)**	1600–3200 3200–6350	1250–1900 2400–4000	640–800 1900–2850	800–1900 1250–2400	480–800 640–1600	800–1900 1250–3200	640–1250 1250–2400	480–800 800–1600	2400–4000 6350–9550	1600–2400 4750–6350	2400–4000 6350–9550	2400–4000 6350–9550	1250–1900 2400–4000	1600–3200 3200–4750
M3 **(#5)**	1050–2100 2100–4250	850–1250 1600–2650	420–530 1250–1900	530–1250 850–1600	320–530 420–1050	530–1250 850–2100	420–850 850–1600	320–530 530–1050	1600–2650 4250–6350	1050–1600 3200–4250	1600–2650 4250–6350	1600–2650 4250–6350	850–1250 1600–2650	1050–2100 2100–3200
M4 **(#8)**	800–1600 1600–3200	640–950 1200–2000	320–400 950–1450	400–950 640–1200	240–400 320–800	400–950 640–1600	320–640 640–1200	240–400 400–800	1200–2000 3200–4750	800–1200 2400–3200	1200–2000 3200–4750	1200–2000 3200–4750	640–950 1200–2000	800–1600 1600–2400
M5 **(#10)**	640–1250 1250–2550	510–760 950–1600	250–320 760–1150	320–760 510–950	190–320 250–640	320–760 510–1250	250–510 510–950	190–320 320–640	950–1600 2550–3800	640–950 1900–2550	950–1600 2550–3800	950–1600 2550–3800	510–760 950–1600	640–1250 1250–1900
M6 **(1/4)**	530–1050 1050–2100	420–640 800–1350	210–270 640–950	270–640 420–800	160–270 210–530	270–640 420–1050	210–420 420–800	160–270 270–530	800–1350 2100–3200	530–800 1600–2100	800–1350 2100–3200	800–1350 2100–3200	420–640 800–1350	530–1050 1050–1600
M7	450–910 910–1800	360–550 680–1150	180–230 550–820	230–550 360–680	140–230 180–450	230–550 360–910	180–360 360–680	140–230 230–450	680–1150 1800–2750	450–1150 1350–1800	680–1150 1800–2750	680–680 1800–2750	360–550 680–1150	450–910 910–1350
M8 **(5/16)**	400–800 800–1600	320–480 600–990	160–200 480–720	200–480 320–600	120–200 160–400	200–480 320–800	160–320 320–600	120–200 200–400	600–990 1600–2400	400–600 1200–1600	600–990 1600–2400	600–990 1600–2400	320–480 600–990	400–800 800–1200
M9	350–710 710–1400	280–420 530–880	140–180 420–640	180–420 280–530	110–180 140–350	180–420 280–710	140–280 280–530	110–180 180–350	530–880 1400–2100	350–530 1050–1400	530–880 1400–2100	530–880 1400–2100	280–420 530–880	350–710 710–1050
M10 **(3/8)**	320–640 640–1250	250–380 480–800	130–160 380–570	160–380 250–480	100–160 130–320	160–380 250–640	130–250 250–480	100–160 160–320	480–800 1250–1900	320–480 950–1250	480–800 1250–1900	480–800 1250–1900	250–380 480–800	320–640 640–950
M12 **(1/2)**	270–530 530–1050	210–320 400–660	110–130 320–480	130–320 210–400	80–130 110–270	130–320 210–530	110–210 210–400	80–130 130–270	400–660 1050–1600	270–400 800–1050	400–660 1050–1600	400–660 1050–1600	210–320 400–660	270–530 530–800
M14 **(9/16)**	230–450 450–910	180–270 340–570	90–110 270–410	110–270 180–340	70–110 90–230	110–270 180–450	90–180 180–340	70–110 110–230	340–570 910–1350	230–340 680–910	340–570 910–1350	340–570 910–1350	180–270 340–570	230–450 450–680
M16 **(5/8)**	200–400 400–800	160–240 300–500	80–100 240–360	100–240 160–300	60–100 80–200	100–240 160–400	80–160 160–300	60–100 100–200	300–500 800–1200	200–300 600–800	300–500 800–1200	300–500 800–1200	160–240 300–500	200–400 400–600
M18 **(11/16)**	180–350 350–710	140–210 270–440	70–90 210–320	90–210 140–270	50–90 70–180	90–210 140–350	70–140 140–270	50–90 90–180	270–440 710–1050	180–270 530–710	270–440 710–1050	270–440 710–1050	140–210 270–440	180–350 350–530
M20 **(3/4)**	160–320 320–640	130–190 240–400	60–80 190–290	80–190 130–240	50–80 60–160	80–190 130–320	60–130 130–240	50–80 80–160	240–400 640–950	160–240 480–640	240–400 640–950	240–400 640–950	130–190 240–400	160–320 320–480
M22 **(7/8)**	140–290 290–580	120–170 220–360	60–70 170–260	70–170 120–220	40–70 60–140	70–170 120–290	60–120 120–220	40–70 70–140	220–360 580–870	140–220 430–580	220–360 580–870	220–360 580–870	120–170 220–360	140–290 290–430
M24 **(15/16)**	130–270 270–530	110–160 200–330	50–70 160–240	70–160 110–200	40–70 50–130	70–160 110–270	50–110 110–200	40–70 70–130	200–330 530–800	130–200 400–530	200–330 530–800	200–330 530–800	110–160 200–330	130–270 270–400
M25 **(1)**	130–250 250–510	100–150 190–320	50–60 150–230	60–150 100–190	40–60 50–130	60–150 100–250	50–100 100–190	40–60 60–130	190–320 510–760	130–190 380–510	190–320 510–760	190–320 510–760	100–150 190–320	130–250 250–380
M26	120–240 240–490	100–150 180–310	50–60 150–220	60–150 100–180	40–60 50–120	60–150 100–240	50–100 100–180	40–60 60–120	180–310 490–730	120–180 370–490	180–310 490–730	180–310 490–730	100–150 180–310	120–240 240–370
M27 **(1 1/16)**	120–240 240–470	90–140 180–290	50–60 140–210	60–140 90–180	40–60 50–120	60–140 90–240	50–90 90–180	40–60 60–120	180–290 470–710	120–180 350–470	180–290 470–710	180–290 470–710	90–140 180–290	120–240 240–350
M28 **(1 1/8)**	110–230 230–450	90–140 170–280	50–60 140–200	60–140 90–170	30–60 50–110	60–140 90–230	50–90 90–170	30–60 60–110	170–280 450–680	110–170 340–450	170–280 450–680	170–280 450–680	90–140 170–280	110–230 230–340
M30 **(1 3/16)**	110–210 210–420	80–130 160–270	40–50 130–190	50–130 80–160	30–50 40–110	50–130 80–210	40–80 80–160	30–50 50–110	160–270 420–640	110–160 320–420	160–270 420–640	160–270 420–640	80–130 160–270	110–210 210–320
M32 **(1 1/4)**	100–200 200–400	80–120 150–250	40–50 120–180	50–120 80–150	30–50 40–100	50–120 80–200	40–80 80–150	30–50 50–100	150–250 400–600	100–150 300–400	150–250 400–600	150–250 400–600	80–120 150–250	100–200 200–300
M33 **(1 5/16)**	100–190 190–390	80–120 140–240	40–50 120–170	50–120 80–140	30–50 40–100	50–120 80–190	40–80 80–140	30–50 50–100	140–240 390–580	100–140 290–390	140–240 390–580	140–240 390–580	80–120 140–240	100–190 190–290
M36 **(1 7/16)**	90–180 180–350	70–110 130–220	40–40 110–160	40–110 70–130	30–40 40–90	40–110 70–180	40–70 70–130	30–40 40–90	130–220 350–530	90–130 270–350	130–220 350–530	130 -220 350–530	70–110 130–220	90–180 180–270
M39 **(1 5/8)**	80–160 160–330	70–100 120–200	30–40 100–150	40–100 70–120	20–40 30–80	40–100 70–160	30–70 70–120	20–40 40–80	120–200 330–490	80–120 240–330	120–200 330–490	120–200 330–490	70–100 120–200	80–160 160–240
M40	80–160 160–320	60–100 120–200	30–40 100–140	40–100 60–120	20–40 30–80	40–100 60–160	30–60 60–120	20–40 40–80	120–200 320–480	80–120 240–320	120–200 320–480	120–200 320–480	60–100 120–200	80–160 160–240
M42 **(1 3/4)**	80–150 150–300	60–90 110–190	30–40 90–140	40–90 60–110	20–40 30–80	40–90 60–150	30–60 60–110	20–40 40–80	110–190 300–450	80–110 230–300	110–190 300–450	110–190 300–450	60–90 110–190	80–150 150–230

Tapping speed v_c = m/min
RPM n = U/min
Diameter d = mm

Calculation:

$$n = \frac{v_c \times 1000}{d \times \pi}$$

Example: M8 with 25 m/min

$$n = \frac{25 \times 1000}{8 \times 3.14} = 995 \text{ U/min (RPM)}$$

- The speed given are guide values acc. to general information and can vary depending on tap manufacturer.
- For optimal production and correct speed, we suggest following the specifications of the tap manufacturer.
- Furthermore, the maximum speed of the tapping attachment must not be exceeded.

RDT15	RDT25	RDT50 RCT50 RCTXT50 sintered gears	RDT50 RCT50 RCTXT50 cut gears	RCT85	RCT85	RCT100	RCT150

High Speed/Top Speed Taps

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TAPMATIC

	Low Carbon Steel, Medium Carbon Steel	High Carbon Steel, High Strength Steel, Tool Steel	High Strength Steel, Tool Steel Hardened	Stainless 303, 304, 316	Stainless 410, 430, 17-4 Hardened	Stainless 17-4 Annealed	Titanium Alloys	Nickel Base Alloys	Aluminium Alloys	Aluminium Die Cast	Magnesium	Brass, Bronze	Copper	Cast Iron
A) m/min **B) m/min**	50–70 —	20–30 40–60	15–20 30–50	10–15 —	6–10 —	10–15 —	12–15 —	6–12 —	50–70 60–80	40–50 50–70	50–70 40–80	30–70 60–80	20–30 30–50	25–40 30–50
Tap size	**A)** rpm for HSS-E uncoated taps **B)** rpm for HSS-E coated taps													
M2 **(#2)**	7950–11150 640–800	3200–4750 6350–9550	2400–3200 4750–7950	1600–2400 640–800	800–1600 640–800	1600–2400 640–800	1900–2400 –	800–1900 –	7950–11150 9550–12750	6350–7950 7950–11150	7950–11150 6350–12750	4750–11150 9550–12750	3200–4750 4750–7950	4000–6350 4750–7950
M3 **(#5)**	5300–7450 420–530	2100–3200 4250–6350	1600–2100 3200–5300	1050–1600 420–530	530–1050 420–530	1050–1600 420–530	1250–1600 –	530–1250 –	5300–7450 6350–8500	4250–5300 5300–7450	5300–7450 4250–8500	3200–7450 6350–8500	2100–3200 3200–5300	2650–4250 3200–5300
M4 **(#8)**	4000–5550 320–600	1600–2400 3200–4750	1200–1600 2400–4000	800–1200 320–400	400–800 320–400	800–1200 320–400	950–1200 –	400–950 –	4000–5550 4750–6350	3200–4000 4000–5550	4000–5550 3200–6350	2400–5550 4750–6350	1600–2400 2400–4000	2000–3200 2400–4000
M5 **(#10)**	3200–4450 250–320	1250–1900 2550–3800	950–1250 1900–3200	640–950 250–320	320–640 250–320	640–950 250–320	760–950 –	320–760 –	3200–4450 3800–5100	2550–3200 3200–4450	3200–4450 2550–5100	1900–4450 3800–5100	1250–1900 1900–3200	1600–2550 1900–3200
M6 **(1/4)**	2650–3700 210–270	1050–1600 2100–3200	800–1050 1600–2650	530–800 210–270	270–530 210–270	530–800 210–270	640–800 –	270–640 –	2650–3700 3200–4250	2100–2650 2650–3700	2650–3700 2100–4250	1600–3700 3200–4250	1050–1600 1600–2650	1350–2100 1600–2650
M7	2250–3200 180–230	910–1350 1800–2750	680–910 1350–2250	450–680 180–230	230–450 180–230	450–680 180–230	550–680 –	230–550 –	2250–3200 2750–3650	1800–2250 2250–3200	2250–3200 1800–3650	1350–3200 2750–3650	910–1350 1350–2250	1150–1800 1350–2250
M8 **(5/16)**	2000–2800 160–200	800–1200 1600–2400	600–800 1200–2000	400–600 160–200	200–400 160–200	400–600 160–200	480–600 –	200–480 –	2000–2800 2400–3200	1600–2000 2000–2800	2000–2800 1600–3200	1200–2800 2400–3200	800–1200 1200–2000	990–1600 1200–2000
M9	1750–2500 140–180	710–1050 1400–2100	530–710 1050–1750	350–530 140–180	180–350 140–180	350–530 140–180	420–530 –	180–420 –	1750–2500 2100–2850	1400–1750 1750–2500	1750–2500 1400–2850	1050–2500 2100–2850	710–1050 1050–1750	880–1400 1050–1750
M10 **(3/8)**	1600–2250 130–160	640–950 1250–1900	480–640 950–1600	320–480 130–160	160–320 130–160	320–480 130–160	380–480 –	160–380 –	1600–2250 1900–2550	1250–1600 1600–2250	1600–2250 1250–2550	950–2250 1900–2550	640–950 950–1600	800–1250 950–1600
M12 **(1/2)**	1350–1850 110–130	530–800 1050–1600	400–530 800–1350	270–400 110–130	130–270 110–130	270–400 110–130	320–400 –	130–320 –	1350–1850 1600–2100	1050–1350 1350–1850	1350–1850 1050–2100	800–1850 1600–2100	530–800 800–1350	660–1050 800–1350
M14 **(9/16)**	1150–1600 90–110	450–680 910–1350	340–450 680–1150	230–340 90–110	110–230 90–110	230–340 90–110	270–340 –	110–270 –	1150–1600 1350–1800	910–1150 1150–1600	1150–1600 910–1800	680–1600 1350–1800	450–680 680–1150	570–910 680–1150
M16 **(5/8)**	990–1400 80–100	400–600 800–1200	300–400 600–990	200–300 80–100	100–200 80–100	200–300 80–100	240–300 –	100–240 –	990–1400 1200–1600	800–990 990–1400	990–1400 800–1600	600–1400 1200–1600	400–600 600–990	500–800 600–990
M18 **(11/16)**	880–1250 70–90	350–530 710–1050	270–350 530–880	180–270 70–90	90–180 70–90	180–270 70–90	210–270 –	90–210 –	880–1250 1050–1400	710–880 880–1250	880–1250 710–1400	530–1250 1050–1400	350–530 530–880	440–710 530–880
M20 **(3/4)**	800–1100 60–80	320–480 640–950	240–320 480–800	160–240 60–80	80–160 60–80	160–240 60–80	190–240 –	80–190 –	800–1100 950–1250	640–800 800–1100	800–1100 640–1250	480–1100 950–1250	320–480 480–800	400–640 480–800
M22 **(7/8)**	720–1000 60–70	290–430 580–870	220–290 430–720	140–220 60–70	70–140 60–70	140–220 60–70	170–220 –	70–170 –	720–1000 870–1150	580–720 720–1000	720–1000 580–1150	430–1000 870–1150	290–430 430–720	360–580 430–720
M24 **(15/16)**	660–930 50–70	270–400 530–800	200–270 400–660	130–200 50–70	70–130 50–70	130–200 50–70	160–200 –	70–160 –	660–930 800–1050	530–660 660–930	660–930 530–1050	400–930 800–1050	270–400 400–660	330–530 400–660
M25 **(1)**	640–890 50–60	250–380 510–760	190–250 380–640	130–190 50–60	60–130 50–60	130–190 50–60	150–190 –	60–150 –	640–890 760–1000	510–640 640–890	640–890 510–1000	380–890 760–1000	250–380 380–640	320–510 380–640
M26	610–860 50–60	240–370 490–730	180–240 370–610	120–180 50–60	60–120 50–60	120–180 50–60	150–180 –	60–150 –	610–860 730–980	490–610 610–860	610–860 490–980	370–860 730–980	240–370 370–610	310–490 370–610
M27 **(1 1/16)**	590–830 50–60	240–350 470–710	180–240 350–590	120–180 50–60	60–120 50–60	120–180 50–60	140–180 –	60–140 –	590–830 710–940	470–590 590–830	590–830 470–940	350–830 710–940	240–350 350–590	290–470 350–590
M28 **(1 1/8)**	570–800 50–60	230–340 450–680	170–230 340 –570	110–170 50–60	60–110 50–60	110–170 50–60	140–170 –	60–140 –	570–800 680–910	450–570 570–800	570–800 450–910	340–800 680–910	230–340 340–570	280–450 340–570
M30 **(1 3/16)**	530–740 40–50	210–320 420–640	160–210 320–530	110–160 40–50	50–110 40–50	110–160 40–50	130–160 –	50–130 –	530–740 640–850	420–530 530–740	530–740 420–850	320–740 640–850	210–320 320–530	270–420 320–530
M32 **(1 1/4)**	500–700 40–50	200–300 400–600	150–200 300–500	100–150 40–50	50–100 40–50	100–150 40–50	120–150 –	50–120 –	500–700 600–800	400–500 500–700	500–700 400–800	300–700 600–800	200–300 300–500	250–400 300–500
M33 **(1 5/16)**	480–680 40–50	190–290 390–580	140–190 290–480	100–140 40–50	50–100 40–50	100–140 40–50	120–140 –	50–120 –	480–680 580–770	390–480 480–680	480–680 390–770	290–680 580–770	190–290 290–480	240–390 290–480
M36 **(1 7/16)**	440–620 40–40	180–270 350–530	130–180 270–440	90–130 40–40	40–90 40–40	90–130 40–40	110–130 –	40–110 –	440–620 530–710	350–440 440–620	440–620 350–710	270–620 530–710	180–270 270–440	220–350 270–440
M39 **(1 5/8)**	410–570 30–40	160–240 330–490	120–160 240–410	80–120 30–40	40–80 30–40	80–120 30–40	100–120 –	40–100 –	410–570 490–650	330–410 410–570	410–570 330–650	240–570 490–650	160–240 240–410	200–330 240–410
M40	400–560 30–40	160–240 320–480	120–160 240–400	80–120 30–40	40–80 30–40	80–120 30–40	100–120 –	40–100 –	400–560 480–640	320–400 400–560	400–560 320–640	240–560 480–640	160–240 240–400	200–320 240–400
M42 **(1 3/4)**	380–530 30–40	150–230 300–450	110–150 230–380	80–110 30–40	40–80 30–40	80–110 30–40	90–110 –	40–90 –	380–530 450–610	300–380 380–530	380–530 300–610	230–530 450–610	150–230 230–380	190–300 230–380

Calculation:

Tapping speed v_c = m/min
RPM n = U/min
Diameter d = mm

$$n = \frac{v_c \times 1000}{d \times \pi}$$

Example: M8 with 40 m/min

$$n = \frac{40 \times 1000}{8 \times 3.14} = 1592 \text{ U/min (RPM)}$$

- The speed given are guide values acc. to general information and can vary depending on tap manufacturer.
- For optimal production and correct speed, we suggest following the specifications of the tap manufacturer.
- Furthermore, the maximum speed of the tapping attachment must not be exceeded.

RDT15	RDT25	RDT50 RCT50 RCTXT50 sintered gears	RDT50 RCT50 RCTXT50 cut gears	RCT85	RCT85	RCT100	RCT150

Roll From Taps

TAPMATIC

	Low Carbon Steel, Medium Carbon Steel	High Carbon Steel, High Strength Steel, Tool Steel	High Strength Steel, Tool Steel Hardened	Stainless 303, 304, 316	Stainless 17-4 Annealed	Titanium Alloys	Nickel Base Alloys	Aluminium Alloys	Aluminium Die Cast	Copper
A) m/min **B) m/min**	30–40 40–60	20–30 30–50	15–25 25–40	10–15 12–20	10–15 —	5–15 —	3–5 8–12	30–60 50–70	20–40 30–50	15–25 25–50
Tap size	**A)** rpm for HSS-E uncoated taps **B)** rpm for HSS-E coated taps									
M2 **(#2)**	4750–6350 6350–9550	3200–4750 4750–7950	2400–4000 4000–6350	1600–2400 1900–3200	1600–2400 –	800–2400 320–1600	480–800 1250–1900	4750–9550 7950–11150	3200–6350 4750–7950	2400–4000 4000–7950
M3 **(#5)**	3200–4250 4250–6350	2100–3200 3200–5300	1600–2650 2650–4250	1050–1600 1250–2100	1050–1600 –	530–1600 210–1050	320–530 850–1250	3200–6350 5300–7450	2100–4250 3200–5300	1600–2650 2650–5300
M4 **(#8)**	2400–3200 3200–4750	1600–2400 2400–4000	1200–2000 2000–3200	800–1200 950–1600	800–1200 –	400–1200 160–800	240–400 640–950	2400–4750 4000–5550	1600–3200 2400–4000	1200–2000 2000–4000
M5 **(#10)**	1900–2550 2550–3800	1250–1900 1900–3200	950–1600 1600–2550	640–950 760–1250	640–950 –	320–950 130–640	190–320 510–760	1900–3800 3200–4450	1250–2550 1900–3200	950–1600 1600–3200
M6 **(1/4)**	1600–2100 2100–3200	1050–1600 1600–2650	800–1350 1350–2100	530–800 640–1050	530–800 –	270–800 110–530	160–270 420–640	1600–3200 2650–3700	1050–2100 1600–2650	800–1350 1350–2650
M7	1350–1800 1800–2750	910–1350 1350–2250	680–1150 1150–1800	450–680 550–910	450–680 –	230–680 90–450	140–230 360–550	1350–2750 2250–3200	910–1800 1350–2250	650–1150 1150–2250
M8 **(5/16)**	1200–1600 1600–2400	800–1200 1200–2000	600–990 990–1600	400–600 480–800	400–600 –	200–600 80–400	120–200 320–480	1200–2400 2000–2800	800–1600 1200–2000	600–990 990–2000
M9	1050–1400 1400–2100	710–1050 1050–1750	530–880 880–1400	350–530 420–710	350–530 –	180–530 70–350	110–180 280–420	1050–2100 1750–2500	710–1400 1050–1750	530–880 880–1750
M10 **(3/8)**	950–1250 1250–1900	640–950 950–1600	480–800 800–1250	320–480 380–640	320–480 –	160–480 60–320	100–160 250–380	950–1900 1600–2250	640–1250 950–1600	480–800 800–1600
M12 **(1/2)**	800–1050 1050–1600	530–800 800–1350	400–660 660–1050	270–400 320–530	270–400 –	130–400 50–270	80–130 210–320	800–1600 1350–1850	530–1050 800–1350	400–660 660–1350
M14 **(9/16)**	680–910 910–1350	450–680 680–1150	340–570 570–910	230–340 270–450	230–340 –	110–340 50–230	70–110 180–270	680–1350 1150–1600	450–910 680–1150	340–570 570–1150
M16 **(5/8)**	600–800 800–1200	400–600 600–990	300–500 500–800	200–300 240–400	200–300 –	100–300 40–200	60–100 160–240	600–1200 990–1400	400–800 600–990	300–500 500–990
M18 **(11/16)**	530–710 710–1050	350–530 530–880	270–440 440–710	180–270 210–350	180–270 –	90–270 40–180	50–90 140–210	530–1050 880–1250	350–710 530–880	270–440 440–880
M20 **(3/4)**	480–640 640–950	320–480 480–800	240–400 400–640	160–240 190–320	160–240 –	80–240 30–160	50–80 130–190	480–950 800–1100	320–640 480–800	240–400 400–800
M22 **(7/8)**	430–580 580–870	290–430 430–720	220–360 360–580	140–220 170–290	140–220 –	70–220 30–140	40–70 120–170	430–870 720–1000	290–580 430–720	220–360 360–720
M24 **(15/16)**	400–530 530–800	270–400 400–660	200–330 330–530	130–200 160–270	130–200 –	70–200 30–130	40–70 110–160	400–800 660–930	270–530 400–660	200–330 330–660
M25 **(1)**	380–510 510–760	250–380 380–640	190–320 320–510	130–190 150–250	130–190 –	60–190 30–130	40–60 100–150	380–760 640–890	250–510 380–640	190–320 320–640
M26	370–490 490–730	240–370 370–610	180–310 310–490	120–180 150–240	120–180 –	60–180 20–120	40–60 100–150	370–730 610–860	240–490 370–610	180–310 310–610
M27 **(1 1/16)**	350–470 470–710	240–350 350–590	180–290 290–470	120–180 140–240	120–180 –	60–180 20–120	40–60 90–140	350–710 590–830	240–470 350–590	180–290 290–590
M28 **(1 1/8)**	340–450 450–680	230–340 340–570	170–280 280–450	110–170 140–230	110–170 –	60–170 20–110	30–60 90–140	340–680 570–800	230–450 340–570	170–280 280–570
M30 **(1 3/16)**	320–420 420–640	210–320 320–530	160–270 270–420	110–160 130–210	110–160 –	50–160 20–110	30–50 80–130	320–640 530–740	210–420 320–530	160–270 270–530
M32 **(1 1/4)**	300–400 400–600	200–300 300–500	150–250 250–400	100–150 120–200	100–150 –	50–150 20–100	30–50 80–120	300–600 500–700	200–400 300–500	150–250 250–500
M33 **(1 5/16)**	290–390 390–580	190–290 290–480	140–240 240–390	100–140 120–190	100–140 –	50–140 20–100	30–50 80–120	290–580 480–680	190–390 290–480	140–240 240–480

Tapping speed v_c = m/min
RPM n = U/min
Diameter d = mm

Calculation:

$$n = \frac{v_c \times 1000}{d \times \pi}$$

Example: M8 with 30 m/min

$$n = \frac{30 \times 1000}{8 \times 3.14} = 1194 \text{ U/min (RPM)}$$

- The speed given are guide values acc. to general information and can vary depending on tap manufacturer.
- For optimal production and correct speed, we suggest following the specifications of the tap manufacturer.
- Furthermore, the maximum speed of the tapping attachment must not be exceeded.

RDT15	RDT25	RDT50 RCT50 RCTXT50 sintered gears	RDT50 RCT50 RCTXT50 cut gears	RCT85	RCT85	RCT100	RCT150